



Technical Datasheet

MBS High Strength Spray Contact Adhesive

Product Description

The MBS High Strength Contact Adhesive is a CFC free, multipurpose adhesive with low odour, developed to bond a wide variety of substrates. It has excellent grab and a long open time. The High Heat version will give a temperature resistance of 105°C in unstressed bonds dependent upon substrate. The product can be delivered through a hose and spray gun system if required.

Product Uses

The MBS High Strength Contact Adhesive 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 vinyl's contain large amounts of plasticizer which, over time, can migrate and soften the bond. When in doubt, test first. **Do not use on flexible PVC.**

Application

1. Use in a well ventilated area.
2. Surfaces to be bonded should be clean, dry and free from dust and grease.
3. Substrates should be conditioned before assembly. This is particularly important with laminates. Condition for 48 hours at 20°C with a relative humidity of 45-55%. Air should be able to circulate freely around the components.
4. Connect the hose to the canister and the spray gun to the hose and tighten the connections.
5. 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.
6. Hold the spray gun at 90° to the surface and apply a uniform generous coat of adhesive, ensuring 80-100% coverage.
7. Move the gun in parallel to the surface and pay particular attention to the edges.
8. Do not allow the adhesive to puddle as this can cause an unevenness that can "show" through the laminate.



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9. 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.
10. It is important to remember that MBS High Strength Contact Adhesive is a contact adhesive and forms a bond by sticking to itself, so there must be sufficient adhesive **on both surfaces** for this to happen. 80-100% coverage on each surface is recommended.
11. Allow the adhesive to tack up and protect from contamination whilst this happens. The adhesive is ready to bond when it feels dry to the touch and does not transfer to the finger tips.

Note: MBS High Strength Contact Adhesive 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.

Assembly

1. Once the two surfaces have been brought together, and aggressive bond will be made. Spacers can be used to ensure the surfaces do not come into contact prematurely.
2. 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.
3. Pay particular attention to the edges. Please note that testing at this point by lifting the edge will weaken the bond. A nip roller will give the best results.
4. Once assembled, the piece can be machined or trimmed as required.
5. Full cure will take 24 hours.

Technical Data

Solids Content:	Approx. 28%
Viscosity:	700 - 800 cps
Colour:	Red or Clear
Tack life:	20 minutes
Coverage:	5 to 10 m ² /litre
Cleaner:	White Spirit



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Storage & Shelf Life

Protect from extremes of temperature in a controlled environment between 15 and 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. Stored under the correct conditions, in original, unopened containers, the product will have a shelf life of 12 months.

Important Note

All the information in the Data Sheet is based on practical experience and is published in good faith. However, because we have no control over the manner or conditions in which our products are used, or over work undertaken or end product manufactured by the purchaser, we cannot accept liability for results.

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