TUSKBOND

# XPR0

## Next Generation Contact Adhesive

## TECHNICAL DATA SHEET

• Uniform Spray • Non-chlorinated
• Limited Health Hazards • Uniform Spray
• Fast Easy Application • Fast Drying
• High Temperature Resistance • Long Open Time

## DESCRIPTION:

XPR0 is our next generation adhesive canister using innovative solvent technology meaning that the adhesive maintains a low hazard to human health due to its low toxicity, as well as providing minimal impact to the environment. XPR0 has all the advantages of Tuskbond ONE including high bond strength, high heat resistance and fast drying times but is completely non-chlorinated.

XPR0 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.

## TECHNICAL SPECIFICATION:

| PROPERTY | TUSKBOND XPR0 |
|---|---|
| Solvent | Acetal |
| Propellant | Hydrocarbon |
| Solids Content (approx) | 27% |
| Spray Pattern | Web |
| Colour | Clear or Red |
| Coverage (13kg Canister) | ~ 100m$^2$ |
| VOC | 575g/l |
| Heat Resistance (SAFT) | 99°C |
| Available Sizes | 14kg |

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## DIRECTIONS FOR USE:

- USE IN A WELL VENTILATED AREA
- Surfaces should be clean, dry and free from grease, oil and dust. Excessive dust will impair performance.
- Attach a suitable spray nozzle, such as a Unijet 6501, to the spray gun.
- Connect the hose to the canister and the spray gun to the hose and tighten the connections.
- Open the valve on the canister. The valve should remain open until the canister is used up. Use the locking nut on the gun after use. Turning off the valve will result in the adhesive drying in the hose and gun causing blockages.
- Hold the spray gun at 90° 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.
- When the adhesive is dry to the touch it is ready for the bond to be made.
- Porous substrates may require two applications
- 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.
- After spraying, remove the spray gun tip and rinse with Solvent Cleaner before it has cured.
- It is important to remember that XPR0 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.
- 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.
- Once the two surfaces have been brought together, and aggressive bond will be made. Spacers can be used to ensure the surfaces do not come into contact prematurely.
- Once the two surfaces are brought together, 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.
- 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.
- Once assembled, the piece can be machined or trimmed as required.
- Full cure will take 24 hours.

## STORAGE & SHELF LIFE:

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. If the adhesive sprays like a jet, the canister is too cold. warm to at least 10°C before using. DO NOT ALLOW THE PRODUCT TO FREEZE. Stored under the correct conditions, in original, unopened containers, the product will have a shelf life of 12 months.

## DISCLAIMER: