



Anglo Adhesives & Services Ltd.

INDUSTRIAL ADHESIVE MANUFACTURERS - CONTRACT FILLING AND PACKAGING

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TECHNICAL DATA SHEET ANGLO TU 1908

INTRODUCTION:

Anglo TU 1908 is a two part optically clear polyurethane adhesive, for bonding polycarbonates and acrylics to themselves and each other, and also to dissimilar substrates such as metals, wood, glass and other plastics.

When bonding metals – Primer FL10 should be used.

Non-flammable and solvent free, Anglo TU 1908 is safe for use in all environments, without risk of stress cracking, swelling or distortion of sensitive plastics. The adhesive can also be applied direct onto screen print ink and acrylic mirrors.

Unlike solvent based adhesives, Anglo TU 1908 will effectively bond materials with very large differences in coefficient of thermal expansion, and its performance on bonding materials such as ABS, PC, rigid PVC, SAN and many alloys has led to its use as a multi-purpose adhesive system by many thermoplastic sheet transformers.

FEATURES:

- Solvent free and odourless
- High peel and lap shear strength
- High impact resistance
- Glass clear
- No shrinkage or creep fatigue
- Effective through wide temperature range – sub zero -40°C to elevated +80°C
- Up to 300% elongation

TECHNICAL PRODUCT CHARACTERISTICS:

Colour	Part A Clear Part B Clear with light green to yellow tint Mixed Glass Clear
Constitution	Aliphatic isocyanate cured with polyol. Component A contains less than 2% dicyclohexylmethane 4,4 disocyanato.

Polymer Base
Polyurethane

Pot Life
15 mins. at 20°C

Coverage
2-3m² per kg

Specific Gravity
1.13gm cu. cm

Viscosity (mixed)
1800-2200 mPaS
@ 20°C

Solids
100%

Cleaner/Thinner
Cleaner 5
Isopropyl Alcohol

Shelf Life
12 months

Storage 5-30°C

Nearest Alt.
Extru-Fix for
Butt or Lapp
joints

Temp. Range
in service
-40°C - +80°C

Mix Ratio **By volume: Part A - 100; Part B - 91**
By weight: Part A - 100; Part B - 85

Coverage **Approx. 200 metres of 3mm bead per 1kg of adhesive (3mm bead = 10-15mm bonding width).**

Cure Time **Tack free - 3 hours at room temperature**
Handling - 30 minutes to 2 hours at room temperature
Full cure - 2 days at room temperature
2 hours at 65°C (after tack free)

Hardness Shore A 95

Tensile Strength 2500 N/cm²

Peel (180°C) 100 N/cm²

PACKAGING

Available in 2 x 500g* pre-weighed sets and 2 x 50g* pre-weighed sets.

* Approx. weights

STORAGE

Store in sealed containers in a clean dry place at a temperature between 5°C and 30°C.

SHELF LIFE

12 months (un-mixed) under the above storage conditions.

SURFACE PREPARATION

Polycarbonate surfaces should be wiped clean with a non-abrasive cloth, very lightly soaked with isopropyl alcohol and allowed to dry.

MIXING THE ADHESIVE

Please note that the pot life of the adhesive is approximately 15 minutes.

If mixing by hand always pour the entire contents of Part B container into Part A, scraping the inside of the can with a stirring stick. Add 5 drops of anti-foam compound, also supplied with the kit.

Immediately start gently stirring the can contents with the stirring stick, and continue for 2 to 3 minutes. Ensure that the sides of the can are scraped to guarantee that all material is thoroughly mixed.

Gentle mixing will prevent excessive Air inducement which may result from whipping or violent mixing of the two parts.

The adhesive can now be applied. However, if it must be totally bubble free, place it under hard vacuum until the majority of air bubbles have been dispersed, and then apply.

APPLICATION

The mixed Anglo TU 1908 should be applied to the polycarbonate and held in position under firm pressure.

Handling time of Anglo TU 1908 is 30 minutes to 2 hours at room temperature, tack-free time 3 hours at room temperature and curing time two days at room temperature.

Curing time can be accelerated by heating the bond by infra-red light or in an oven for 2 hours at 62°C.

Excessive adhesive extruding from a bond can be removed easily and without trace by cleaning with isopropyl alcohol for polycarbonate, or a normal degreasing agent. This must be carried out within 4 hours after the adhesive has been applied; after this time a chisel or similar tool will be necessary.

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