

# TECHNICAL DATASHEET

## Hi-Tack Spray Bonding System Web Spray

### Description & Uses

AlphaChem Web Spray aerosol is a fast drying, high tack spray adhesive, suitable for permanently bonding a wide variety of substrates including wood, metals, rubber, most plastics, cardboard, polythene and concrete, as well as decorative laminates. It provides a permanent bond with good temperature resistance.

### Directions

- Use in a well ventilated area.
- Ensure all surfaces are clean, sound, dry and free from dust, grease or other contaminants.
- Substrates should be conditioned before assembly, this is particularly important with laminates. Condition for 48 hours at 20°C with a relative humidity of 45-55% - air should be able to circulate freely around all components.
- Hold the aerosol at approximately 70° to the surface and apply a generous and even coat of adhesive, ensuring 80-100% coverage, moving the aerosol parallel to the surface, pay particular attention to the edges.
- On porous surfaces a second coat might be necessary – always apply to laminate first and spray one surface horizontally and the other vertically.
- When the adhesive is dry to the touch, and does not transfer, it is ready for bonding.
- Bring the two surfaces together and apply a uniform pressure, starting in the middle and working out, pay particular attention to the edges.
- Drying time is 2 minutes under normal conditions, but this will vary with differing temperatures and humidity's. High humidity & low temperatures will slow drying time, and if the temperature gets very low it can produce bloom. Full cure takes 24 hours.
- Avoid over spraying and pooling of the adhesive as this will increase the drying time and may cause adhesive to show through the laminate. If the surfaces are bonded without allowing the adhesive to become dry, solvent entrapment will occur and this will lead to bond failure.
- It is the user's responsibility to dispose of all packaging correctly.

### Cleaning

Web Spray Aerosol can be removed with most solvent cleaners.



### Storage

Store between 5° and 25° in clean dry shaded conditions in original unopened containers. Do not allow the product to freeze.

### Shelf Life

24 months when stored as directed.

### Limitations

- Always test a small sample of the materials first to ensure the suitability of the product for the application. For instance, some vinyl's contain large amounts of plasticiser which, over time, can migrate and soften the bond. When in doubt, test first.
- Do not use on flexible PVC or expanded polystyrene.
- It is the user's responsibility to ensure suitability for use. It is advisable to read the SDS prior to use.
- Read the label carefully for essential health and safety information prior to use.

### Technical Data

<b>Colour</b>	Clear
<b>Appearance</b>	Liquid
<b>Coverage</b>	2.5 m <sup>2</sup> (Typical coat weight of 25gm <sup>2</sup> )
<b>Solids Content</b>	28-30%
<b>Specific Gravity</b>	~1.2

### Further Information:

In the event of further queries or problems concerning the use of this product, please contact the address below, e-mail [info@cromar.uk.com](mailto:info@cromar.uk.com).

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