



Nordale Australasia Pty Ltd

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Nordale 2000 Laminating Spray Contact Adhesive

TECHNICAL DATA SHEET

Description:

Nordale 2000 is a sprayable contact adhesive designed for flat laminating operations and postforming.

It has superior heat resistance and will bond a wide variety of surfaces including particle board, MDF, decorative plastic laminate, plywood, plasterboard, aluminium, mild steel and galvanised iron.

Typical Properties:

Appearance:	Clear,Red,Green liquid
Viscosity:	Approx 350 cps
Solids:	Approx 18%
Drying Time:	10 to 15 minutes
Bonding Range:	Up to 15 minutes
Heat Resistance:	> 150°C
Coverage:	Approx. 6-8 SqM per litre.

Directions:

All surfaces to be bonded must be clean, dry and free from dust, oil grease etc. Metal surfaces should be wiped with Nordale solvent cleaner to remove oil often found on metals.

Nordale 2000 can be applied using conventional air spray equipment and is suitable for use with most post forming equipment.

The adhesive should be sprayed onto both surface to be bonded, aiming for approximately 90% coverage over the bulk of the area and higher on the edges. Edges to be post formed should have 100% coverage of adhesive.

Allow the adhesive to become touch dry (the adhesive should feel tacky but not transfer when touched with the back of your hand) before bonding. This will take up to 15 minutes depending on the porosity of the surface, temperature and humidity.

When touch dry, position the surfaces carefully and bond together, applying firm pressure (276kPa (40psi) is recommended). This is best done using a nip roller or hand roller.



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Limitations:

Nordale 2000 is unsuitable for use on polystyrene, polyethylene, polypropylene, plasticised PVC, copper and it's alloys.

Nordale 2000 should not be used for exterior or load bearing applications.

Most common causes of failure are:

- Insufficient adhesive
- Insufficient pressure
- Incorrectly prepared surfaces
- Temperatures below 18°C accompanied by high humidity

Clean Up:

Equipment can be cleaned up using Nordale Solvent Cleaner.

NB. Solvent is not recommended for use on vinyl or lacquered surfaces.

Storage and Handling:

Please read the Material Safety Data Sheet for this product

BEFORE it is used.

Keep product away from all possible sources of ignition. Product must be stored in compliance with local and federal storage regulations. Store material between 15°C and 30°C, away from sources of heat and direct sunlight.

If the product is classed as a dangerous good, ensure that the product is stored in compliance with the applicable dangerous goods storage regulations.

Refer to the products Material Safety Data Sheet for the dangerous goods classification.

Shelf Life:

Up to 12 months when stored under the above conditions in the original unopened containers.

Note: Additional information on physical properties, health hazards, storage, handling and transport is available in the Material Safety Data Sheet (MSDS).