

# S1922 (TF)

HIGH PERFORMANCE SPRAYABLE ADHESIVE



## PRODUCT INFORMATION

Alpha S1922 (TF) is a powerful, general purpose adhesive, having high heat resistance. S1922 (TF) has been formulated without the use of toluene enabling it to be sold to the general public, due to its use of a safer solvent system.

Alpha S1922 has been developed to be applied with spray systems. The high performance of the finished bond makes it suitable for use in a wide range of applications particularly in the automotive, building and furniture Industries. This adhesive has excellent spraying characteristics. The finished bond exhibits high strength and high heat resistance.

## KEY INFORMATION

- High performance adhesive
- Excellent heat resistance
- Easy to use
- Toluene Free
- Instant tack

## TYPICAL APPLICATIONS

Alpha S1922 (TF) is suitable for the following applications:

- Automotive Industry: Bonds to many of the substrates commonly used in automotive industry such as polyester, ABS, metals, plastics and leather cotton backed PVC
- Building Industry: Bonding a wide range of materials including Asbestolux, Plasterboard, Plywood, Chipboard, rigid Polyurethane and PVC foam, laminated plastics, copper and aluminium foils, vitreous enameled metal paints and other painted surfaces.
- Laminate Industry: Bonding laminated plastic veneers, such as Formica, Arborite and Perstop, etc, to a wide variety of core materials.
- Furniture Industry: Bonding foam cushioning to molded chair shells and settees S.1922 will withstand the heavy bull nosing required for edge finishing.

## PRODUCT CHARACTERISTICS

The following technical information and data should be considered representative or typical only. Therefore, the information should not be used for specification purpose.

Property	Data
Colour	Yellow
Base	Polychloroprene rubber
Consistency	Liquid
Specific Gravity (20°C)	0.818
Total Solids Content	18.0 ± 1.5 %
Viscosity (20°C)	120-280 cP
Open Joint Time	Porous Substrates: Instant to 25 minutes* Non-Porous Substrates: 5 to 45 minutes*
Cure Time	7 days
Heat Resistance	- 40 to 140°C
Coverage	5-9 m <sup>2</sup> / 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 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 Polycarbonate -ABS	> 50N/25mm, 7 days testing at 20°C
Shear Test	Wood - Aluminium	743N/625 mm <sup>2</sup>
Shear Test	Wood - Laminate	1092N/625 mm <sup>2</sup>

## HANDLING & APPLICATIONS

The general application information presented here is based upon typical conditions determined by Alpha Adhesives & Sealants 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 T559 (TF) or a suitable cleaner. The materials to be bonded should be dry.
Adhesive Application	<p>Using a suitable spray delivery system, apply Alpha S1922 (TF) adhesive to both substrates that are to be bonded. Ensure that an even coat is applied in all cases.</p> <ul style="list-style-type: none"> <li>For non-porous substrates (e.g. metal, plastics) – apply two to three thin layers over substrate and allow to dry for 5 to 15 minutes.</li> <li>For porous substrates (e.g. wood, leather) – apply two to three layers over substrate and allow to dry for 1 to 10 minutes.</li> </ul> <p>Allow the applied coat of adhesive to achieve a tacky, touch dry state (times according to above instructions). Assemble the bond and consolidate with sufficient pressure to assure a good contact across the bond line. The use of a nip-roller is preferred for ensuring optimum contact is achieved across the bonded area.</p>
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 140°C.
Cleaning	Alpha Cleaner T559 (TF) should be used to remove residues from surfaces.

## HEALTH & SAFETY INFORMATION

Alpha S1922 (TF) is classified as hazardous according to Directive EC 1272/2008. Please refer to the Alpha S1922 (TF) Safety Data Sheet for further health & safety information.

## STORAGE

Alpha S1922 (TF) 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 S1922 (TF) will keep satisfactorily for up to 12 months from date of manufacture if stored according to the recommended conditions.

## PRODUCT AVAILABILITY

Product Reference	Pack Size	Container	Box Quantity
Alpha S1922 (TF) Clear	205 L	Drum	N/A
Alpha S1922 (TF) Clear	25 L	Drum	N/A
Alpha S1922 (TF) Red	25 L	Drum	N/A
Alpha S1922 (TF) Clear	5 L	Tin	N/A

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