

## EVO-STIK 528 CONTACT ADHESIVE

### A GENERAL PURPOSE POLYCHLOROPRENE ADHESIVE

Evo-Stik 528 is intended for use in interior situations, it may also be used in exterior situations where it can be protected from the weather (sun and rain), e.g. bonding laminates.

#### FEATURES

- ◆ Excellent final bond strength.
- ◆ High shear strength.
- ◆ Good temperature resistance.
- ◆ High initial grab.
- ◆ Easy application by serrated spreader.

#### TYPICAL USES

- ◆ Evo-Stik 528 is particularly suitable for bonding decorative laminated plastic sheets and rigid plastic sheets of PVC or ABS to wood, wood composite boards and to metals.
- ◆ Evo-Stik 528 may also be used to bond insulating fibreboards and acoustic tiles to suspended or vertical surfaces such as flat-surfaced ceilings or walls.
- ◆ Most types of rigid plastic nosings and coverings may also be bonded.

#### LIMITATIONS

- ◆ Evo-Stik 528 is unsuitable for use with expanded polystyrene, due to solvent attack.
- ◆ Do not use on or near bituminous substrates.
- ◆ It will not bond polyolefins such as polyethylene and polypropylene.
- ◆ It is also unsuitable for use where only point contact exists between the surfaces to be bonded.

#### METHOD OF USE

- ◆ Before using this product refer to the relevant Health & Safety Data Sheet.

#### SURFACE PREPARATION

- ◆ All surfaces to be bonded should be smooth, 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 such as Evo-Stik Adhesive Cleaner 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 before application of the adhesive.

#### APPLICATION

- ◆ Apply an even ribbed coating of adhesive to both surfaces to be bonded, using a trowel or spreader with a serrated edge and taking care that its serrations are neither worn nor filled with dried adhesive.
- ◆ To ensure the correct coverage is obtained use the spreader at such an angle as to give good rib formation after drying.
- ◆ Keep the surfaces separated until both adhesive films are touch dry.
- ◆ When working at high relative humidity, condensation of moisture on the adhesive film may take place, recognisable by the appearance of a white 'bloom' on the surface. This can be detrimental and work should not continue until the conditions have improved by raising the temperature and/or drying the atmosphere.

## DRYING TIME

- ◆ This depends on such variables as spreading thickness, surface porosity, and ambient temperature and humidity.
- ◆ Typical touch dry times are 15-20 minutes for porous substrates and 25-35 minutes for non-porous substrates.
- ◆ Normally assembly should not be delayed for more than 45 minutes after application.

## ASSEMBLY

- ◆ Bring the two coated and touch dry surfaces into contact and press together over the whole bond area.
- ◆ Hand pressure is normally sufficient but a suitable press or a rubber hand roller may often be used with advantage.
- ◆ Sustained pressure is unnecessary.

## PLEASE NOTE:

- ◆ Bringing the surfaces together before they are touch dry will result in solvent being trapped, this will adversely affect the final bond and may give rise to blistering problems,

particularly if the adhesive has not been evenly spread.

- ◆ Evo-Stik 528 is a contact adhesive and the bond is formed as soon as the two surfaces touch. It is therefore essential to avoid contact before the parts are in alignment, such as by the insertion of pins along one edge of one surface, against which the other surface can be located.
- ◆ The initial bond strength allows immediate handling of the assembly but maximum bond strength is reached after approximately 24-48 hours at normal temperatures.

## COVERAGE

- ◆ Up to 5.5m<sup>2</sup>/litre on a single smooth surface.
- ◆ Increased porosity or non-uniformity will reduce this coverage.
- ◆ Calculation of the coverage for the completed bond area should take account of the fact that adhesive has to be applied to both surfaces.

Date: 06 March 2005

Information Sheet No.: ZE0090

- SHELF LIFE:** Up to 12 months from the date of manufacture when stored as shown below:
- STORAGE:** Store under dry conditions between 5°C and 25°C, and in accordance with the requirements of the petroleum Regulations.

PACKAGING	Code:		
	805200	500ml	x24
805507	1 Litre	x12	
805705	2.5 Litre	x1	
805910	5 Litre	x1	

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

## TYPICAL ADHESIVE CHARACTERISTICS

- Physical Form: Moderately viscous liquid.  
Colour: Amber  
Odour: Sweet hydrocarbon  
Chemical Type: Blend of polychloroprene rubber and synthetic resins, in a mixture of petroleum solvents.  
Solids Content: 100%  
Specific Gravity: 0.89 approximately.  
Temperature resistance: -20 to +65°C.  
Water resistance: Good. After a few weeks the shear strength decreases gradually.

Sales & Technical contacts at Bostik	Telephone	Facsimile	Email addresses
Sales	01785 272700	01785 241818	<a href="mailto:customer.service@bostik.com">customer.service@bostik.com</a>
Technical advice	01785 272727	01785 272867	<a href="mailto:technical.service@bostik.com">technical.service@bostik.com</a>
Technical Data & COSHH (MSDS) sheets	01785 272827	01785 212962	<a href="mailto:gatehouse@bostik.com">gatehouse@bostik.com</a>

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