

# **ALPHA**

**SOLUTIONS FOR INDUSTRY**

## **S.708 & S.758**

### **MULTI-PURPOSE ADHESIVES**

#### **DESCRIPTION**

Both products are heavy, golden brown solutions of brushing viscosity. S.708 has a lower viscosity than S.758 and it has a slightly longer open joint time. SN.1314 is a non-flammable version of S.758.

#### **APPLICATIONS**

Alpha S.708 and S.758 have been developed as multi-purpose adhesives. Both form strong, permanent contact bonds between the following materials - rigid PVC sheet, polyurethane foams of the polyester and polyether types, supported PVC leather cloth\*, leather, polyester glass fibre, rubber sheet and extrusions all of which may be bonded to each other or to hardboard, chipboard, wood, painted or unpainted metal. Rigid laminated plastics such as Formica, Ware rite, Melamine, etc may also be fixed with these adhesives. They are both well established in the automotive and coach building industries as multi-purpose body trim adhesives. Typical body trim and coach building operations to which S.708 and S.758 are suited include door and fascia trim, roof headlining, parcel racks and glove compartments.

S.708 and S.758 have also proved their versatility in the shop-fitting and bar-fitting trades and in the boat building, furniture and footwear industries, where they are widely used as multi-purpose adhesives. Both materials have excellent ageing resistance.

\* Care should be taken to establish that the backing of the supported PVC leather cloth is of sufficient quality to prevent plasticizer migration.

#### **METHOD OF USE**

1. The materials to be bonded should be dry, clean and free of dust, grit, loose materials, oil or grease.
2. Stir before use. Using a brush or spreader, apply a thin even coating of adhesive to both of the surfaces.
3. Allow the solvent content to evaporate before bonding the materials. The time for this evaporation will depend on the temperature and humidity. On absorbent or permeable materials such as leather/chipboard, bonding may be possible within a matter of 2-3 minutes of application; on non-absorbent or non-permeable materials (e.g. Formica/metal) a minimum of 15 minutes should elapse before the surfaces are bonded.
4. Bond the materials under firm pressure.
5. Dried coatings of S.708 may be reactivated by wiping over the surfaces with solvent T161. S.758 may be reactivated by using solvent T559. Alternatively, both may be treated with infra red heat, exposing one surface at 95°C + 5°C.

## **HEALTH AND SAFETY**

Before use please read the product Health and Safety data sheet.

## **PROPERTIES**

|                             | <b><u>S.708</u></b>  | <b><u>S.758</u></b> |
|-----------------------------|--|---------------------|
| Total Solids                | 25 ± 1.5%  | 26.5 ± 1.5%         |
| Viscosity (at make)         | 4100-4600 cps  | 6000-6500 cps       |
| Typical Specific Gravity    | 0.87   | 0.878               |
| Flash Point                 | -12°C  | -12°C               |
| Coverage                    | 3-4 square metres of bonded material/litre                         |                     |
| Minimum Open Joint Time     | 2-15 minutes - depending upon absorbency of materials to be bonded |                     |
| Maximum Open Joint Time     | 30 minutes   | 20 minutes          |
| Max. continuous use temp./C | 80   | 80                  |
| Cleaner                     | T559   | T559                |

## **STORAGE AND SHELF LIFE**

Stored in well sealed containers, Alpha Adhesives S.708 and S.758 will keep satisfactorily for 18 months from date of manufacture. Low or high temperature storage should be avoided and the adhesives should preferably be stored within the temperature range +10°C - +20°C.

## **SERVICES**

For further information on this product together with advice on application please contact Alpha Technical Services Department.

## **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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