

ALPHA

SOLUTIONS FOR INDUSTRY

S 248 Sprayable polychloroprene contact adhesive

Description

S 248 is a sprayable high heat resistant contact adhesive, giving a fast flash off & a long open joint time. S 248 shows excellent adhesion to a wide variety of substrates such as wood, polyurethane foam, decorative laminates, plastics, metals & elastomers. S 248 with its excellent hot bond strength makes it ideal for postforming decorative laminates onto chipboard & MDF base boards. S 248 can be used with static & continuous postforming equipment.

Application

S 248 can be used through most spray equipment, but for best results a Devilbiss JGA with a FX fluid tip & needle & a 777 air cap is recommended. Atomising pressures of between 40 – 50 psi & fluid pressure of 20 - 30 psi is required

Technical Data

Total Solids	15 ± 1 %
Viscosity	less than 100 cps
Specific Gravity	0.800
Open Joint Time	2 – 40 minutes depending on substrates being adhered
Coverage	7 – 10 sq metres/litre
Colour	Red or Neutral
Cleaner	T 559
Flash Point	- 18 °C
Heat resistance	up to 120 °C

Method of use

1. The materials to be bonded should be dry, clean and free from dust, loose material, oil or grease.
2. Spray apply an even coating of S.248 to both surfaces.
3. Allow the S.248 solvents to evaporate until the adhesive film is "tacky". Under normal ambient conditions this will take between 1 and 1½ minutes. Bond should be made within 40 minutes of spraying.
4. Locate the coated surfaces accurately before bringing them into contact, as an immediate bond will be formed. Apply firm even pressure to consolidate the bond. For best results on laminates use either nip rollers for rapid through put or existing press systems (using a pressure of approximately 270 to 420 KN per square metre, i.e. 40-60 lbs, per square inch). The immediate high contact bond strength increases appreciably within the next 48 hours and will develop still further in service. For the best heat resistance, leave at room temperature for 7 days, before subjecting to high temperatures

Health & Safety

See separate health and safety data sheet.

Storage and Shelf Life

Stored in well sealed containers, S 248 will keep satisfactorily for up to 12 months, from date of manufacture. S 248 must be protected from frost and stored between 5 – 25°C.

Important Notice

Whilst all reasonable care is taken in the compilation of this data sheet, it is the customer's responsibility to determine the suitability of the product for the desired application.

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