



# EVO-STIK Impact Solvent Free

## WATER-BASED CONTACT ADHESIVE

Date: 20 July 2018

Fact Sheet No.: TDS00027

### YOUR SMART ADVANTAGES

- High strength and bonds instantly on contact
- Safe clean and easy to use
- No need for clamping or support whilst the adhesive sets

### USES

EVO-STIK Impact Solvent Free is a non-flammable polychloroprene rubber latex based adhesive which changes from white to translucent when dry. It is economical in use and gives excellent bond strength.

It is ideal for bonding most types of materials: wood, MDF, laminate, metal, rigid PVC, cork, leather, rubber, polystyrene, glass, mirror, stone and ceramics. It is also very suitable for bonding smooth porous surfaces of concrete or plaster as well as canvas and expanded polystyrene. Non-porous materials such as metals and painted surfaces may be bonded, provided that the adhesive films are allowed to dry completely before the bond is made.

### PRODUCT CHARACTERISTICS

Colour	White (translucent when dry).
Form	Mobile aqueous emulsion
Specific Gravity	1.12 approx.
Composition	Polychloroprene latex/resin blend
Solids Content	Approx. 55%
Solvent	Water

Product Code	30812362 250ml Tins x 6
Storage/Shelf Life	Store for up to 12 months from date of manufacture when stored in original, unopened packaging under dry conditions within the temperature range of +5°C to +30°C.

### TYPICAL PERFORMANCE DATA (Approx.)

Coverage	12m <sup>2</sup> per litre single coat
	6m <sup>2</sup> per litre single coat 2 surfaces
	3m <sup>2</sup> per 250ml – 1 surface
	1.5m <sup>2</sup> per 250ml – 2 surfaces

### DIRECTIONS FOR USE

IMPORTANT: Before using EVO-STIK Impact Solvent Free refer to the relevant Health & Safety Data Sheet, available at [www.bostik.co.uk](http://www.bostik.co.uk).

### PREPARATION

1. Substrates to be bonded must be perfectly clean dry and free from dust, paint, grease and loose material.
2. Smooth or polished surfaces must first be roughened with fine abrasive.
3. Rubber and similar materials must be abraded well and then the bonding area vigorously wiped with a cloth damped with EVO-STIK Adhesive Cleaner (a solvent based cleaner). Without such treatment a poor bond will result.
4. If degreasing is necessary, use EVO-STIK Adhesive Cleaner.

### APPLICATION

5. To prevent splashes, place the tin on a flat surface and lever the lid off gently with a screwdriver.
6. EVO-STIK Impact Solvent Free is suitable for application by brush, paint pad, paint roller or sponge.

7. The use of a notched or serrated spreader is not recommended as too much adhesive will be applied and this will take very much longer to dry.
8. Thoroughly stir the contents of the container before use.
9. Application by paint pad or by roller is very quick and applies a smooth thin layer of adhesive which will dry reasonably quickly.
10. Both surfaces to be bonded should be coated with an even coat of adhesive and allowed to become touch dry.
11. Porous surfaces such as plaster may require a second coat. The milky white opaque adhesive becomes nearly clear when dry.
12. The adhesive dries by evaporation of water into the atmosphere and on porous substrates also by absorption of the water into the pores.
13. The drying time is very dependent on substrate, coating weight, temperature and humidity. Under normal conditions the film dries in 30 minutes at 20°C.
14. The process can be accelerated by warming e.g. by radiant heat or by passage of a current of warm air over the surface.

#### **BONDING**

15. It is important to leave the adhesive until it changes colour before bonding.
16. Align the surfaces carefully when in place; press together gently, preferably, within 2 hours of drying.
17. Apply as much pressure as possible by hand roller, static press or nip roller without causing damage. Sustained pressure is unnecessary.

#### **CLEANING**

18. Use a moist cloth to remove uncured product.
19. Cured product requires mechanical removal.

#### **PRECAUTIONS IN USE**

For any application not covered please contact Technical Services on +44 (0)1785 272625 or visit [www.bostik.co.uk](http://www.bostik.co.uk) for advice.

Recommendations and suggestions are for guidance only, since conditions of use are completely beyond our control.

For health and safety instruction, first aid measures and spillage and disposal instructions, see separate Health and Safety Data Sheet for EVO-STIK Impact Solvent Free, available at [www.bostik.co.uk](http://www.bostik.co.uk).

BOSTIK HOTLINE

Smart help +44 (0) 1785 272625



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