



# Anglo Adhesives & Services Ltd.

INDUSTRIAL ADHESIVE MANUFACTURERS - CONTRACT FILLING AND PACKAGING

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## SOLIBOND 4224

### DESCRIPTION

SOLIBOND 4224 is a non-flammable solvent based adhesive formulated for spray application, but may also be brush applied.

Suitable for bonding fabrics and flexible foams to themselves or to each other on to painted metal, chipboard, wood, hardboard, fibre glass etc.

Equally suitable for attachment of furnishing fabrics, including PVC, hessian, felt and upholstery padding.

### THE ADHESIVE IS ALSO AVAILABLE IN AEROSOL CANS

### SPECIFICATION

% Non Volatiles, w/w:	35 to 40
Viscosity, Brookfield RVT, Spindle 2, Speed 50, 20°C:	350 to 450 cps
Weight per Litre:	1.13 to 1.16 Kg
Flammability of Dry Film:	Fire Retardant
Open Joint Time:	
1 Way Application:	30 secs. to 3 mins. (Spray) 10 secs. to 30 mins. (Brush)
2 Way Application:	2 to 25 mins.

### CLEANER :

4224 THINNERS (See separate Data Sheet)

### APPLICATION

#### **By Spray**

For conventional spraying, air at the rate of 12 to 15 cu. Ft. per min. applied directly to a siphon or gravity feed gun is suitable. In low pressure sprays, via a pot containing adhesive, air at 3 to 4 cu. Ft. per min. is satisfactory. Materials to be bonded should be dry, clean, free from dust, loose materials, oil and grease. For applications not subject to stress and tension immediately after bonding or for laminating large areas, a one way stick is satisfactory. Bonds should be consolidated as soon as possible after spraying, e.g. 30 seconds to 3 minutes. The tack time will depend on the adherends and the quantity of adhesive applied. For application involving high stress during assembly or service a two way stick is necessary. Apply to both surfaces and allow to dry for about 2 minutes before completing the bond. A delay time of up to 20 to 25 minutes can be tolerated before bonding consolidation on materials that are not too porous.

## **BY BRUSH**

It is usually necessary to apply the adhesive to only one surface. Form bond whilst adhesive is wet and hold or clamp in position until firm (10 seconds to 30 minutes depending on quantity of adhesive and porosity of substrates).

## **SHELF LIFE:**

6 months when stored in unopened containers in dry conditions between 5 and 30°C.

## **PACKAGING**

Supplied in 500 ml aerosols and 5, 25 and 205 litre containers. Other sizes may be available on request.

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