

**5242/C®****SUPER STRONG, PROFESSIONAL AND +100°C TEMPERATURE-RESISTANT CONTACT ADHESIVE.****PRODUCT DESCRIPTION**

Professional, aromatics-free and +100°C temperature-resistant contact adhesive on a neoprene rubber basis.

**FIELD OF APPLICATION**

Ideally suitable for professional surface bonding and laminating many materials that must bond, be loaded and/or be tooled immediately. Ideal for materials under pressure or curved work, whereby it is impossible to clamp or press. Surfaces to be bonded need to fit completely. Highly suitable for bonding and laminating of metal and hard synthetic panel boards (HPL; Formica®, Duropal, Resopal), veneer, hardboard and plywood on, for example, wood, multiplex plywood, chipboard or MDF. Also for bonding flexible insulation and foam materials, cork, leather and rubber. Not suitable for polystyrene foam (Tempex®), PE, PP and vinyl.

**PROPERTIES**

- Excellent temperature resistance up to +100°C
- Aromatics-free (toluene-free)
- Liquid
- Easy to spread
- Universal
- Bonds immediately
- Moisture resistant
- Chemical resistant

**PREPARATION**

**Working conditions:** Use only at temperatures between +15°C and +25°C at a relative humidity of up to 65%. In order to prevent the formation of bubbles due to condensation, the temperature of the adhesive and materials to be bonded should be the same as the ambient temperature and preferably

between +18°C and +20°C. Never allow a draught onto pasted surfaces.

**Surface requirements:** Surfaces must be dry, clean, dust- and grease-free and a good fit. Clean and degrease the surfaces to be bonded for optimal results.

**Preliminary surface treatment:** For optimal result, degrease first.

**Tools:** Use a solid brush or fine-toothed (1 mm) glue spreader to cover large surfaces. Use a roller or rubber mallet to join the materials firmly.

**APPLICATION**

**Coverage:** 2-2.5 m<sup>2</sup>/litre, applied on both sides, depending on the nature of the materials to be bonded.

**Directions for use:**

Stir well before use. Should preferably not be diluted. Apply the adhesive thinly and evenly to both surfaces using the fine-toothed adhesive spreader (1 mm) or brush. In case of porous material, apply a second layer when the first layer is dry. Allow both surfaces to dry for 10 to 30 minutes. The adhesive should be dry to the touch. Correctly position both parts and join by pressing firmly or tapping. Once joined, the parts are immediately bonded! Adjustment is then no longer possible. Avoid entrapping of air bubbles.

**Time to press (+20°C):** Short, pressure is more important than pressure time.

**Open time:** 10-30 minutes. The adhesive should be dry to the touch and have stopped stringing. Assembly time strongly depends on the porosity of the surfaces (the more porous the surface, the faster the adhesive is absorbed so the assembly time is shorter) and temperature (a high temperature results in faster evaporation of the solvent, so the assembly time is shorter).

**Stains/residue:** Remove fresh adhesive residue immediately with Acetone. Dried adhesive residue can only be removed mechanically or with a paint remover (test first).

**Points of attention:** For optimum results, both the adhesive and the parts to be bonded must be at room temperature (definitely do not use below +10°C). The final bonding strength depends on the pressure applied. Therefore, press as firmly as possible across the entire surface. Should the adhesive joint between porous materials be exposed to long-lasting contact with water, the adhesive may detach from the wet surface.

**CURE TIMES**

**Full bond strength:** Full bond strength after approx. 24 hours

\* Curing time may vary depending on a.o. surface, product quantity used, humidity level and ambient temperature.

**TECHNICAL PROPERTIES**

**Moisture resistance:** Good

**Temperature resistance:** Between -15°C and +90°C.

**Chemicals resistance:** Oil, bases and acid resistant.

**Elasticity:** Very good

**TECHNICAL SPECIFICATIONS**

**Chemical base:** Neoprene rubber

**Colour:** Orange

**Viscosity:** approx. 5100 mPa.s.

**Solid contents:** approx. 22 %

**Density:** approx. 0.86 g/cm<sup>3</sup>

**Specifications:**

Packaging intended for professional use only.

## STORAGE CONDITIONS

At least 24 months after date of manufacture. Broken packaging limits storage life. Store properly closed in a cool and frost-free place. Shelf life is a minimum 24 months.