

Technical Data Sheet

16/11/2018

Issue 1

Tuskbond HH550 500ml

Contents

1. Supplier
2. Product Description
3. Technical Specifications
4. Storage
5. Directions for Use
6. Limitations
7. Disclaimer

Supplier

Sangler Ltd.
 Shelley Close
 Lowmoor Business Park
 Kirkby in Ashfield
 NG17 7JZ
 T: 01623 722661
 F: 01623 885971

Features

- Uniform spray
- Fast easy application
- Fast drying
- High solids
- High temperature resistance
- Low odour
- Long open time
- Bonds a wide variety of substrates

Product Description

Tuskbond HH550 will bond a wide variety of substrates, including wood, metals, rubber, fabric, most plastics, cardboard, polythene and concrete, as well as decorative laminates. It is ideal for permanent bonds that require good initial bond strength. It provides good temperature resistance and if protected from contamination has an open time of several hours. Always test a small sample of the materials first to ensure the suitability of the product for the application. For instance, some vinyls contain large amounts of plasticiser which, over time, can migrate and soften the bond. When in doubt, test first.

Do not use on flexible PVC or expanded polystyrene.

Technical Specifications

Property	Tuskbond HH550
Solvent	Dichloromethane
Propellant	Hydrocarbon
Solids content (approx.)	28%
Spray pattern	Web
Colour	Clear
Coverage (500ml aerosol)	~2.5m ² (Dry coat weight of 25gm ⁻²)
Heat resistance	105°C

Storage

Protect from extremes of temperature in a controlled environment between 15 and 35°C, and away from direct sunlight. **Do not stand on a cold concrete floor.** Low temperatures can result in irreparable separation of the adhesive. Stored under the correct conditions, in original, unopened containers, the product will have a shelf life of 12 months.

DO NOT ALLOW THE PRODUCT TO FREEZE

Technical Data Sheet

16/11/2018

Issue 1

Directions for Use

USE IN A WELL VENTILATED AREA

1. Surfaces should be clean, dry and free from grease, oil and dust. Excessive dust will impair performance.
2. Substrates should be conditioned before assembly. This is particularly important with laminates. Condition for 48 hours at 20°C with a relative humidity of 45-55%. Air should be able to circulate freely around the components.
3. Hold the aerosol at approximately 70° to the surface and apply a uniform coat of adhesive, to both substrates, ensuring 80-100% coverage. Spray one surface vertically the other horizontally. Pay particular attention to the edges.
4. It is important to remember that **Tuskbond HH550** is a contact adhesive and forms a bond by sticking to itself, so there must be sufficient adhesive **on both surfaces** for this to happen.
5. Porous substrates may require two applications.
6. Drying takes approximately 1 to 2 minutes depending on substrates, ambient temperature and humidity. Over spraying and pooling of the adhesive will increase the drying time and may cause the adhesive to show through the laminate.
7. Allow the adhesive to tack up and protect from contamination whilst this happens. The adhesive is ready to bond when it feels dry to the touch and does not transfer.
8. Once the two surfaces have been brought together, an aggressive bond will be made. Spacers can be used to ensure the surfaces do not come into contact prematurely.
9. Apply a uniform pressure over the work piece, starting in the middle and working outwards. Use blocks or a 3 inch roller and ensure the whole piece has been worked to ensure adequate contact of the adhesive.
10. Pay particular attention to the edges. Please note that testing at this point by lifting the edge will weaken the bond. A nip roller will give the best results.
11. Once assembled, the piece can be machined or trimmed as required.
12. Excess adhesive can be removed with a suitable solvent cleaner such as white spirit.
13. To prevent the spray nozzle from blocking, at the end of each period of use, turn the can upside down and press nozzle until spray is clear of adhesive.

Limitations

Tuskbond HH550 dries within two minutes under normal conditions, but this will vary under different temperatures and humidities. High humidity and low temperatures will slow the drying time and if the temperature gets very low, can produce bloom. Bloom is moisture which forms on the glue line caused by solvent evaporation lowering the air temperature above it.

Disclaimer

All the information in the Data Sheet is based on practical experience and is published in good faith. However, because we have no control over the manner or conditions in which our products are used, or over work undertaken or end product manufactured by the purchaser, we cannot accept liability for results. Responsibility for ascertaining the suitability of products for his purposes rests with the purchaser. All conditions, representations, statements, warranties or guarantees whatsoever, whether express, implied or statutory, in respect of any goods manufactured, sold or supplied by us are hereby expressly excluded and we accept no liability in respect of any claim for damage or consequential loss caused to any property arising directly or indirectly out of the use of our products or goods.