



The Glue People

Trade Grade Products Ltd
Unit 2, Thorne Way
Woolsbridge Industrial Park
Three Legged Cross
Wimborne, Dorset, BH21 6FB

Tel 01202 820177
Fax 01202 814011

Tradegrip GP SAF 20 TX

Thixotropic contact adhesive.

General Description

Tradegrip SAF 20 TX is a thixotropic contact adhesive which is clean and easy to apply. Being a non-drip adhesive it is ideal for use on vertical as well as horizontal surfaces. Tradegrip SAF 20 TX produces bonds with excellent bond strength and good temperature resistance.

Recommended use

- Tradegrip SAF 20 TX is ideal as a general purpose contact adhesive; particularly suitable for bonding decorative laminates/plastic sheets and other rigid plastics such as PVC and ABS to wood, metal and wood composite boards.
- Tradegrip SAF 20 TX may also be used to bond cane fibre boards and acoustic tiles to suspended or vertical surfaces such as dry cement/sand renderings. Most types of plastic nosings and coverings may also be bonded.
- Tradegrip SAF 20 TX is intended for interior use, but it has been successfully used in exterior locations protected from the weather, such as for laminates bonded to shop fronts.
- Tradegrip SAF 20 TX is unsuitable for use with expanded polystyrene, with polyolefins such as polyethylene and with bituminous substrates, it is also unsuitable for use where only point contact is obtained between the surfaces to be bonded.

Application

Preparation

Surfaces must be cleaned, dry, smooth, firm and free from any contaminants liable to impair adhesion. Smooth or polished surfaces should first be roughened with a fine abrasive. If degreasing is necessary; a detergent/water treatment should first be considered. If this is inappropriate a suitable solvent may be used. It is advisable to check the effects of degreasing solvents on plastics, rubber materials and painted surfaces before carrying out the operation. Allow all solvent to evaporate before the application of adhesive.

Method of application

Apply an even, ribbed coat of adhesive to both surfaces using a trowel or serrated spreader. For correct coverage use the spreader at such an angle as to give good rib formation after drying. If a white 'bloom' appears on the surface, raise the temperature and/or dry the atmosphere.

Drying time depends on the film thickness, temperature, humidity and porosity of the substrates. Approximate touch-dry times are 15 to 20 minutes for porous substrates and 23 to 35 minutes for non-porous substrates.

Bring the two dry-coated surfaces into contact within 45 minutes of application and press together over the entire bond area. To obtain optimum initial bond strength surfaces should be bonded as soon as possible after drying. Apply as much pressure as possible using a hand roller, static press or nip roller without causing damage. Sustained pressure is not necessary.

Bringing the surfaces together before they are touch-dry will result in solvent being trapped which will adversely affect the final bond, possibly giving rise to blistering problems.

Tradegrip SAF 20 TX is a contact adhesive and the bond is formed as soon as the two surfaces touch, it is therefore essential with large areas to avoid contact before the parts are in alignment. The adhesive does allow for slight adjustment in the positioning of small areas of the materials being bonded provided no pressure is applied that would induce appreciable contact between the surfaces.

The initial bond strength allows for immediate handling of the assembly, but maximum bond strength is reached after approximately 48 hours at normal temperatures.

Special bonding methods

In some applications it may be convenient to pre-coat components some time before assembly is required. TradeGrip SAF 20 TX may be adapted to this type by means of reactivation processes. The adhesive film must be kept free from contamination.

Reactivation by heat: The dried adhesive film may be reactivated by heating to a temperature of 85-95°C. A battery of 4 x 250W infra red lamps placed 200-250mm above the coated surface will provide adequate reactivation in 30-90 seconds. The actual time being dependant on the nature and/or colour of the substrate.

Reactivation by solvent: Pre-coated areas may also be reactivated by a brush of Tradesolve 1, normally only one surface should be brushed. The bond should not be made until the activated film has reached a touch-dry state.

Physical Data

Physical form	Thixotropic gel.
Colour	Off white to amber.
Chemical type	Polychloroprene rubber / synthetic resin blend.
Solvent	Ethyl acetate / hydrocarbon blend.
Flammability	Highly flammable.
Solids content	22% (approx.)
Specific gravity	0.89 (approx.)
Storage life @ 25°C	12 months. Store in accordance with the requirements of the petroleum regulations in a dry, flame-proof area between 5°C and 25°C.
Dry tack time	15-20 minutes for porous substrates. 23-35 minutes for non-porous substrates.

Special comments

Important Notice

Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheet, TradeGrip SAF 20 TX.