

180AQ Waterbased contact adhesive

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Technical data

Basis	Polychloroprene rubber (neoprene).
Consistency	Fluid
Curing system	Physical drying and crystallisation
Density**	Ca. 1,10 g/ml
Viscosity (Brookfield)	Ca. 3.200 mPa.s
Open time (*)	≤ 120 min.
Evaporation time (= time before closing)	Ca. 20 min ca. 5 min in combination with a (hot) air stream
Drying time (23°C and 50% R.H.)	Ca. 72h
Consumption (*)	Ca. 50 ml/m ² each side

* These values may vary depending on environmental factors such as temperature, moisture, and type of substrates. ** This information relates to fully cured product.

Product description

180AQ Waterbased contact adhesive is a waterbased, universal, liquid and solvent-free contact adhesive base upon polychloroprene.

- Specifically for adhesions on higher temperatures (+105°C)
- Not suitable for polyethylene (PE), polypropylene (PP) and Teflon® (PTFE/PFA/FEP), nor for applications whose surfaces only touch by a few points.

Properties

- Ready for use
- Fast strength build-up.
- Low usage
- Immediately fixed
- Adhesion under tension is possible
- Applicable with brush, roller or spray installation
- Moisture resistant.
- Heat resistant (until +105°C)
- Chemical resistant against light acids and bases
- Toluene and solvent free

Packaging

Colour: blue

Packaging: 5L bottle

Shelf life

At least 24 months in original, unopened packaging at a cool and dry storage place, between +5°C and +25°C. After use, close the packaging with the original cap. Store frost free

Substrates

Surface preparation: The substrate had to be clean, dry, free of dust, rust, oil and grease. Ideal to apply in a room with a temperature of minimum +18°C Make sure both the adhesive and the surfaces are acclimatised. For a better adhesion, it's recommended to roughen the surface with sanding paper P80, metal has to be free of rust and roughened at a St 3 level (according to ISO 8501-1). Both substrates have to be even and/or well matched. Always perform an adhesion test on non-current substrates prior to use.

Applications

- Used in two-sided adhesions on various materials, wood and stratified decorative coveringpanels (Formica®, Resopal®,...), veneer, stairsteps and nosings, PVC-plinths, leather, cork, textile, with each other for wood, stone, concrete, plaster, metal and other smooth, non-porous surfaces.
- Can be used for adhesion between polystyrenefoam (PS) (Isomo®, Styropor®, Frigolit®, Kemisol®, Hisfa®, ...), foamrubber, polyetherfoam

Remark: This technical data sheet replaces all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. Since the design, the quality of the substrate and processing conditions are beyond our control, no liability under this publication is accepted. In every case it is recommended to carry out preliminary experiments. Soudal reserves the right to modify products without prior notice.

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Application method

Apply the adhesive on both sides with a hard brush, roller or gun. Make sure the adhesive is spread equally. For strong porous materials (plaster, concrete, ...) a second layer can be applied after drying of the first layer (± 30 min). Dry for about 20 mins, depending on the circumstances, the product will become more transparent and close within max. 2h The adhesion happens immediately. Next press well with a roller or in a press during 15s, or tap with a rubber hammer. Close the lid immediately after usage.

Health- and Safety Recommendations

Take the usual labour hygiene into account. Consult label and material safety data sheet for more information.

Remarks

- Pressing the materials, during curing, is not necessary to reach the highest end strength. The initial strength and not the duration of the compression will determine the ultimate strength.
- 180AQ Waterbased contact adhesive can be sprayed with the conventional spray installations for waterbased products, but also with Airless/Air Assist spray systems. Make sure to use inox or plastic parts. Pressure vessels are preferred over membrane pumps, plunger pumps aren't recommended. As material for the tubes, nylon, teflon® or flexible polyethylene is recommended. When compressed air is used, make sure the oil- and waterfilter works sufficient. After usage always clean immediately with lukewarm water.
- 180AQ Waterbased contact adhesive is a waterbased product with a longer evaporation time because water evaporates slower as the usual solvents. The usual evaporation times are about 20 min, this can be shortened by a higher air circulation above the glued surface with i.a. a ventilator. If the air is heated, the evaporation time can be shortened until about 5 min.
- Once the maximum open time is exceeded and the adhesive is too dry to bond, the surface can be reactivated with an extra thin layer of 180AQ Waterbased contact adhesive.
- Bondings with 180AQ Waterbased contact adhesive are immediately fixed. Cropping and sawing is possible immediately after applying and pressing together.
- Adhesions with 180AQ Waterbased contact adhesive can resist temperatures up to $+105^{\circ}\text{C}$, but exposure to temperatures higher as 65°C or sunlight is only allowed after 72h.

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