



EVO-STIK 613

SOLVENT BASED ADHESIVE

KEY FEATURES

- High grab
- High shear strength
- Good temperature resistance

DESCRIPTION

Evo-Stik 613 is a Toluene free solvented contact adhesive exhibiting high initial grab. It can be easily applied by brush or spreader; the resultant bonds give excellent bond strength, high shear strength and good temperature resistance.

RECOMMENDED USE

Evo-Stik 613 is a general purpose, contact adhesive particularly suitable for bonding plastic laminates and other rigid plastics (excluding polyethylene & polypropylene) on particleboard, MDF, woods, metals and all types of board with the exception of bituminous materials.

Evo-Stik 613 may also be used to bond boards of insulating 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 plastic nosings and covings may also be bonded. **Evo-Stik 613** is intended for interior use. It is not suitable for use with expanded polystyrene foam and is also unsuitable for use where only point contact is obtainable between the surfaces to be bonded.

IMPORTANT

Before embarking on any work involving **Evo-Stik 613** the safety data sheet should be carefully studied by those carrying out the work.

METHOD OF USE

SURFACE PREPARATION

- Substrates to be bonded should be perfectly clean dry and free from dust and grease.
- Smooth or polished surfaces should first be roughened with fine abrasive.
- If degreasing is necessary, a detergent/water treatment should first be considered. If this is inappropriate a suitable solvent e.g. **Bostik Cleaner 5** may be used. It is advisable to check the effects of degreasing solvents on plastics, rubber materials and painted surfaces before carrying out the operation. All traces of cleaning solvents must be allowed to evaporate completely before application of the adhesive.

APPLICATION

- **Evo-Stik 613** can be applied by brush 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. If a white "bloom" appears on the surface, raise the temperature and/or dry the atmosphere.

ADDITION OF ACCELERATOR FOR INCREASED HEAT RESISTANCE

- For temperature resistance above 60°C stir into the adhesive an addition of 5% **Accelerator F** (by weight) then use in the normal way.
- The mixture has a pot life of approx. 4 hours.

DRYING

- Drying time depends on film thickness, surface porosity, temperature and humidity.
- **Minimum drying time 20 minutes** - this is to ensure through drying of the adhesive film, the surface may feel touch dry prior to this but bonding too early can cause problems of solvent entrapment, resulting in poor bonding.

NORMAL BONDING METHOD

- Bring the two dry, coated surfaces into contact within 60 minutes of application and press together over the entire bond area.
- To obtain optimum initial bond strength, surfaces should be bonded as soon as possible after recommended drying time.
- Apply as much pressure as possible by hand roller, static press or nip roller without causing damage. Sustained pressure is not necessary.
- Bringing the surfaces together before the surfaces 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 24 - 48 hours.

SPECIAL BONDING METHODS

In some applications it is convenient to pre-coat components some time before assembly is required. **Evo-Stik 613** may be adapted to this type of use by means of reactivation processes. The adhesive film must be kept free from contamination.

Reactivation by heat

The dried adhesive film may be reactivated by heating to a temperature of 85 - 95°C. A battery of 4 x 250W infrared lamps placed 200-250mm above the coated surface will provide adequate reactivation in 30 - 90 seconds. The actual time being dependent on the nature and/or colour of the substrate.

Reactivation by solvent

Pre-coated areas may also be reactivated by a brush coat of **Bostik Cleaner 3**, normally to only one of the surfaces. The bond should not be made until the activated film has reached a touch dry condition.

GENERAL PRECAUTIONS

- Do not add anything to the adhesive to modify its properties.
- After each use, close the container tightly in order to avoid solvent evaporation.

TYPICAL CHARACTERISTICS	
Physical Form	Moderately viscous liquid
Colour	Amber
Chemical Type	Polychloroprene rubber/ synthetic resin blend
Solvent	Ester/Ketone/ hydrocarbon blend
Flammability	Highly Flammable
Viscosity Brookfield RVT 10rpm at 25°C [mPa.s]	Approx. 3750
Total Solids Content [%]	Approx. 23
Relative Density	Approx. 0.84
Cleaner	Bostik Cleaner 3

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BSI STANDARDS



PACKAGING

For current pack sizes please contact the Customer Service Department.

STORAGE

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

SHELF LIFE

At least 12 months closed in original container stored under the above conditions

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SMART HELP

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