

## PRODUCT DATA

Date: July 2013

Information Sheet No.: TDS01480-01

# EVO-STIK 5007/2

## SOLVENTED ADHESIVE

**EVO-STIK 5007/2** is a very high wet tack; fast drying; non-staining and virtually clear adhesive based on a blend of nitrile synthetic rubber and resins. It exhibits excellent chemical resistance is resistant to plasticiser migration and has excellent heat resistance; up to 70°C.

### RECOMMENDED USE

**EVO-STIK 5007/2** was specifically developed for bonding cellular plastics such as cellular PVC, polyether, polyester and polyurethane foams to themselves or to other substrates. In addition **5007/2** gives exceptionally high quality bonds with materials such as rigid & flexible PVC, wood, metal and cloth.

**EVO-STIK 5007/2** is not suitable for use on expanded polystyrene.

### BONDING INSTRUCTIONS

#### 1. 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. 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.

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#### 3. APPLICATION

- EVO-STIK 5007/2** is suitable for application by brushing or roller coating techniques.
- If spray application is required, **EVO-STIK 5007/2** can be diluted with **EVO-STIK CLEANER 1** in the ratio 2 volumes of adhesive to 1 volume of cleaner.

### BONDING

- One way wet method** - Apply an even coat of adhesive to one of the surfaces to be bonded and assemble the components within 2 minutes. Light even pressure should be applied to the bond immediately after joining using hand pressure, roller or press, sustained pressure is not necessary.
- Two way dry method** - Apply an even coat of adhesive to both surfaces to be bonded. Allow films to become just dry to the touch; this normally takes about 7 minutes, but low temperatures and/or high levels of humidity retard drying. Assemble the parts using light even pressure by hand, roller or press, sustained pressure is not necessary.
- Reactivation method** - The adhesive films may be allowed to dry completely and can then be reactivated when required by moistening the films with **EVO-STIK CLEANER 1**, applied by brush. Assembly is then carried out as described above for the two-way method.
- NB** – In conditions of high ambient humidity, particularly at low temperatures, some condensation of moisture may occur on wet adhesive films giving a white “bloom” on the surface. Care should be taken to avoid this occurrence since bond performance will be impaired.

## TYPICAL CHARACTERISTICS

Physical Form:	Liquid
Colour:	Off white & translucent
Chemical Type:	Nitrile
Solvents:	A blend of aliphatic Ketones
Viscosity (Brookfield RVT 10rpm at 25°C):	Approx. 3800 mPas
Solids Content:	Approx. 25%
Specific Gravity:	Approx. 0.85
Flammability:	Highly Flammable
Cleaner / Thinner:	Evo-Stik Cleaner 1

## PACKAGING

For current pack sizes please contact the Customer Service Department

## STORAGE

Store in a dry flameproof area between 5 and 25°C.

## SHELF LIFE

12 months from date of manufacture, under the above storage conditions.

## MATERIAL SAFETY DATA

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

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