

Adhesive CR 3301 CONTACT ADHESIVE FOR FIXING CORK, BAMBOO, WOOD COATINGS AND BONDING POROUS MATERIALS.

AREAS OF APPLICATION.

Adhesive CR 3301 specifically designed for fixing different types of coatings (including flexible) to almost any surface. Recommended for fixing natural veneer, cork and bamboo coatings, coatings made of natural fibers, rubber coatings (rolled and tiled), vulcanized rubber, textiles and nonwovens, as well as bonding of these materials on a variety of surfaces.

PROPERTIES.

- High strength and good thermal stability of the assemblies.
- Resistance to hydrolysis (water resistance), acids and mineral oil.
- Good connection flexibility, including at low temperatures.
- Easy to apply.
- High adhesion to most bases.
- Long open time, which allows working with large surfaces.

TECHNICAL DATA.

Based	<i>polychloroprene rubber and synthetic resins in organic solvents.</i>
Colour	<i>light brown</i>
Conventional solids content, %	<i>20 – 22</i>
Viscosity at 20°C, mPa.s	<i>approx. 2500</i>
Density at 20 °C, g/cm ³	<i>approx. 0.83</i>
Open time at 20 °C, min	<i>35</i>
Bond Strength, N/cm, 24 hour	<i>50 – 60</i>
The time to reach 70% of maximum strength, min	<i>60 – 90</i>
Temperature resistance of the assemblies (adhesive strength not less than 20 N/cm), °C	<i>70</i>
Maximum allowable operating temperature (short-term exposure), °C	<i>100</i>

PACKAGING.

Metal can 620g (0,8L)	12 units in cardboard box
Conical metal container 2,3kg (3L)	4 units in cardboard box
Conical metal container 16,5kg (20L)	
Cylindrical metal container 40kg (50L)	

STORAGE.

Storage time 12 months. Recommended storage temperature: 5 - 25 °C. Storage in original containers.

SAFETY.

Highly flammable and irritant.

This product data sheet is only valid in conjunction with the latest edition of the corresponding Safety Data Sheet. Any updating of safety-relevant information – in accordance with statutory requirements – will only be reflected in the Safety Data Sheet, copies of which will be revised and distributed. Information relating

Technical Datasheet

Adhesive CR 3301

to the current classification and labeling, applications and processing methods and further data Read material safety data sheet before use.

INSTRUCTIONS FOR USE.

Substrates preparation:

The substrates to be assembled must be dry, dust free and not have any traces of grease or other contaminants that could adversely affect the adhesive performance. They may be cleaned with MEK or ethyl acetate. Check the compatibility of the solvent used with the substrates. If necessary, rub down metal surfaces beforehand and clean them. When using solvents, extinguish all sources of ignition and carefully follow the safety and handling instructions given by the manufacturer. Surfaces humidity must not exceed 3%.

Application :

Apply a regular layer with a brush or a notched spreader to each substrate.

Recommended temperature for glue application is 18 – 22 °C, humidity 60 – 65%. For highly absorbent surfaces (such as chipboard, gypsum) are recommended double glue application with 10 minutes interval between each application. For non-absorbing – one glue application. Apply nearly 120 – 140 g of adhesive for each square meter.

Drying:

Adhesive film should be dried under natural conditions. Minimal drying time depends on temperature and usually near 8 – 12 minutes. The end of drying is easy to identify by touch – adhesive ceases to be tacky.

Bonding:

Press products to each other thermally activated adhesive films, and highly compressed (pressed) or rolled rollers. Leave under load is not needed.

Attention. The time between the by compressing and thermal activation must not exceed the open time - this glue - 35 minutes. After 60 - 90 minutes adhesive joint strength reaches 70% of its maximum. A further increase in strength occurs slowly during 30 - 40 hours.

PRECAUTIONS FOR USE.

Adhesive CR 3301 cannot be used for bonding expanded polystyrene or untreated polyethylene, polypropylene, fluorinated polymers or plasticised PVC.

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