

## PRODUCT DATA

Date: September 2011

Information Sheet No.: T8000-28

# EVO-STIK 8000

## SOLVENTED CONTACT ADHESIVE

**EVO-STIK 8000** is a good quality general purpose neoprene adhesive, it can be used as either a single or two part adhesive depending on the materials to be bonded and the bond strengths required.

### RECOMMENDED USE

**EVO-STIK 8000** was developed primarily for use with **ACCELERATOR F** to bond a range of rubbers and rubber coated fabrics (e.g. Neoprene, Hypalon, Natural Rubber etc.) in inflatable constructions such as life rafts, dinghies, high speed inflatable boats etc. It may also be used in the manufacture of dry and wet suits for the bonding of rubber or nylon coated fabrics to themselves.

When used with **ACCELERATOR F**, **EVO-STIK 8000** meets the stringent requirements of the Ministry of Defence Specifications.

**EVO-STIK 8000** may also be used as a single component adhesive in many general purpose applications for bonding materials such as Formica, Melamine and PVC laminates to wood metal etc. It may also be used to bond PVC to metal, wood etc., but it must be used with accelerator. It is not recommended for bonding plasticised PVC or expanded polystyrene.

### BONDING INSTRUCTIONS

#### SURFACE PREPARATION

Substrates to be bonded should be perfectly clean dry and free from dust, grease and other contaminants.

- INFLATABLES
  - Neoprene, Natural Rubber and Hypalon coated materials should be solvent wiped, lightly buffed and solvent wiped again to attain maximum results
- WET & DRY SUITS
  - For best results all surfaces should be cleaned with a solvent wipe using e.g. **EVO-STIK CLEANER 1**.

#### APPLICATION

- MIXING RATIO
  - **EVO-STIK 8000** 100 parts by weight
  - **ACCELERATOR F** 4 parts by weight

Materials should be mixed thoroughly for approx. 5 minutes

- DRY / WET SUITS
  - Apply one coat of adhesive to each surface and allow to dry for 10 - 20 minutes to ensure complete solvent evaporation.

See final page for disclaimer.

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- Apply a second coat to each surface and allow to dry for 10 - 20 minutes until solvent has evaporated but adhesive remains tacky
- Bring the two surfaces together and apply pressure by hand roller or pinching.
- Full cure can take up to 7 days but good handling strength will be obtained immediately.

➤ INFLATABLES

- A minimum of two coats should be applied to each surface.

➤ GENERAL SINGLE COMPONENT

- Apply an even coat of adhesive to both surfaces to be bonded, allow to dry for 10 - 20 minutes to allow the solvent to evaporate but the adhesive remains tacky
- Bring both surfaces together and consolidate the bond by roller or press.

## TYPICAL CHARACTERISTICS

	<b>EVO-STIK 8000</b>	<b>ACCELERATOR F</b>
Physical Form:	Liquid	Liquid
Colour:	Off white	Pale brown
Chemical Type:	Polychloroprene rubber, synthetic resin blend	Polyisocyanate
Solvent:	Mix of hydrocarbons & Ketone	Ethyl Acetate
Viscosity (Brookfield RVT, 10rpm at 20°C):	Approx. 2500 mPas (25 Poise)	
Solids Content:	Approx. 22%	Approx. 27%
Specific Gravity:	Approx. 0.87	Approx. 0.98
Flammability:	Highly flammable	Highly flammable
Open Time:	10 - 30 minutes subject to substrates, ambient & substrate conditions & length of time after addition of accelerator	
Pot Life (2 component mix):	Approx. 4 hours	

## 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

**EVO-STIK 8000** - 12 months stored in its original container under the above conditions.

**ACCELERATOR F** - 6 months stored in its original container under the above conditions.

## MATERIAL SAFETY DATA

For further information refer to the relevant Health and Safety Data Sheet.

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