



TECHNICAL DATA SHEET

GP2000 CONTACT ADHESIVE

INTRODUCTION

GP 2000 Contact Adhesive is a general purpose, one part, synthetic, rubber/resin contact adhesive, particularly suitable for bonding decorative laminated plastic sheets, and other rigid plastics sheets (e.g. PVC and ABS), to wood, metal and all types of boards, except bituminous materials. GP 2000 Contact Adhesive may also be used to bond boards of insulating fibre and cane fibre, rigid polyurethane foam, laminated panels and acoustic tiles to suspended or vertical surfaces such as flat-surfaced ceilings or walls. Most types of rigid plastics nosings and covings may also be bonded.

The adhesive is intended to be used in interior situations. It is not suitable for use with expanded polystyrene, nor with polyolefins such as polythene, and it is also unsuitable for use where only point contact is obtainable between the surfaces to be bonded.

FEATURES

- Excellent final bond and high shear strength
- Good temperature resistance
- Variety of application
- Easy to apply by brush or serrated spreader
- High initial grab

METHOD OF USE

Important:

Before embarking on any work involving GP 2000 Contact Adhesive, study the section overleaf headed "Precautions in Use". The safe usage of GP 2000 Contact Adhesive Primer, Accelerator (DF or DFE) and GP 2000 Contact Cleaner as described in separate Product Data Sheets.

Surface Preparation

Surfaces should be clean, dry and free from dust and grease. Smooth or polished surfaces should be finely abraded. Degrease with a detergent/water treatment; if this is inappropriate, GP 2000 Contact Adhesive, GP 2000 Contact Cleaner may be used, after checking the effect of the solvent on plastics, rubber materials and painted surfaces. All traces of solvent must evaporate before application of the adhesive.

Porous surfaces soak up the adhesive and lead to poor bonding. In such cases, GP 2000 Contact Adhesive may be applied by brush or paint roller to provide a seal.

Application

Apply an even ribbed coat of adhesive to both surfaces, using a serrated trowel or spreader. For correct coverage, use the spreader to such an angle as to give good rib formation after drying. If a white bloom appears on the surface, raise the temperature and/or dry the atmosphere.

Drying of Adhesive

Drying time depends on film thickness, surface porosity, temperature and humidity.

Touch-dry times	Porous substrates	15 . 20 minutes
	Non-porous substrates	25 . 35 minutes
Assembly time	45 minutes maximum after application	

Assembly

GP 2000 Contact Adhesive bonds as soon as the two surfaces touch. It is hence essential to avoid contact before the parts are in alignment. Bring the two coated and touch-dry surfaces into contact and press together over the whole bond area. Hand pressure is normally sufficient, but a press or a hand roller may be used. Sustained pressure is unnecessary. Bringing the surfaces together before they are touch-dry will result in solvent being trapped, adversely affecting the final bond, and possibly giving rise to blistering problems.

The initial bond strength allows immediate handling, but maximum bond strength is reached after approximately 24-48 hours.

Special Methods

Reactivation By Heat	In some applications, it is convenient to precoat components some time before assembly is required. The dried adhesive may be reactivated by heating to a temperature not less than about 80°C. The heated surfaces are then bonded in the normal way. Tests must be made to ensure the substrates are not harmed by this process.
Reactivation by Solvent	Precoated areas may also be reactivated by the brush application of GP 2000 Contact Cleaner to only one surface. The bond should not be made until the activated film has reached the touch-dry condition.
Addition of Accelerator (DF or DFE) for Increased Resistance to Temperature	For temperature resistance above 60°C, stir into the adhesive 5% by volume of GP 2000 Contact Accelerator (DF or DFE) and use the adhesive in the normal way. The mixture has a pot life of about 4 hours.

PRODUCT CHARACTERISTICS

Colour and Form	Off-white to amber moderately viscous liquid
Constitution	A blend of polychloroprene rubber and synthetic resins, none of which are classified as dangerous, as the term is defined by the Classification, Packaging and Labelling of Dangerous Substances Regulations, 1984, in a mixture of toluene, ethyl acetate, and C ₆ and C ₇ aliphatic and alicyclic hydrocarbons, containing less than 3% n-hexane in total. The solvents are subject to Occupational Exposure Standards, as listed in H & SE Guidance Note EH40.
Packaging	In 25 litre drums; in 5 litre screw cap or lever-lid cans, as required; in cartons containing twelve 1 litre tins; and in cartons containing twelve 500 ml tins.
Storage	Store in accordance with the requirements of the Petroleum Regulations. When stored in original, sealed containers, in a dry place, within the temperature range of 5° - 30°C, the usable life is at least one year.
Coverage	Approximately 5.5 m ² /litre on a single, smooth, non-porous surface; increased surface porosity or non-uniformity will reduce this coverage. Calculation of the coverage for the bond area should take account of the fact that two surfaces are involved.
Performance	Good bond strength is maintained up to 60°C. Improved resistance to temperatures up to 120°C can be obtained by using GP 2000 Contact Accelerator (DF or DFE).

PRECAUTIONS IN USE

GP 2000 Contact Adhesive is safe in use and without risk to health provided due attention is paid to the following points.

Flammability

GP 2000 Contact Adhesive is classed as a %PETROLEUM MIXTURE+ and as a %HIGHLY FLAMMABLE LIQUID+. Do not smoke during its use, and do not use near sources of ignition such as radiant heaters, pilot lights or sparks. Electrical installations in the vicinity must also be such as to be free from the risk of spark generation, and in general, industrial usage of the adhesive must be in accordance with the requirements of the Highly Flammable Liquids and Liquefied Petroleum Gases Regulations, 1972.

Fire Precautions

Have available a quantity of dry sand, for dumping on to a fire, and also an extinguisher of the dry powder, vaporising liquid, or foam type.

Health

GP 2000 Contact Adhesive is classified as %Harmful+, under the Classification Packaging and Labelling of Dangerous Substances Regulations, 1984, because of the presence of an essential proportion of toluene in its solvent content. Inhalation of the vapour in sufficient quantity can result firstly in apparent intoxication, followed possibly by drowsiness, dizziness and nausea, leading eventually to unconsciousness. Possible effects of long-term excessive exposure are the risks of anaemia and damage to liver and kidneys.

Ingestion of the adhesive may cause nausea and vomiting, leading to the risk of inhalation of vomit and a resulting pneumonia-like illness.

As is advisable for all solvent-containing materials, avoid contact of the adhesive with the skin. Use resin-removing cream, NOT solvent, to remove any contamination of the skin that might occur.

Avoid contact of the material with the eyes.

Ventilation

Effective removal of solvent vapour from the working environment is essential, partly to ensure complete freedom from the risk of explosion, but also to prevent the risk of vapour inhalation by those in the vicinity. Although natural ventilation is sometimes sufficient and acceptable, it will otherwise be necessary to provide a safe form of extraction ventilation, designed to remove as much of the solvent vapour as possible, from as close to the work as possible, and aiming to reduce aerial contaminants so that they are at worst below the limit for the solvents published in Guidance Note EH40.

First Aid Measures

In case of inhalation of vapour resulting in discomfort or other cause for concern, provide the patient with fresh air at once, and seek medical advice.

In case of contact of the adhesive with the eyes, irrigate continuously with water for 15 minutes, and meanwhile seek medical advice.

In case of swallowing of the adhesive, DO NOT induce vomiting, and seek medical advice.

SPILLAGE

Cover spilt adhesive with sand or earth, and then scrape up with sparkproof tools. Transfer the mixture to a sealable metal container. Dispose of as in the following paragraph.

DISPOSAL

GP 2000 Contact Adhesive comes within the scope of the Control of Pollution (Special Waste) Regulations, 1980. Emptied containers, and those containing scrap or spilt adhesive, should be re-sealed or re-lidded so that the vapour is confined to the container. They should be stored as for full containers, and they should be transported safely, and in accordance with the requirements of the Regulations, to the site of a properly built incinerator. Containers should first be opened, and then immediately incinerated, paying due regard to the presence of the flammable solvents in the waste.