

AN1823

NON-FLAMMABLE CONTACT ADHESIVE



PRODUCT INFORMATION

Alpha AN1823 is a non-flammable, multi-purpose contact adhesive that forms strong, permanent contact bonds between a wide range of materials such as rigid PVC sheet, polyurethane foams, PVC leather cloth, leather, polyester glass fibre, rubber sheet and extrusions all of which may be bonded to each other or to hardboard, chipboard, wood, painted or unpainted metal. Rigid laminated plastics such as Formica, Ware rite, Melamine, etc., may also be fixed with this adhesive.

The product is well established in the automotive and coach building industries as a multi-purpose body trim adhesive. Typical body trim and coach building operations to which AN1823 is suited include door and facia trim, roof headlining, parcel racks and glove compartments. AN1823 has also proved its versatility in the shop-fitting and bar-fitting trades and in the boat building, furniture and footwear industries, where it is widely used as a multipurpose adhesive.

KEY INFORMATION

- **Non-flammable**
- **Multi-purpose adhesive**
- **Bonds to a wide variety of materials**
- **Easy to apply**
- **Long open time**

TYPICAL APPLICATIONS

Alpha AN1823 is suitable for the following applications:

- Bonding laminate materials (e.g. Formica, Warerite, Melamine) to wood
- Interior trimming in the automotive, marine and transportation industries
- All purpose adhesive for wood, rubber, most plastics, fabrics, cork etc.

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	Off-white or light yellow
Base	Polychloroprene
Consistency	Liquid
Specific Gravity (20°C)	1.248
Total Solids Content	15 – 17 %
Viscosity (20°C)	5000 – 6500 cP
Heat Resistance	up to 70°C
Open Joint Time	10 – 40 minutes*
Coverage	3 – 4 square metres of bonded material / litre*

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



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 Wood	> 20 N / 50mm
180° Peel Test	Cloth-backed PVC Leather to Painted Steel	> 20 N / 25mm

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 TN1239 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 is approximately 10-40 minutes depending on the surface to be bonded as well as application temperature and humidity. 3. Bring the surfaces together (avoid any trapped air bubbles) and apply as much pressure as possible to the whole area. The use of a hand roller is recommended.
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 70°C.
Cleaning	Alpha Cleaner TN1239 should be used to remove residues from surfaces.

HEALTH & SAFETY INFORMATION

Alpha AN1823 is classified as hazardous according to Directive EC 1272/2008. Please refer to the Alpha AN1823 Safety Data Sheet for further health & safety information.

STORAGE

Alpha AN1823 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 AN1823 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 AN1823	25 L	Drum	N/A

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