

NIGHTINGALE SUPPLY

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TECHNICAL DATA SHEET

SUPRASEC 7113

(Formerly known as Daltobond CLS)

Summer Grade Laminating Adhesive

- **DESCRIPTION**

Is a sprayable, solvent borne, flexible polyurethane adhesive suitable for bonding a wide range of Substrates including polystyrene foam, timber, plastic, aluminium and Colorbond surfaces. It has been designed for bonding polystyrene foam to a wide variety of flexible and rigid facing materials in the manufacture of insulation and structural sandwich panels.

The adhesive system is moisture cured and hence the cure rate is related to the prevailing relative humidity and temperature of the substrates and the atmosphere. The adhesive is already activated by addition of catalyst for use during the summer periods. Maximum flexibility of operation is retained if the catalyst is supplied separately (as Suprasec CLS and Suprasec Cat1 package) as the cure-open time can be adjusted to the required level by selecting the appropriate catalyst additions. Cure time can be reduced significantly by use of a hot press.

Suprasec 7113 cures to a tough flexible film and hence can be used for flexible film and rigid substrates. It has been specifically designed to allow some initial slip after lamination to aid in the ready alignment of assemblies.

- **TYPICAL PROPERTIES:**

Appearance:	Red Liquid
Viscosity:	Approximately 75 cps
Solids Content:	Approximately 50%
Boiling Point:	Approximately 40°C (Solvent)
Specific Gravity:	1.17
Solvent:	Predominantly Methylene Chloride
Flammability:	Non-Flammable
Shelf Life:	Best used within 6 months from date of manufacture.

- **DIRECTIONS FOR USE:**

The surface is designed for spray application at a rate of 100 – 200 gsm to one surface of the glue line. Airless spray with a pump of ratio of 30:1 and a fluid pressure of 8-17 Mpa (1200-2500 psi) is recommended.

An air assisted spray gun can also be advantageous. Spray tips which give a wide spray area and of relative large diameter (0.017" – 0.025") are recommended.

The adhesive is particularly suitable for high speed lamination as the methylene chloride based solvent system ensures solvent retention is minimised.

Where very rapid assembly is required, the coated panels should be passed under infra-red or hot air heaters prior to assembly. It is generally recommended that panels can be assembled within 30 minutes although under normal temperatures and humidity good adhesion can be obtained after at least 45 minutes open time. Pressing of the assemblies is recommended to ensure intimate contact. Low pressures (28- 70kPa ie. 4 – 10 psi) are generally all that is required. Cure can be greatly accelerated by a hot press where excellent bonds can be achieved within 12 minutes at 50° compared with 1 – 1.5 hours at ambient temperatures. More detailed application information is available on request

- **COVERAGE:**

Suprasec 7113 Cat Z is designed for use at an application rate of 100 – 200 gsm, to one surface of the lamination. Coverage rates will vary depending on the porosity and texture of the surfaces to be bonded.

- **CLEAN UP:**

Moisture can permeate into spray equipment in time, particularly when the equipment is not being used. This may cause the adhesive to gel and subsequent line blockage. It is recommended that the equipment be thoroughly cleaned whenever the line is to be shut for a period of time. Providing moisture impervious lines such as Teflon are utilised the adhesive can be left in the sealed system for longer periods of time. The lines should be flushed with a suitable solvent such as methylene chloride, leaving the spraying system full of solvent.

- **STORAGE & HANDLING:**

Store in a cool dry place. Partially used containers should be purged with dry nitrogen to prolong storage stability as the material will skin in 2-3 hours if left in contact with humid air. If contact with moisture or water occurs the drums should not be resealed. Reaction with water leads to gas evolution with possible pressure build-up. Preferably part-used containers should be purged with dry nitrogen for maximum storage stability.

The information presented is believed to be accurate, however, no guarantee is implied or given. User should conduct their own testing to determine the suitability of any product for a particular purpose.