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TECHNICAL DATA SHEET

ANGLO 3353

HEAT ACTIVATABLE POLYURETHANE ADHESIVE FOR PVC BONDING AND REPAIRS

INTRODUCTION:

Anglo 3353 is a single component bonding and repair adhesive used extensively in the "Bouncy Castle" industry as it has excellent adhesion to the wide variety of materials used in the PVC inflatable and footwear industry.

FEATURES:

- Low activation temperatures.
- Can be used for wet or heat activated bonding.
- Excellent adhesion to plasticised PVC.
- Easy application.
- Ideal for mechanised production lines
- Can be cross-linked with accelerator 8101 to provide heat resistant bond.

APPLICATIONS:

Anglo 3353 is the market leading product for the bonding of "Bouncy Castle" Inflatables. It is used extensively in footwear manufacture for bonding soling materials such as leather, P.V.C., resin rubber, polyurethane and thermoplastic rubber to most commonly used upper materials. It has good water resistance, green strength and spotting tack, combined with a quick drying solvent blend for high speed production on modern tack systems. Anglo 3353 is particularly suitable for bonding P.V.C. due to its excellent resistance to plasticisers. It is the market leading product for the bonding of "Bouncy Castle" Inflatables.

METHOD OF USE:

IMPORTANT: Before embarking on any work involving Anglo 3353, the Material Safety Data Sheet should be carefully studied by those carrying out the work. The safe usage of Anglo Cleaner 1 & 5 are described in separate Material Safety Data Sheets.

Polymer Base:
Polyurethane

Cure Time:
Heat

Coverage:
5-7m² per Ltr

S.G. :
0.85Kg/Ltr

Viscosity:
3700 mPaS

Solids:
17%

**Cleaner or
Thinner:**
Cleaner 1 &
Cleaner 5

Shelf Life:
12 months

Storage:
5 - 30 C

SURFACE PREPERATION

Surfaces to be bonded should be 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 Anglo Cleaner 5 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.

Anglo 3353 may be applied by brush, roller-coater or automatic cementing machine. An even coat Adhesive should be applied to both surfaces and allow to dry for 10 to 15 minutes. The substrates should be reactivated at a temperature of not less than 80 Celsius and pressed at 80 psi for 10 to 15 seconds. Substrates may be pre-coated and stored for up to 21 days prior to use, provided there is a fresh coat of adhesive on the substrates prior to final bonding.

INSTRUCTIONS FOR USE

PREPARATION OF SUBSTRATES:

P.V.C. :	Rough lightly or wipe with a solvent
Leather :	Rough well, removing all pigment
Poromercis :	Rough lightly with a synthetic brush
Suede :	Rough lightly
Coated Fabrics :	Rough away synthetic coating or solvent wipe
Denim or Canvas :	Prime or apply two coats of cement

After the above preparation apply an even coat of Anglo 3353. Drying time 10 –15 minutes, 5 – 10 Minutes forced drying.

PREPARATION OF SUBSTRATES:

Normal P.V.C. :	Wipe with Anglo Cleaner 5
Leather :	Rough well, prime or apply two coats of cement
Resin Rubber :	“Lascol” ‘scrub’ or ‘Satreat’
Mictocellular :	“Lascol” ‘scrub’ or ‘Satreat’
Gristle Rubber :	Rough and/or ‘Satreat’ solvent wipe
Expanded PVC and Polyurethane Units:	Lightly rough away top skin or bonding area
Thermoplastic Rubber :	Brush apply ‘Satreat’
Crepe Rubber :	Brush ‘Satreat’ well into surface
Microcellular EVA:	Brush apply EVA primer 2801. Allow 15 minutes to dry
Nylon :	Satra nylon adhesive primer or phenol primer. Allow 30 minutes to dry

After the above preparation apply an even coat of Anglo 3353. Drying time 10 – 15 minutes.

HEAT REACTIVATION:

Heat activate the substrates at a temperature of not less than 80 degrees C. Time dwell on press 10 - 15 minutes. Pressure according to type of material used.

DILUTION:

The product Anglo 3353 may be diluted upto 50% for priming stitch sealing and strengthening ie. "Patch Bonding". Important dilution of the adhesive by any percentage reduces bond strength.

PRECAUTIONS:

Isolate from source of heat, naked flames and sparks. Used under conditions of efficient ventilation toxic limits should not normally be exceeded. Avoid excessive inhalation of vapour. Avoid contact with skin and eyes. Do not ingest.

PRODUCT CHARACTERISTICS:

COLOUR & FORM:	Clear viscous liquid
CONSTITUTION:	Polyurethane rubber solvent
PACKAGING:	205 litres drums and 250ml tins
STORAGE:	5 -30 degrees C

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