



# Contact Adhesives

## CONTACT KLEBOSTIK 44

### Technical Data Sheet

Reviewed: 30.07.2018



#### DESCRIPTION

**CONTACT KLEBOSTIK 44** is an extra strong contact adhesive for professional use based on synthetic rubber, resins and solvents. It has excellent resistance to temperature, humidity, oils and acids.

#### ADVANTAGES

- Excellent bonding strength to most substrates
- Excellent initial grab
- Fast application
- Long open time
- Excellent resistance to ageing
- Excellent temperature resistance (-15°C - +70°C)
- Suitable for professional use
- Interior and exterior use

#### APPLICATIONS

- Bonds laminated plastics (Formica, Perstorp, Dupopal, Resopal, etc.), wood, veneer, plastic edging strips, chipboard, panels, rubber, leather, carton, hard and flexible polyurethane, felt, cork, fabrics to each other as well as to wooden and metallic surfaces, MDF, concrete etc.
- Ideal for applications in construction, shoe, woodworking and car industries.

#### INSTRUCTIONS FOR USE

1. The surfaces to be bonded must be dry and free from grease and dust.
2. The surfaces to be bonded must fit closely together.
3. Metal surfaces must be primed with spray gun solvent prior to application.
4. Stir the adhesive well.
5. Apply an even film of adhesive on both surfaces crosswise with a strong brush or spreader for coating large surfaces.
6. Porous materials must be coated twice; the second time after the first layer is dry.
7. When the coat of adhesive is just tacky (20 minutes) and does not longer transfer to your finger upon touching, the surfaces can be brought together.
8. Take care to position the materials accurately, because once the joint is made, they cannot be adjusted by sliding.

9. Apply pressure. For small surfaces firmly tap the surfaces with a rubber hammer. For larger surfaces roll with a pressure roll.
10. The use of clamps or press is suggested. The pressure must then be sufficiently high and evenly applied to the entire surface.

#### REMARKS

- Do not use at temperatures below +5°C. At low temperatures care must be taken that the temperature of the adhesive and of the surfaces to be bonded is higher than the ambient temperature. Cold materials have a strong tendency to attract the moisture present in the surrounding air. Moisture on the adhesive film may have a negative effect on the bond and will lead to unsatisfactory results.
- Bumps and gaps reduce the contact surface therefore will lead to unsatisfactory bonding results.
- Air bubbles can be avoided by rolling the material during fixing specially for large surfaces.

#### CLEANING

Clean all equipment and stains with nitro or spray gun solvent immediately after use.

#### CONSUMPTION

100-200 gr/m<sup>2</sup> (one side application)

#### TECHNICAL CHARACTERISTICS

**Base:** Polychloroprene rubber.

**Consistency:** Thixotropic liquid

**Colour:** Yellow / brown

**Smell:** Characteristic

**Specific gravity:** 0,876 gr/ml

**Viscosity:** 35-40 sec 20°C (DIN CUP 8)

**Water solubility:** <0.1%

**Flash point:** >-27°C (Hexane) (IP 170)

**Vapour pressure (20 °C):** 19000 Pa (Hexane)

**Vapour pressure (50 °C):** 58500 Pa (Hexane)

**Flammability:** Very flammable

**Open time:** approx. 40 min 18°C – 25°C

**Initial bonding:** 40 minutes 20°C

**Final bonding:** Subsequent processing of the bonded parts is possible after 3-5hours. Final strength is achieved after approximately 24 hours at 20°C.

**Application temperature:** +10°C - +30°C.

#### STORAGE

Products should be stored in a dry and cool place at a temperature of 5°C -35°C, away from sources of ignition. Protect from humidity and direct sunlight.

#### SHELF LIFE

24 months from the production date in the above mentioned storage conditions. The product should remain in the original unopened packaging bearing the manufacturer's batch number.

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#### PACKAGING

Tins: 500ml, 1lt, 5lt

PACKAGING	CODE	BARCODE
Tin 500ml	01511	5204094015116
Tin 1Lt	01512	5204094015123
Tin 5Lt	01513	5204094015130

#### HEALTH AND SAFETY INFORMATION



Acute Tox. 4: H312+H332 - Harmful in contact with skin or if inhaled  
Aquatic Chronic 3: H412 - Harmful to aquatic life with long lasting effects  
Flam. Liq. 2: H225 - Highly flammable liquid and vapour  
Repr. 2: H361f - Suspected of damaging fertility.  
Skin Irrit. 2: H315 - Causes skin irritation  
STOT RE 2: H373 - May cause damage to organs through prolonged or repeated exposure  
STOT SE 3: H336 - May cause drowsiness or dizziness  
P101: If medical advice is needed, have product container or label at hand  
P102: Keep out of reach of children  
P210: Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking  
P264: Wash thoroughly after handling  
P280: Wear protective gloves/protective clothing/eye protection/face protection  
P304+P340: IF INHALED: Remove person to fresh air and keep comfortable for breathing  
P370+P378: In case of fire: Use ABC powder extinguisher to extinguish.  
P501: Dispose of contents and / or their container according to the separated collection system used in your municipality  
EUH208: Contains Rosin. May produce an allergic reaction.  
Substances that contribute to the classification: Xylene; N-hexane; Acetone

The directives contained in this technical data sheet are the result of our long experience from real life applications and the research testing of our research and development laboratory and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications, which are beyond our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. We are liable only for our products for being free from faults and of consistent quality. Users are responsible for complying with local legislation and for obtaining any required approvals or authorizations. The present edition of this technical datasheet automatically cancels any previous ones concerning the same product.



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