

## technical data sheet

# Anchor-Weld™ 2700 Series

## High Heat Resistant Spray Grade Contact Adhesive

### DESCRIPTION

Anchor-Weld™ 2700 / 2701 Contact Adhesive is a premium quality, high solids, sprayable contact adhesive, featuring high heat resistance, good sprayability, early green strength coupled with a good working tack life.

Anchor-Weld™ 2700 / 2701 gives strong adhesion to a wide range of materials including decorative plastic laminates (Formica®, Laminex®), timber and timber composites, many natural and synthetic rubbers, cementitious composites, ferrous and non ferrous metals and polyurethane foam.

Specifically designed for easy spraying without cob webbing, especially where automatic spraying equipment is employed, Anchor-Weld™ 2700 / 2701 is suitable for use with all current post forming equipment designed for use with contact cements. (heated bar or infra red bank heaters)

### FEATURES & BENEFITS

- n-hexane solvent safe
- Quick drying
- High heat resistance (100°C+)
- High early green strength

### TYPICAL PROPERTIES

Type	Polychloroprene rubber/resin
Colour	2700 - Red 2701 - Clear
Solids Content	Approx 18%
Viscosity	Approx. 310cps
Tack Up Time	10 – 15 mins @ 20°C
Open Time	Approx 30 mins @ 20°C
Water Resistance:	Good but not for continuous immersion
Solvent Resistance	Good to oil and petrol but will not withstand immersion.
Service Temperature Range:	-40°C to +100°C Where the bond is to be subjected to higher temperatures, and varying conditions, ie, stress, tension, etc these figures are quoted for guidance only. The suitability for your requirements should first be checked.
Combustibility of dry film:	Does not support combustion

### PACKAGING

Available in 20L and 200L containers

### COVERAGE:

Up to 10m<sup>2</sup> per litre on one surface

### APPLICATION

Ensure adequate Tests are conducted before using commercially.

Mix thoroughly before use.

### Surface Preparation:

Surfaces must be clean, dry and free from oil, dust and other foreign materials. Clean metals with Anchor-Weld™ 901 Cleaner/Thinner before applying adhesive as mill process oil is often found on rubber and plastic sheet and castings. Bare metals should be primed with Bostik 9252 Primer, to ensure maximum adhesion.

### Application Instructions

Anchor-Weld™ 2700 / 2701 is designed for application by spray using suction feed or pressure pot equipment. Apply an even coating of adhesive to **both surfaces**, covering **at least 80% on each surface**. Edges to be post-formed **MUST have 100% coverage**. Highly porous or absorbent surfaces may require two coats. Allow the first coat to tack off before applying the next. Allow the adhesive to dry for approximately 10-15 minutes (depending on atmospheric conditions) or until the surface can be touched without any adhesive transfer. Align surfaces then join by applying even and firm pressure, avoiding air entrapment. For large flat areas the use of nip or hand rollers are recommended. A minimum pressure of 280kPa (40psi) is required to give optimum bond strength. **Hand pressure is not sufficient!** Bonding of materials should occur within 20 minutes of adhesive application for optimum bond strength – if left longer, a light spray coat to both surfaces should be re-applied to reactivate the adhesive.

### LIMITATIONS

- Do not use on copper or highly reactive metals
- Do not use on expanded polystyrene foam
- Not suitable for polyethylene or polypropylene plastic
- Unsuitable for unbacked PVC, Leather or Vinyls. May cause staining on light coloured PVC/Vinyl stocks.
- Not recommended for automotive or marine trim applications.

### CLEAN-UP

Use Anchor-Weld™ 901 Cleaner/Thinner to clean up equipment and excessive adhesive. Anchor-Weld™ 901 Cleaner/Thinner is NOT recommended for removing adhesive from vinyl or lacquered surfaces.

**STORAGE:**

Store out of direct sunlight. Storage areas must be well ventilated and comply with Local, State and Federal regulations. For maximum shelf life store between 5-20°C

**SAFETY DIRECTIONS:**

Please refer to the Material Safety Data Sheet which is available on request. The solvents contained within this product are Highly Flammable.

**Anchor-Weld 2700/2701**

Item No	Stock Size
512761	Anchor-Weld 2700 Super Red 20 Litre
239143	Anchor-Weld 2700 Super Red 200 Litre
238953	Anchor-Weld 2701 Super Clear 20 Litre
512788	Anchor-Weld 2701 Super Clear 200 Litre

*The representations and recommendations regarding the products are based on tests which we believe to be reliable. However, no guarantee of their accuracy can be made because of the great range of field conditions and variations encountered in raw materials, manufacturing equipment and methods. Thus, the products are sold with a limited warranty only, and on the condition that purchasers will make their own tests to determine the suitability of the product for their particular purposes. Under no circumstances will Bostik Australia Pty Ltd be liable to anyone except for replacement of the products or refund of the purchase price.*

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