



# EVO-STIK 528 Contact Adhesive

## A GENERAL PURPOSE POLYCHLOROPRENE ADHESIVE

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Fact Sheet No.: TDS00442

### YOUR SMART ADVANTAGES

- High initial grab, with excellent final bond strength
- High shear strength, with good temperature resistance
- Easy application by serrated spreader

### USES

EVO-STIK 528 Contact Adhesive is intended for use in interior situations. It may also be used in exterior situations where it can be protected from the weather (sun and rain) e.g. bonding laminates. The new improved (toluene free) formulation has a lower odour and is clearer.

EVO-STIK 528 Contact Adhesive is ready for use and bonds decorative laminates (e.g. Formica), rigid PVC, wood, chipboard, hardboard, cork, leather, some rubber, stone, metal and dense firm fabrics. EVO-STIK 528 Contact Adhesive may also be used to bond insulating fibreboards and acoustic tiles to suspended or vertical surfaces such as flat-surfaced ceilings or walls.

Do not use EVO-STIK 528 Contact Adhesive on polystyrene or on cellulose painted surfaces.

### PRODUCT CHARACTERISTICS

Colour	Translucent amber
Form	Viscous liquid
Specific Gravity	0.84 approx.
Composition	Blend of polychloroprene rubber and synthetic resins, in a mixture of petroleum solvents.
Product Codes	30803761 500ml x 24

	30803762 1 Litre x12
	30813330 2.5 Litre x1
	30021180 5 Litre x1
Storage/Shelf Life	Store for up to 12 months from date of manufacture when stored in original, unopened packaging under dry conditions within the temperature range of +5°C to +25°C.
Odour	Sweet hydrocarbon
<b>TYPICAL PERFORMANCE DATA (Approx.)</b>	
Application Temperature	+5°C to +30°C.
Service Temperature	-40°C to +65°C.
Coverage	4 – 6m <sup>2</sup> per litre per coat, depending upon the surface type
Drying Times	10 to 20 minutes Full bond strength after 24 to 48 hours.
Open Time	Up to 45 minutes

### DIRECTIONS FOR USE

IMPORTANT: Before using EVO-STIK 528 Contact Adhesive refer to the relevant Health & Safety Data Sheet, available at [www.bostik.co.uk](http://www.bostik.co.uk).

### PREPARATION

1. All surfaces to be bonded must be smooth, clean, dry and free from dust and grease.
2. Smooth or polished surfaces must be roughened with a fine abrasive.

3. If degreasing is necessary, a detergent/water treatment should first be considered. If this is inappropriate, a suitable solvent such as EVO-STIK Adhesive Cleaner may be used. It is advisable to check the effects of degreasing solvents on plastics, rubber materials and painted surfaces before carrying out the operation. All traces of cleaning solvents must be allowed to evaporate before application of the adhesive.

#### APPLICATION

4. Apply an even ribbed coating of adhesive to both surfaces to be bonded, using a trowel or spreader with a serrated edge and taking care that its serrations are neither worn nor filled with dried adhesive.
5. To ensure the correct coverage is obtained use the spreader at such an angle as to give good rib formation after drying.
6. Keep the surfaces separated until both the adhesive films are touch dry.
7. When working at high relative humidity, condensation of moisture on the adhesive film may take place, recognisable by the appearance of a white 'bloom' on the surface. This can be detrimental and work should not continue until conditions have improved by raising the temperature and/or drying the atmosphere. This depends on such variables as spreading thickness, surface porosity, and ambient temperature and humidity.
8. Typical touch dry times are 10 to 15 minutes for porous substrates and 10 to 20 minutes for non-porous substrates.
9. Normally assembly should not be delayed for more than 45 minutes after application.
10. Bring the two coated and touch dry surfaces into contact and press together over the whole bond area.
11. Hand pressure is normally sufficient but a suitable press or a rubber hand roller may often be used with advantage.
12. Sustained pressure is necessary.

#### CLEANING

13. Remove as much of the adhesive as possible by mechanical means.
14. Adhesive can be removed using a cloth dampened with acetone or EVO-STIK Adhesive Cleaner.
15. Always check if the cleaning solvent might damage a nearby surface by testing.

#### PRECAUTIONS IN USE

EVO-STIK 528 Contact Adhesive is unsuitable for use with expanded polystyrene, or plasticized PVC (vinyl).

Do not use on or near bituminous surfaces.

EVO-STIK 528 Contact Adhesive will not bond polyolefins such as polyethylene and polypropylene.

It is not suitable for use where only point contact exists between the surfaces to be bonded.

Bringing the surfaces together before they are touch dry will result in solvent being trapped, this will adversely affect the final bond and may give rise to blistering problems, particularly if the adhesive has not been evenly spread.

EVO-STIK 528 Contact Adhesive forms a bond as soon as the two surfaces touch. It is therefore essential to avoid contact before the parts are in alignment, such as by insertion of pins along one edge of one surface, against which the other surface can be located.

The initial bond strength allows immediate handling of the assembly but maximum bond strength is reached after approx. 24 to 48 hours at normal temperatures.

For any application not covered please contact Technical Services on +44 (0)1785 272625 or visit [www.bostik.co.uk](http://www.bostik.co.uk) for advice.

Recommendations and suggestions are for guidance only, since conditions of use are completely beyond our control.

For health and safety instruction, first aid measures and spillage and disposal instructions, see separate Health and Safety Data Sheet for EVO-STIK 528 Contact Adhesive, available at [www.bostik.co.uk](http://www.bostik.co.uk).

BOSTIK HOTLINE

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