

Adhesive Stels CR 3402 multifunctional contact adhesive for bonding various materials. Excellent adhesion to metal.

AREAS OF APPLICATION.

Adhesive Stels CR 3402 specifically designed for bonding rubber, metal, leather, wood, chipboard, plastic. Not recommended for bonding polystyrene, polyolefins.

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.
- The mean open time, allowing to work with large surfaces.
- High strength instantly.
- Short time for further increase in strength.

TECHNICAL DATA.

Based	<i>polychloroprene rubber and synthetic resins in organic solvents.</i>
Colour	<i>Light brown</i>
Conventional solids content, %	<i>25 – 27</i>
Viscosity at 20°C, mPa.s	<i>approx. 600</i>
Density at 20 °C, g/cm ³	<i>approx. 0.83</i>
Open time at 20 °C, min	<i>20</i>
Bond Strength, N/cm, 24 hour	<i>47 – 60</i>
The time to reach 70% of maximum strength, min	<i>15 - 20</i>
Temperature resistance of the assemblies (adhesive strength not less than 20 N/cm), °C	<i>80</i>
Maximum allowable operating temperature (short-term exposure), °C	<i>110</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 on distance from open flame.

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 Stels CR 3402

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 surfaces should be sound, smooth, clean and dust-free. Surface may be painted (paint should hold well).

Application :

Apply a regular layer with a brush or spray application to each substrate. Recommended applying temperature 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 100 – 120 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 - 20 minutes. After 15 - 20 minutes adhesive joint strength reaches 70% of its maximum. A further increase in strength occurs slowly during 30 - 40 hours.

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