

# 145 SPT Spray – Contact Adh.

## Product description

145 SPT Spray – Contact Adh. is a ready to use, toluene free, sprayable, contact adhesive based on polychloroprene rubbers.

## Properties

- Ready to use (on a sprayable viscosity)
- Immediately fixed
- Fast build-up of end strength
- Moisture resistant
- Resistant to high temperatures

## Applications

- Used in two-sided adhesions on various materials, wood and stratified decorative coveringpanels (Formica®, Resopal®,...), veneer, stairsteps and nosings, PVCplinth, leather, cork, textile, with each other for wood, stone, concrete, plaster, metal and other smooth, non-porous surfaces
- Meant for all adhesions where a fast bonding is required, for adhesions of two non-porous materials
- Only for interior use

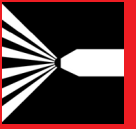
## Technical data

Base	Polychloroprene rubber
Consistency	Liquid
Curing system	Physical drying and crystallisation
Drying time	ca. 72 hours
Density	ca. 0,81 g/ml
Viscosity	250 mPa.s - 400 mPa.s
Open time	ca. 20 minutes
Consumption	ca. 50 ml/m <sup>2</sup> , each side
Application temperature	Ideal between +15°C and +20°C, Min. +10°C, Max. +25°C
Temperature resistance	-15°C → +70°C
Pressing time	15-30 sec
Solid content	ca. 17%
Evaporation time	ca. 10 minutes

*Footnote: evaporation time, open time and curing speed may vary depending on environmental factors such as temperature, moisture, and type of substrates.*

## Substrates

- Substrate condition  
The surfaces must be clean, free of dust, grease, oil and rust.
- Substrate preparation  
Make sure both the adhesive as the substrates are acclimatized. For a better adhesion, it is recommended to roughen the surface with sanding paper P80. Metal has to be free of rust and roughened at a St 3 level (according to ISO 8501-1). Both substrates have to be even and/or well matched.
- Substrate types  
145 SPT Spray – Contact Adh. has no good adhesion or is not suitable for PE, PP, PTFE (Teflon®), bituminous substrates. Given the wide variety of EPDM-substrates, a preliminary adhesion test is required. We recommend a preliminary adhesion and compatibility test on every surface.



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## Application method

- Application method  
Sprayable with the traditional spray installations or with pneumatic spray guns. Opening: 2,5 mm or wider Pressure: 3 to 5 bar Pressure on can: 0,5 to 2 bar, also sprayable with a HVLP gravity feed spray gun. Remark: The adhesive doesn't spray like a paint, it forms drips and wisps. When the adhesion doesn't have to happen immediately or when bonding two non-porous materials: Apply the adhesive two-sided with the spray gun. Make sure that the adhesive is sprayed equally, the coverage has to be min. 80%. For strong porous materials (plaster, concrete, ...) a second adhesive layer has to be applied, ± 20 mins after the first layer. Wait for ca. 10 minutes and join both parts together. The bonding happens immediately. Then press hard with a roller or tap strongly with a rubber hammer. The applied pressure and not the duration of the compression will determine the ultimate strength of the bond. If the adhesion has to be adapted (at least 1 substrate has to be porous) or when bonding two porous materials: It's sufficient to apply 145 SPT Spray – Contact Adh. on one of the two sides.
- Application tools  
Pneumatic gun  
Spray opening: 2,5mm  
Pressure: 3 - 5bar  
Pressure on can: 0,5 - 2bar
- Cleaning method  
Apply solvent cleaner to a cloth to wipe off uncured product.
- Repair method  
Repair with the same material.

## Health- and Safety Recommendations

Dangerous. Respect the precautions for use.  
Use only in well-ventilated areas.  
In case of insufficient ventilation it is appropriate to wear respiratory protection.  
Do not smoke.  
Take the usual labour hygiene into account. Consult the packaging label and safety data sheet for more information.

## Packaging/Logistics

Packaging: Various sizes available. Please consult the product catalogue, the Soudal website or a Soudal representative.  
Shelf life: 12 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C, The product should be stored in accordance to the rules of storage of inflammable substances. Consult material safety data sheet for more information.

## Remarks

- When the metal is free of rust and roughened, it's important to ground the element. A discharge of static electricity can ignite the solvents if the adhesive is applied on the surface.
- Pressing the materials, during curing, is not necessary to reach the highest end strength. The initial strength and not the duration of the compression will determine the ultimate strength.
- Once the maximum open time is exceeded and the adhesive is too dry to bond, the surface can be reactivated with an extra thin layer of 145 SPT Spray – Contact Adh.

This technical data sheet replaces all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. It is general in nature and does not constitute any liability. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. Since the design, the quality of the substrate and processing conditions are beyond our control, no liability under this publication is accepted. It is the responsibility of the user to determine by his own tests whether the product is suitable for the application. In every case it is recommended to carry out preliminary experiments. The manufacturer reserves the right to modify products without prior notice.