

# Soudabond 480 Power Spray

## Product description

Soudabond 480 Power Spray is a strong and fast contact adhesive based on synthetic rubbers. It is applied two-sided. Soudabond 480 Power Spray is intended to be sprayed.

## Properties

- Universal use
- Short evaporation time
- Fast build-up of end strength
- High end strength
- Doesn't contain toluene and methylene chloride
- Compatible with polystyrene
- Fast drying
- Very good adhesion on many materials

## Applications

- For bonding a broad range of materials (not suitable for uneven surfaces)
- Suitable for the fast bonding of e.g. plastics, metal, timber, porcelain, cork, leather, ceramics, cardboard, paper and rubber

## Technical data

Base	Synthetic rubber
Consistency	Fluid
Curing system	Physical drying
Density	ca. 0,79 g/ml
Viscosity	100 mPa.s - 130 mPa.s
Open time	ca. 60 minutes
Consumption	100 - 300 ml/m <sup>2</sup> , each side
Application temperature	5°C - 30°C
Temperature resistance	-20°C → +100°C
Pressing time	15-30 sec
Solid content	ca. 19%
Evaporation time	ca. 3 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 materials should be flat and well fitting as well as clean, dry and free of dust and grease.
- Substrate preparation  
Both substrates have to be even and/or well matched. Rough grinding of smooth surfaces improves the adhesion. All substrates should be tested for suitability with regard to adhesion and compatibility.

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## ■ Substrate types

Soudabond 480 Power Spray has a good adhesion to following substrates: all common materials. Beware of migration of the plasticizer from soft plastics, this might negatively influence the bond. Soudabond 480 Power Spray has no good adhesion or is not suitable for PE, PP, PTFE (Teflon®). We recommend a preliminary adhesion and compatibility test on every surface.

## 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.

2-Sided application (permanent bond): Apply the adhesive evenly to both to be bonded surfaces. 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. 3 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.

### ■ 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.

Since the can contains flammable propellant, all possible ignition sources should be removed before application.

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

- 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 Soudabond 480 Power Spray
- The applied pressure and not the duration of the pressure will determine the ultimate strength of the bond.
- Not suitable for synthetic materials with a high percentage of plasticizer.
- Do not use in applications where continuous water immersion is possible.

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.