

PRODUCT DATA SHEET

EVERBUILD® Smart Tack®

ADVANCED SPRAY BONDING SYSTEM FORMING A WEB PATTERN ON APPLICATION

PRODUCT DESCRIPTION

EVERBUILD® Smart Tack® is an advanced spray bonding system that outperforms and outdates conventional contact adhesives, providing significant performance and time saving application benefits.

Based on new technology resins, EVERBUILD® Smart Tack® is applied by spray and provides very fine strands of "high solids" adhesive that forms a web type pattern on application.

USES

- Laminates
- Veneers
- Edge banding
- Vinyl's*
- uPVC sheet#
- Fabrics
- Temporary/light duty bonding on carpets, fabrics, polystyrene/PU sheeting, posters etc.

CHARACTERISTICS / ADVANTAGES

- Fast Tacking: - Surfaces can normally be "closed" after only 3-5 minutes
- Long Open Time: - Surfaces can also be left open for up to 2 hours.
- Immediate Handling: - High early bond strength allows item to be handled, cut drilled and planed within 5 minutes of closing.
- High temperature: - Unaffected by temperatures up to 90°C (194°F).
- Fast Application; - 15 times quicker than applying conventional contact adhesive by spreader.
- Cost effective: - Goes approximately three times further than applying conventional contact adhesive by spreader.
- Convenient; - No airline, electric or press. Easy to maintain, no mess.
- Safer: - Low odour, no CFC's, self contained systems.
- Blue Colour: - Unique to EVERBUILD® Smart Tack® range.

Solids	<u>28-32%</u>
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Viscosity	<u>Low</u>
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PRODUCT INFORMATION

Chemical Base	Synthetic rubber / resin
Packaging	EVERBUILD® Smart Tack® Handy - 500ml Aerosol can EVERBUILD® Smart Tack® Bulk Tank - 17kg Metal canister
Colour	Blue and Clear
Shelf Life	12 months from date of manufacture in original unopened containers.
Storage Conditions	Store in original unopened containers between 5°C and 25°C. Store as flammable liquid.
Density	0.9 - 0.99 g/cm ³

APPLICATION INFORMATION

Consumption	EVERBUILD® Smart Tack® Handy - 2.5-3.5m ² EVERBUILD® Smart Tack® Bulk Tank - 128m ²
Tack Free Time	3 minutes - 2 hours

APPLICATION INSTRUCTIONS

Always read SDS and wear protective clothing, gloves and eye/face protection before use.

SUBSTRATE PREPARATION

Surfaces to be bonded must be clean, dry and dust/grease free. When bonding plastic laminates/sheeting, it is recommended that substrates are conditioned for 48hrs before assembly at 20°C with a relative humidity of 45-55%. Air should be able to circulate freely around these components.

APPLICATION METHOD / TOOLS

EVERBUILD® Smart Tack® Handy

Permanent bonding (laminates trim etc)

Apply to both surfaces. Always apply to laminate first and spray one surface horizontally and one surface vertically. Set spray band width by turning nozzle to H (high) M (medium) or L (low) positions depending on width of glue band required. Spray at a distance of approx. 15cm (6 inches) from the substrate. Apply an even coat ensuring 80-100% coverage. Avoid localized spraying as this will allow the adhesive to puddle which in turn can cause unevenness and can "show" through the laminate trim or cause blistering or peel. One coat is normally sufficient per side for non porous substrates. A second coat is recommended on porous substrates. Allow the adhesive to tack up and protect from contamination (dust etc) whilst this happens. EVERBUILD® Smart Tack® is normally ready for bonding within 3-5 minutes at 20°C/50% relative humidity and may be left open for up to 2 hours before bonding. Ensure there are no wet patches of adhesive remaining before bonding. At low temperatures, care must be taken to ensure that the temperature of the adhesive and of both surfaces to be bonded is higher than the ambient temperature. Cold materials have a strong tendency to attract moisture present in surrounding air, which can have disastrous effects on the bond strength.

Temporary or light duty bonding (carpets, fabrics, polystyrene sheet etc)

Apply as above but to the substrate surface only. Never apply direct to polystyrene. Always apply to the "other" surface.

EVERBUILD® Smart Tack® Bulk Tank

Ensure hose is screwed into position on both gun and canister, taking care not to cross thread or damage the thread. Ensure lock on spray gun is engaged. Fully open the valve on the canister and direct the gun at the surface to be bonded.

Before applying, ensure the gun is correctly adjusted and test spray on a practice piece.

Adjust knob at rear of gun until an even fan of 13 – 23 cm (5-9") of fine strands of adhesive is produced. If the

adhesive is "wet" tighten knob until only fine strands appear.

Fitting hose and gun to new canister: Close valve on canister completely. Hold gun trigger open, pointing away from person, until all pressure is released. Disconnect the hose at the valve and re-connect to a new canister. Open valve and check fittings for leaks.

Permanent bonding (laminates etc)

Apply to both surfaces. Always apply to laminate first and spray one surface horizontally and one surface vertically. Hold the spray gun at 90° to, and at a distance of 30 – 35cm (12-14 inches) from the substrate. Do not hold closer than 30cm to avoid "wetting" the surface. Squeeze trigger and move gun parallel to the surface in a smooth motion paying particular attention to the edges. Apply an even coat ensuring 80-100% coverage. Avoid localized spraying as this will allow the adhesive to puddle which in turn can cause unevenness and can "show" through the laminate or cause blistering. One coat is normally sufficient per side for non porous substrates. A second coat is recommended on porous substrates. Allow the adhesive to tack up and protect from contamination (dust etc) whilst this happens. The adhesive is ready for bonding when the whole area is touch dry, i.e. does not transfer to the finger when touched.

EVERBUILD® Smart Tack® Bulk Tank is normally ready for bonding within 3-5 minutes at 20°C/50% relative humidity and may be left open for up to 2 hours before bonding. Ensure there are no wet patches of adhesive before bonding. At low temperatures, care must be taken to ensure that the temperature of the adhesive and of both surfaces to be bonded is higher than the ambient temperature. Cold materials have a strong tendency to attract moisture present in surrounding air, which can have disastrous effects on the bond strength.

Temporary or light duty bonding (carpets, fabrics, polystyrene sheet etc)

Apply as above but to the substrate surface only. Never apply direct to polystyrene. Always apply to the "other" surface.

CLEANING OF TOOLS

Remove overspray with Stick 2 Contact Adhesive Thinner & Cleaner applied by cloth, checking compatibility with surface in a small inconspicuous area before full application.

EVERBUILD® Smart Tack® Handy

Remove skin from outer face of nozzle when left to stand for 15 mins or more.

EVERBUILD® Smart Tack® Bulk Tank

Gun and hose must be left attached to canister between jobs. Remove skin from outer face of nozzle when left to stand for 15 mins or more. Clean blocked guns by dismantling and soaking metal parts in Stick 2 Contact Adhesive Thinner & Cleaner.

LIMITATIONS

- Do not use in areas subject to continuous water immersion.
- Do not use on colour core laminates or on any translucent/opaque sheeting.
- Do not use on bitumen, asphalt, or cellulose painted surfaces.
- Do not spray directly onto polystyrene. Spray onto other surface.
- Do not use as a mirror adhesive as the product may attack the mirror backing. Use Everbuild Mirror Mate adhesive.
- Do not use in areas subject to intense lighting or sunlight where the surface temperature could exceed 90°C.
- At low temperatures, care must be taken to ensure that the temperature of the adhesive and of both surfaces to be bonded is higher than the ambient temperature. Cold materials have a strong tendency to attract moisture present in surrounding air, which can have disastrous effects on the bond strength.
- Always allow adhesive to become touch dry on both surfaces. Premature bonding may cause solvent entrapment and blistering of laminates.
- *Not to be used with flexible vinyl's only rigid.
- #Not to be used on flexible PVC.
- As the manufacturer cannot know all the uses its products may be put to, it is the users responsibility to determine suitability of use. If in doubt, contact Technical Services Department for advice.

VALUE BASE

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for the exact product data and uses.

ECOLOGY, HEALTH AND SAFETY

LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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