

# Tuskbond Red 17kg Disposable Container Technical Data Sheet 2008

## 1. TUSBOND SPAY ADHESIVE

- Tuskbond is a self contained sprayable contact adhesive. It is a multipurpose product that will bond to a wide variety of substrates. It has excellent grab and a long open time. It is CFC free and has a very low odour. The product is delivered through a hose and spray gun system, which means application, is clean and efficient. After use the gun is locked off and the system remains ready for instant re-use.

## 2. PRODUCT USES

- Tuskbond will bond a wide variety of substrates including wood, metals, rubber, fabric, most plastics, cardboard, polythene and concrete as well as decorative laminates. It can also be used to bond expanded polystyrene when forming a bond to a different substrate, in this instance the product should be used as a one way stick and only applied to the opposite substrate (do not spray onto the expanded polystyrene). It is ideal for permanent bonds that require good initial bond strength. It provides good temperature resistance and if protected from contamination has an open time of several hours. Always test a small sample of the materials first to ensure the suitability of the product for the application. For instance some vinyls contain large amounts of plasticizer which, over time, can migrate and soften the bond. When in doubt, test first.

## 3. SUBSTRATES

- Surfaces to be bonded should be clean, dry and dust and grease free. Substrates should be conditioned before assembly. This is particularly important with laminates. 48 hrs at 20°C with a relative humidity of 45-55%. Air should be able to circulate freely around the components.

## 4. TO APPLY

- Connect the hose to the canister and the spray gun to the hose and tighten the connections. Open the valve on the canister. The valve should remain open until the canister is used up. Use the locking nut on the gun after use. Turning off the valve will result in the adhesive drying in the hose and gun causing blockages. Hold the spray gun at 90° to the surface and apply a uniform generous coat of adhesive ensuring 80-100% coverage. Move the gun in parallel to the surface and pay particular attention to the edges. Do not allow the adhesive to puddle as this can cause an unevenness that can "show" through the laminate. On porous surfaces it may be necessary to apply a second coat. Always apply to the laminate first and spray one substrate horizontally and the other vertically. It is important to remember that Tuskbond is a contact adhesive and forms its bond by sticking to itself so there must be sufficient adhesive for this to happen. Allow the adhesive to tack up and protect from contamination whilst this happens. The adhesive is ready when it feels dry to the touch and does not transfer to the finger.

*NOTE: Tuskbond dries in two minutes under normal conditions but this will vary under different temperatures and humidities. High humidity and low temperatures will slow the drying time and if the temperature gets very low can produce bloom. Bloom is moisture which forms on the glue line caused by solvent evaporation lowering the air temperature above it.*

## 5. TO ASSEMBLE

- Once the two surfaces are brought together an aggressive bond will be made. Spacers can be used to ensure the surfaces do not come into contact prematurely. Once the two surfaces are brought together apply a uniform pressure over the work piece starting in the middle and working outwards. Use blocks or a 3 inch roller and ensure the whole piece has been worked to ensure adequate contact of the adhesive. Pay particular attention to edges. *Testing at this point by lifting at the edge will weaken the bond!* A nip roller will give the best results. Once assembled the piece can be machined or trimmed as required. Full cure will take 24 hours. Overspray can be removed with white spirit.

## 6. STORAGE

- Protect from extremes of temperature in a controlled environment between 15-35°C and away from direct sunlight. Do not stand on a cold concrete floor. *Low temperatures can result in low adhesive coat weights and poor bonds.* If canisters are subjected to low temperatures the adhesive will thicken and sometimes separate from the propellant. After bringing the canister back to room temperature, shake or roll the canister to mix the adhesive and propellant.

## 7. TECHNICAL DATA

- Chemical name: Sprayable Contact Adhesive
- Appearance: Clear or Red liquid
- % solids: 28-30%
- SG: 90-..99
- Coverage: 15-20 sq metres per Kg
- Shelf Life: 12 months when stored in original unopened containers .
- Do not allow to Freeze
- Use in a well ventilated area

## 8. DISPOSAL CONSIDERATIONS

- The one trip or disposable type ( 17kg )has a circular piercing ring near the neck which is designed to be punched out when the canister is completely empty so that the canister can then be safely disposed of ensuring compliance with all local, regional, national and EC regulations.

## 9. NOTICE TO PURCHASER

- Tuskbond may be used in many applications. It is the responsibility of the customer to test samples of substrates to be used to ensure suitability of the product.