



Product code : X2428A

## EMFICOL X2428A

### DESCRIPTION

EMFICOL X2428A is a sprayable contact adhesive based on polychloroprene and synthetic resins in organic solvents.

### AREAS OF APPLICATION

EMFICOL X2428A is specially recommended for bonding laminated panels, streamlined rubber, wood, veneer, steel or aluminium to chipboard, plywood, fibre cement, mineral wools.

### TECHNICAL DATA

Colour	Orange-red
Viscosity	Brookfield LVT / spindle 1 / 12 rpm : 210 ± 20 mPa.s
Density at 20 °C	0.885 ± 0.005
Conventional solids content (EN 827)	15.3 ± 1.3 %
Open time at 20 °C	30 min
Temperature resistance of the assemblies	120 °C maximum on panels
Final setting at 20 °C	2 to 3 d
Cleaner	EMFINET 695

### ADVICE

See also material safety data sheet



### INSTRUCTIONS FOR USE

Substrates preparation :

The substrates to be assembled must be dry, dust free and not have any traces of grease or other contaminants that could adversely affect the adhesive performance.

Clean them if necessary with EMFINET 695 or EMFINET 688/1 for substrates sensible to ketones.

Check the compatibility of the solvent used with the substrates.

If necessary, rub down metal surfaces beforehand. Clean them after rubbing down.

Let dry after degreasing.

When using solvents, extinguish all sources of ignition and carefully follow the safety and handling instructions given by the manufacturer.

Adhesive and substrates have to be between 10 and 30 °C.

Application :

Apply evenly with a manual or an automatic spray gun (nozzle diameter : 1,5 to 2 mm; air pressure : 3 to 4 bar ; product pressure : 1 to 1.5 bar ) to both surfaces to be assembled.

Let the solvents evaporate (5 to 15 minutes depending on temperature, coating weight, spraying fineness and substrates).

Take care not to exceed open time ; otherwise, bonding will be defective.

Assemble precisely both parts (once the two substrates are assembled, they can't be repositioned or separated) in applying a uniform, short but high pressure across the entire surface.

With rigid materials, assembling has to be followed by an even and maximum pressure applied across the entire surface without irreversible deformation of substrates.

In damp and cold weather, ensure that materials and adhesive are at a correct temperature in order to prevent formation of dew as the solvents evaporate, which could result in defective bonding.

The high tack and heat resistance of EMFICOL X2428A allow assemblies under strain.

#### CONSUMPTION

100 to 150 g/m<sup>2</sup> to both surfaces; For very porous materials, a higher amount may be necessary.

#### STORAGE AND SHELF LIFE

12 months between 5 and 25 °C in closed original packaging.

#### PACKAGING

25 L metal cans.

Other packagings are possible on demand.

#### SAFETY

Highly flammable and irritant. Read material safety data sheet before use.

The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired.

Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application.

Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product.

Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions.

The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.