Technical Datasheet

Stormoprene 2 Part Contact Adhesive

Two Part Toluene Free High Performance Contact Adhesive

BASE	Polychloroprene
SOLIDS	Approx 22%
VISCOSITY	Approx 3000 cps
COLOUR	Off-White
TACK LIFE	5 – 15 mins
COVERAGE	Up to 4m2/ltre
CLEANER	Solvent 7
FLASH POINT	See MSDS
SHELF LIFE	12 months @ 5 - 25ºC

DESCRIPTION

Stormoprene Two Part Adhesive is a solvent based system formulated on polychloroprene rubber. It is used in conjunction with Part B Curing Agent as a two part high performance adhesive system for a wide range of industrial applications.

* Gives high strength bonds between a wide range of materials including all types of rubbers.
* Excellent resistance to heat, salt water and humidity.
* Easy to mix two part system - supplied in sets with the requisite amount of curing agent.
* Easy to apply by brush, roller or serrated trowel.
* Contact bonds can be made within 10 - 15 minutes, full cure in 48 hours.
* Mixed adhesive has a pot life of 4 - 6 hours.

Stormoprene will bond natural, polychloroprene, butyl, nitrile, Hypalon and polyurethane rubber materials, rigid PVC, wood, leather and metal (for maximum performance it is recommended that metal is primed with Stormsure Metal Primer). It is particularly suitable for the fabrication of inflatable products such as boats, balloons, marine fenders and dracone barges and is also ideal for use in bonding rubber linings in storage tanks.

IMPORTANT

It is not recommended that Stormoprene Two Part Adhesive be used on plasticised PVC because of the possibility of plasticiser migration.

METHOD OF USE

1. Ensure that the surfaces to be bonded are clean and grease free by abrading them with clean emery cloth or by using Stormsure Solvent 2 to remove surface contamination.
2. Mix together thoroughly, for approximately 5 minutes, Stormoprene Part A, preferably in the proportions as supplied or by taking (be weight) 100 parts of the adhesive and 6 parts Part B Curing Agent.
3. Apply an even coat of the mixed adhesive to both mating surfaces by brush, roller coater or serrated trowel.
4. Allow the adhesive coats to dry for 5 to 15 minutes or until they can just be touched with the knuckles without any adhesive being transferred.

NOTE Two thin coats are preferable for maximum adhesion. The first coat should be allowed to dry for approximately 20 to 30 minutes before applying the final coat and allowing this to dry for 5 to 15 minutes.

5. Join the surfaces, taking care not to trap any air, using as much pressure as possible.

Components may be handled within minutes of being bonded.
N.B. For the maximum adhesion to metal use Stormsure Metal Primer. Stir this primer thoroughly and then apply by brush an even, thin coat to the metal surfaces.
Allow primer coat to dry for at least one hour before applying Stormoprene adhesive.
Tack life: Approximately 5 to 15 minutes dependent on the surfaces being loaded.
Pot Life: 4 to 6 hours in a closed container, but shorter in open containers due to solvent evaporation. Also the pot life can decrease with age of the adhesive.
Curing Time: 48 hours under normal ambient temperature conditions but the strength of the adhesive bond continues to increase, reaching its maximum within 6 days. Cure rate may be accelerated by heating, e.g, 2 hours at approximately 70ºC.
Coverage: Approximately 4m_2 per litre but can vary with material being bonded. (2m_2 bonded area)

Cleaner/Thinner: Use Stormsure Solvent 7 for adhesive dilution, removal of surplus adhesive and cleaning of application tools and equipment.

TYPICAL ADHESIVE CHARACTERISTICS

	Part A	Part B
Physical Form:	Low viscosity liquid	Mobile liquid
Colour:	Off-White	Brown (translucent)
Chemical Type:	Polychloroprene rubber/resin	Isocyanate solution (MDI)
Solvent:	Hydrocarbon/ketone	Chlorinated mixture hydrocarbon
Viscosity:	3.0 Ns/m_2 (30 poises)	Low.
Solids content:	22% approx.	20% approx.
Specific Gravity:	0.9 approx.	1.3 approx.
Flammability:	Highly flammable	Non-flammable

TYPICAL BOND CHARACTERISTICS

Temperature	From -40ºC to +90ºC but will withstand resistance to higher temperatures for shorter periods.
Water resistance:	Very good
Oil, Petrol and Kerosene resistance:	Fair - Good
Solvent resistance:	Not resistant to esters, ketones, aromatic and chlorinated hydrocarbons which may swell and soften the bond.
Acid and Alkali resistance:	Good, virtually unaffected by 5N sodium hydroxide.
Humidity resistance:	Good, after exposure to 100ºC RH at 38ºC for 14 days.
Ageing:	Good but exposed adhesive film can darken.

PACKAGING

250ml set 1 litre set 5 litre set 25 litre sets

Before using this product please ensure that you have been supplied with and have read carefully the following information:
1. The hazard labels (complying with CHIP and CDG/CPL Regs).
2. Stormsure Material Safety Data Sheet. The above figures do not constitute a specification. They represent typical values obtained for this product.

Date : 1/6/8