AW 1830/1831

SPRAY GRADE POLYSTYRENE ADHESIVE

YOUR SMART ADVANTAGES

- Rapid drying
- Polystyrene foam safe
- Excellent sprayability

DESCRIPTION

AW 1830 / 1831 Adhesive is a spray grade adhesive specifically formulated for bonding expanded polystyrene foam and other lightweight materials used in the insulation and air conditioning industries. It has excellent green strength, flexibility and good heat resistance.

AW 1830 / 1831 Adhesive can be used with steel, aluminium, galvanised iron, wood, hardboard, particleboard, cement sheet, concrete, masonry, expanded polystyrene, insulation batts and fibreglass reinforced plastics.

APPLICATION INSTRUCTIONS

Ensure adequate tests are conducted before using commercially.

Mix thoroughly before each use.

Surface Preparation

Surfaces must be clean, dry and free from oil, dust and other foreign materials. Clean metals with AW 901 Cleaner/Thinner before applying adhesive as mill process oil is often found on rubber and plastic sheet and castings.

Application

1. Apply by conventional air assisted spray equipment. General spray gun recommendations:
   - Tip Size: 1.4 mm minimum
   - Fluid Pressure: 30 – 50 psi
   - Atomizing Air Pressure: 35 – 70 psi
   - Fine Spray: 60 - 70 psi
   - Course Spray: 35 – 50 psi

2. Spray adhesive to one surface at a rate that gives satisfactory adhesion. For best results, spray both surfaces (contact bond method) and ensure the spray pattern is uniform and gives complete surface coverage. For sandwich panel construction, adhesive coverage should be 165 to 250 grams per square meter, wet, ON EACH SIDE.

3. Allow the adhesive to partially dry so it tacks up. This may only take 30 seconds, depending on the ambient temperature and air movement. OPEN TIME: 5 minutes maximum, depending on amount of adhesive applied and ambient temperature. More adhesive and lower ambient temperature will extend drying time and open time. Special precaution for polystyrene: Do not apply excessive adhesive and do not trap wet adhesive between the surfaces, otherwise a small degree of styrene deformation can occur, resulting in a failed bond.

4. Mate the surfaces together before the adhesive has gone tack free, and ensure that the laminate is adequately nip rolled or contacted with sufficient pressure to wet the adhesive onto the other surface. A MINIMUM contact pressure of 175kPa (25psi) is required for adequate adhesion, especially for sandwich panel construction.

PRODUCT CHARACTERISTICS

<table>
<thead>
<tr>
<th>Type</th>
<th>Synthetic Rubber / Resin</th>
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</thead>
<tbody>
<tr>
<td>Colour</td>
<td>Light Yellow / Blue</td>
</tr>
<tr>
<td>Solids Content</td>
<td>Approx. 30%</td>
</tr>
<tr>
<td>Viscosity</td>
<td>Medium to thin consistency</td>
</tr>
<tr>
<td>Tack up Time</td>
<td>1-5 mins @ 20°C</td>
</tr>
<tr>
<td>Touch Dry</td>
<td>Approx. 5 – 10 mins @ 20°C</td>
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Product code

- AW1830 – 20L – Clear 30840012
- AW1830 – 200L – Clear 30840013
- AW1831 – 20L – Blue   30803244
- AW1831 – 200L – Blue  30840020

LIMITATIONS

- Not suitable for polyethylene or polypropylene plastic
- Not recommended for bonding laminates or post-forming applications
AW 1830/1831

STORAGE & SHELF LIFE
Store in a cool, dry place, out of direct sunlight and away from all sources of ignition. Storage areas must be well ventilated and comply with Local, State and Federal regulations. For maximum shelf life, store between 5°C and 20°C. Shelf life is up to 12 months when stored in original, unopened containers, under the above conditions.

HEALTH & SAFETY
Please refer to the SDS which is available online. The solvents contained within this product are Highly Flammable.

CLEAN-UP
Use AW 850 Cleaner/Thinner to clean up equipment and excessive adhesive. Colored adhesive may cause staining on light colored upholstery fabrics/materials.

For emergency information contact the Poisons Information Centre, phone 131 126 or the Emergency Response Service, phone 1800 033 111.