

ALPHA S248 Joinery

Sprayable Polychloroprene Contact Adhesive

No
Mixing

High Heat
Resistance

Long Open
Time

Single
Component



KEY INFORMATION

- **HIGH PERFORMANCE CONTACT ADHESIVE**
- **HIGH HEAT RESISTANCE – 40°C TO 120°C**
- **LONG OPEN JOINT TIME (5 - 40 MINUTES)**
- **BONDS A WIDE RANGE FOR MATERIALS**

TYPICAL APPLICATIONS

Bonding a wide variety of materials including polyurethane foam, plastics, metals & elastomers.

Post-forming decorative laminates to wooden core materials.

Foam building applications.



PRODUCT INFORMATION

Sprayable high heat resistant contact adhesive, giving a fast flash off and a long open joint time.

Excellent adhesion to a wide variety of substrates such as wood, polyurethane foam, decorative laminates, plastics, metals and elastomers.

Excellent hot bond strength makes it ideal for post-forming decorative laminates onto chipboard and MDF base boards and can be used with static and continuous post-forming equipment.



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Technical Data

COLOUR	Clear, Red or Blue	VISCOSITY (20°C)	Less than 100cP
BASE	Polychloroprene rubber	OPEN JOINT TIME	Porous Substrates: 1 to 20 minutes* Non-Porous Substrates 5 to 40 minutes*
CONSISTENCY	Liquid	CURE TIME	7 days
SPECIFIC GRAVITY (20°C)	0.800	HEAT RESISTANCE	- 40 to 120°C
TOTAL SOLIDS CONTENT	14—16%	COVERAGE	7-10m ² / litre

* Dependent upon ambient temperature, relative humidity and the materials used

HANDLING & APPLICATIONS

The general application information presented here is based upon typical conditions determined by Alpha Adhesives & Sealants testing. Our recommendations on the use of this product are based on methods believed to be reliable. It is advised that users conduct their own tests to determine the suitability of the product for their specific application.

Surface Preparation All substrates must be clean of any dust, grit, loose material, wax, grease and oil using Alpha T559. The materials to be bonded should be dry.

Adhesive Application Alpha S248 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.

1. **Spray** apply an even coating of Alpha S248 on to both surfaces that are to be bonded.

2. **Allow the adhesive to dry** until the adhesive film is tacky. Under normal ambient conditions, this will take between 1 and 2 minutes. The bond should be made within the 40 minutes of applying the adhesive (dependent on temperature, humidity and porosity of the materials).

3. **Locate the coated surfaces** accurately before bringing them into contact, as an immediate bond will be formed.

4. **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).

Curing 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.

Cleaning Alpha Cleaner T559 should be used to remove residues from surfaces.



HEALTH & SAFETY INFORMATION

Alpha S248 is classified as hazardous according to Directive EC 1272/2008. Please refer to the Alpha S248 Safety Data Sheet for further health & safety information.

STORAGE

Alpha S248 should be stored in its original container, with the lid tightly secured, in dry conditions and at temperatures between 5°C and 25°C.

Alpha S248 will keep satisfactorily for up to 12 months from date of manufacture if stored according to the recommended conditions.

Alpha Adhesives & Sealants Ltd, Llewellyn Close, Sandy Lane Industrial Estate, Stourport-on-Severn, Worcestershire DY13 9RH

Tel: 01299 828626 Fax: 01299 828666 Email: sales@alpha-adhesives.co.uk Web: www.alpha-adhesives.co.uk

