

EVO-STIK TX 528 THIXOTROPIC CONTACT ADHESIVE THIXOTROPIC SOLVENTED CONTACT ADHESIVE

EVO-STIK TX 528 is a general purpose, thixotropic, non-drip contact adhesive, which is clean, and easy to apply, being non-drip it is ideal for use on vertical as well as horizontal surfaces. The resultant bonds give excellent bond strength and good temperature resistance.

RECOMMENDED USE

- EVO-STIK TX 528 is a general purpose, contact adhesive particularly suitable for bonding decorative plastic sheets and other rigid plastics such as PVC and ABS to wood, metal and wood composite boards.
- TX 528 may also be used to bond cane fibre boards and acoustic tiles to suspended or vertical surfaces such as dry cement/sand renderings. Most types of plastic nosings and coverings may also be bonded.

LIMITATIONS

- EVO-STIK TX 528 is intended for interior use, but it has been used successfully in exterior locations protected from the weather, such as for laminates bonded to shop fronts.
- It is unsuitable for use with sensitive surfaces such as expanded polystyrene, cellulose painted surfaces, bituminous surfaces.
- EVO-STIK TX 528 should not be used with vinyl or plasticised PVC as it will soften in time.
- It will not bond well to polyolefins such as polyethylene, polypropylene or teflon.

BONDING INSTRUCTIONS

SURFACE PREPARATION

- EVO-STIK TX 528 is not a gap-filling adhesive; surfaces must be flat and close fitting.
- Substrates to be bonded should be perfectly clean dry and free from dust and grease. If degreasing is necessary, a solvent such as EVO-STIK ADHESIVE CLEANER {Code **097056** 250ML x 12 or **094604** 5L x 1} Always check the effects of the solvent on sensitive substrates such as plastics and

rubber. Do not use petrol, diesel or white spirits as they leave an oily surface.

- Smooth or polished surfaces should first be roughened with fine abrasive.
- Excessively porous surfaces soak up the adhesive and lead to the risk of poor bonding. In such cases, prime with a mixture of equal volumes of EVO-STIK TX 528 and EVO-STIK ADHESIVE CLEANER.

APPLICATION

- EVO-STIK TX 528 can be applied by trowel or serrated spreader.
- Apply an even ribbed coat of adhesive to both surfaces using a serrated trowel or spreader. For correct coverage use the spreader at such an angle as to give good rib formation after drying. Work in warm, dry and well ventilated conditions. Cold and or high humidity will lead to poor drying and hence a poor bond.
- Allow the adhesive to become just touch dry. The drying time will depend upon film thickness, surface porosity, temperature, humidity and ventilation. In good conditions the approximate drying times are:

Porous substrate	15 - 20 minutes
Non-porous substrate	25 - 35 minutes

- For best results bring the two dry, coated surfaces into contact within 10 minutes of the adhesive films becoming 'touch dry' and press together over the entire bond area. Apply as much pressure as possible by hand. Sustained pressure is unnecessary.
- Bringing the surfaces together before the surfaces are touch dry will result in solvent being trapped, adversely affecting the final

Date: 10 July 2005

Information Sheet No.: ZE0188

bond, and possibly giving rise to blistering problems.

- Bonding too late will leave large areas unbonded which will later give rise to blisters, due to differential movement.
- TX 528 is a contact adhesive and the bond is formed as soon as the two surfaces touch. It is hence essential with large areas to avoid contact before the parts are in alignment. The adhesive does allow for slight adjustment in the positioning of small areas of the materials being bonded provided **no pressure** is applied that would induce appreciable contact between the surfaces.
- The initial bond strength allows for immediate handling of the assembly, but maximum bond strength is reached after approx. 24 - 48 hours at normal temperatures.

CLEANING

- ◆ Wet adhesive can be removed by allowing to just dry then peeling or scraping off.
- ◆ For dry adhesive use as little EVO-STIK ADHESIVE CLEANER as possible. Always test the effects of solvent on the surface prior to proceeding. Always work in very well ventilated conditions.

COVERAGE 4-6 m²/Litre on a single surface

PACKAGING

Code:

657502	1 Litre x 12
657601	2.5 Litre x 1
657700	5 Litre x 1

HEALTH AND SAFETY: Available separately in files named as the packaging code above.

SHELF LIFE: 12 months if stored as directed below

STORAGE & TRANSPORTATION: Store in accordance with the requirements of the petroleum regulations in a dry flameproof area between 5 and 25°C.

TYPICAL CHARACTERISTICS

Physical Form:	Thixotropic Gel
Colour:	Off white to amber
Chemical Type:	Polychloroprene rubber/synthetic resin blend
Solvent:	Ethyl acetate/hydrocarbon blend
Solids Content:	Approx. 22%
Specific Gravity:	Approx. 0.89
Flammability:	Highly flammable
Temperature:	Resists up to 65°C, less in humid conditions.
UN Class:	3; Number:1133; Packing group: III

Sales & Technical contacts at Bostik

	Telephone	Facsimile	Email addresses
Sales	01785 272700	01785 241818	customer.service@bostik.com
Technical advice	01785 272764	01785 272867	technical.service@bostik.com
Technical Data & COSHH (MSDS) sheets	01785 272827	01785 212962	gatehouse@bostik.com

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