

AF178

HIGH HEAT RESISTANT CONTACT ADHESIVE



PRODUCT INFORMATION

Alpha AF178 has been developed as a multi-purpose contact adhesive where high strength and heat resistant performance is desired. It is an easily applied adhesive with short open time that forms strong and permanent contact bonds. The combination of fast drying, long tack life and excellent hot strength make it an ideal choice for automotive trim bonding.

KEY INFORMATION

- **Multi-purpose contact adhesive**
- **Excellent high temperature performance**
- **Excellent bond strength**
- **Short open time**
- **Easy to use**

TYPICAL APPLICATIONS

Alpha AF178 is suitable for the following applications:

- Laminate materials (e.g. Formica, Waverite, Melamine) to wood
- Polyurethane foams or mineral wool panels to plasterboard
- Painted or unpainted metals to most surfaces
- General purpose adhesive for wood, rubber, most plastics, fabrics, cork, linoleum and rigid PVC

PRODUCT CHARACTERISTICS

The following technical information and data should be considered representative or typical only. Therefore, the information should not be used for specification purposes.

Property	Data
Colour	Yellow
Base	Polychloroprene rubber
Consistency	Liquid
Specific Gravity (20°C)	0.880
Total Solids Content	26.0-30.0 %
Viscosity (20°C)	5,500 – 6,500 cP
Heat Resistance	up to 100°C
Open Joint Time	7 to 20 minutes*
Coverage	3 – 4 m ² of bonded material / litre*

* dependent upon ambient temperature, relative humidity and the materials used.



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PRODUCT PERFORMANCE

The performance data presented here has been determined by Alpha Adhesives & Sealants Limited standard test methods and are average values that should not be used for specification purposes. Our recommendations on the use of this product are based on tests believed to be reliable. It is advised that users conduct their own tests to determine the suitability of the product for their specific application.

Test	Substrates	Results/Observations
180° Peel Test	Cloth-backed PVC Leather to Painted Steel	50N/25mm, 7 days testing at Room Temperature
180° Peel Test	Cloth-backed PVC Leather to Painted Steel	50N/25mm, 7 days testing at 100°C
180° Peel Test	Cloth-backed PVC Leather to Painted Steel	20N/25mm, 72 hours testing at 100% R.H.

HANDLING & APPLICATIONS

The general application information presented here is based upon typical conditions determined by Alpha Adhesives & Sealants Limited testing. Our recommendations on the use of this product are based on methods believed to be reliable. It is advised that users conduct their own tests to determine the suitability of the product for their specific application.

Process Step	Guidelines
Surface Preparation	All substrates must be clean of any dust, grit, loose material, wax, grease and oil using Alpha T559 or a suitable cleaner. The materials to be bonded should be dry.
Adhesive Application	TWO-WAY STICK 1. Stir before use. Using a brush or spreader, apply a thin even coating of adhesive to both of the surfaces. 2. Allow the solvent content to evaporate before bonding the materials (touch dry) . The time for this evaporation will depend on the temperature and humidity. 3. Bond the materials under firm pressure. 4. Dried coatings of Alpha AF178 may be reactivated by wiping over the surfaces with solvent T559. Alternatively, Alpha AF178 may be treated with infra red heat, exposing one surface at 95°C ± 5°C.
Curing	The immediate high contact bond strength increases appreciably within the next 48 hours and will develop still further in service. For the best heat resistance, leave at room temperature for 7 days, before subjecting to high in-service temperatures up to 100°C.
Cleaning	Alpha Cleaner T559 should be used to remove residues from surfaces.

HEALTH & SAFETY INFORMATION

Alpha AF178 is classified as hazardous according to Directive EC 1272/2008. Please refer to the Alpha AF178 Safety Data Sheet for further health & safety information.

STORAGE

Alpha AF178 should be stored in its original container, with the lid tightly secured, in dry conditions and at temperatures between 5°C and 25°C. Alpha AF178 will keep satisfactorily for up to 18 months from date of manufacture if stored according to the recommended conditions.

PRODUCT AVAILABILITY

Product Reference	Pack Size	Container	Box Quantity
Alpha AF178	205 L	Drum	N/A
Alpha AF178	5 L	Tin	N/A
Alpha AF178	1 L	Tin	12

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