

BASE	TECHNICAL DATA SHEET	PRODUCT
Polyurethane	POLYURETHANE ADHESIVE	A.7520
SOLIDS 95 ± 1%	<p>DESCRIPTION</p> <p>Apollo A.7520 is a single part, roller-coatable, moisture curing polyurethane adhesive suitable for bonding a wide variety of substrates.</p> <p>SURFACE PREPARATION</p> <p>Materials to be bonded should be clean and free from dust, grease and other contaminants. Metals should be stored in a warm environment prior to bonding to avoid chilling of the glue line, which leads to extended cure times. Most pre-finished metals have backing coats which are well suited to bonding. However, some grades of Aluminium, Galvanised Steel and plastics can be difficult to bond and may require the use of a primer. A test panel should always be prepared when new materials are to be used to establish the adhesives compatibility.</p> <p>ADHESIVE APPLICATION</p> <p>The adhesive should be applied evenly over one side of each glue line by means of a mechanical roller coater, hand roller or notched trowel. The amount applied will vary according to the porosity of the substrates but will normally be in the range 100-125 gsm (dry). After application of the adhesive a fine mist of atomised water must be applied to the adhesive, the amount required being approximately 10% of the weight of adhesive.</p> <p>The surfaces to be bonded should then be brought together as quickly as possible, to minimise water evaporation, and placed under pressure within the open time of the adhesive. The pressure required will depend to a great extent on the nature of the substrates being bonded but is usually in the range of 0.5 to 0.9 bar.</p> <p>Pressure should be maintained until the adhesive is sufficiently cured to permit handling of the bonded item. Full cure of the adhesive is not obtained for 24 hours and handling within this period should be kept to a minimum.</p> <p style="text-align: right;">CONTINUED OVER PAGE</p>	
VISCOSITY 4000 ± 1000 cps		
COLOUR Light Brown		
TACK LIFE N/A		
COVERAGE 100 – 125 g/m ²		
CLEANER Solvent 6 or 9		
FLASH POINT See MSDS		
SHELF LIFE 3 months stored @ 5 – 25°C		

The open time and cure cycle to permit handling will vary according to:-

- | | |
|-------------------------------|----------------------------|
| 1. Temperature | 4. Method of working |
| 2. Weight of adhesive applied | 5. Substrates being bonded |
| 3. Weight of water overmist | |

and should always be determined by experiment.

Processing Guide

Weight of adhesive 100-125 gsm ²		Water overmist 10 - 15 g/m ²			
Temperature °C	15	17.5	20	22.5	25
* Open time mins	40	32	25	20	15
* Cure time mins	90	70	55	45	35

* measured from when the water overmist is applied.

STORAGE AND HANDLING

Apollo A.7520 is a moisture sensitive adhesive and left in contact with the open atmosphere will eventually gel. For this reason Apollo A.7520 is protected with a blanket of Nitrogen in the drum prior to despatch, which forms a dry, inert layer on top of the adhesive. The adhesive under these conditions will have a storage life of three months, provided the containers are stored unopened in a dry place at a temperature between 4°C and 25°C. Once the container has been opened for use and the inert blanket replaced by moist air, the adhesive will have a limited life.

Ref : A.7520

Date : 28/09/2006

The above figures do not constitute a specification. They represent typical values obtained for this product.

HEALTH AND SAFETY

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. Apollo Material Safety Data Sheet A. 7520

IMPORTANT NOTICE

This leaflet is for general guidance only and may contain inappropriate information under particular conditions of use. All recommendations and suggestions are therefore made without guarantee. Samples will be provided on request to enable customers to satisfy themselves as to the suitability of the product for any specific purpose and to assess the product under their own working conditions.

Please note that the BSI/UKAS logo for BS EN ISO 9001:2000 Certification on this document refers to the Quality Management System used throughout the production of products.