



H.B. Fuller



ROYAL
ADHESIVES & SEALANTS

Silaprene®

ISO 9001:2000 2/14/05

TECHNICAL SALES BULLETIN

SILAPRENE® DC 12149 HEAT RESISTANT PSA ADHESIVE

SILAPRENE DC 12149 is an amber colored, solvent-based, pressure sensitive adhesive for paper, card stock, foils, rigid plastics, and polyolefin foams and films.

DESIGNED TO BOND:

1. Polyethylene and polypropylene foam and plastic.
2. Most plastic substrates, including polyurethane foam.
3. Paper, cardboard, chipboard, and metal foils.
4. Glass and ceramic materials.
5. Most elastomers, including EPDM, natural and TPR.
6. Painted and bare metal.
7. Not recommended for highly plasticized vinyls.

PHYSICAL CHARACTERISTICS:

1. Brush or roll coat viscosity.
2. High tack strength to most substrates.
3. Excellent peel adhesion.
4. Good resistance to creep and cold flow.
5. Resists heat, water and cold.
6. Retains tack at temperatures as low as 40°F.
7. High shear strength.
8. Can be used for above the beltline applications.
9. Shelf life: 1 year at temperatures not to exceed 80°F.

TYPICAL PROPERTIES:

(Specification ranges available on request)

Base:	SBR rubber
Color:	Amber
Solvent:	Toluene
Solids:	48%
Viscosity:	6000 cps, RVF Brookfield, #3 spindle, @ 10 rpm.
Weight/gallon:	7.6 pounds
Specific Gravity:	.91
Temperature range:	40°F to 240°F

PREPARATION OF SUBSTRATES:

Surfaces to be bonded should be cleaned of all dust, oils or other contaminants. A solvent wipe is often adequate. Bonds to rigid surfaces are usually improved by a solvent wipe followed with light abrasion (180 grit), and solvent wiping to remove abrasive residue. Dry surfaces thoroughly before applying adhesive.

METHOD OF APPLICATION:

Apply one coat of adhesive by brush to one of the surfaces

to be bonded. Join the surfaces when the adhesive is tacky to the touch but does not transfer to the finger. Use sufficient pressure to ensure good contact. Bonds can be made in 1 to 5 minutes, depending on ambient conditions and coating weight.

The adhesive can be applied by knife coating, roll coating, and by reverse roll coating. For better adhesion and surface wet-out, the adhesive can be applied directly to the surface to be bonded. However, for better control of adhesive film thickness, coating onto release paper is recommended. Dry film thickness can vary from 1 to 10 mils, depending on the surface conditions of the substrate.

After drying the adhesive on the release paper, the substrate should be laminated to the adhesive film and pressed or rolled between nip rollers to effect a transfer from the release paper to the substrate. Combined surfaces should be dried an additional 24 hours at room temperature prior to cutting or other operations. This will allow any remaining solvent to diffuse out and reduce flowing and gumming of cutting knives

CLEANER AND THINNER:

Toluene

PRECAUTIONARY DATA:

This product is extremely flammable. Vapors may form an explosive mixture with air. Precautions should be taken to keep product away from fire, sparks, motors and other sources of heat or flame. Turn off or deactivate any electrical equipment or sources of ignition. Adequate ventilation is required to keep vapor concentrations below the Threshold Limit Value.

- For professional or industrial use only.
- Read the container label and the Safety Data Sheet carefully before use.
- Keep away from children.
- Keep container closed when not in use.
- Store closed container under 80°F.
- This product contains toxic chemicals subject to the reporting requirements of Section 313 of the Emergency Planning and Community Right-to Know act of 1986 and 40CFR 372.

DISPOSAL INFORMATION:

When discarded, this material is hazardous waste. Do not reuse container or remove label. Safely dispose of container and contents in accordance with applicable Federal, State and local regulations.