

ALPHA

SOLUTIONS FOR INDUSTRY

S 2193 HIGH PERFORMANCE BONDING SYSTEM

Description

Alpha S 2193 is a general purpose, two part poly-chloroprene based adhesive specifically formulated to give good adhesion to a variety of natural and synthetic rubber surfaces, used in the manufacture of inflatable life rafts, general rubber goods and numerous industrial applications.

Application

Alpha S2193 being resistant to salt water, atmospheric oxidation, oil, specified chemicals, aviation fuels, mild acids and alkalis make it ideal for bonding rubbers used in the manufacture of life rafts, inflatable life jackets, diving suits and rigid hull inflatable boats.

Technical Data

PART A

Base	Poly-chloroprene
Colour	Off white
Total Solids	23 ± 1.5%
Viscosity (at manufacture)	2900 ± 400 cps
Typical Specific Gravity	0.870
Flash Point	-12°C
Cleaner	T559

PART B

Composition	Non volatile isocyanate in Ethyl Acetate
Colour	Light brown/amber
Total Solids	27 ± 1%
Flash point	-4°C
Typical Specific Gravity	1.00

MIXED ADHESIVE

Mix Ratio	100 parts Part A: 6 parts Part B by weight
Total Solids	24 ± 1%
Open Joint Time	Minimum 5 minutes Maximum 20 minutes
Coverage	3 . 4 sq. metres/ litre
Method of application	Brush or roller coater
Cleaner	T559
Pot Life	6 hours at 20°C
Minimum Service Temperature	-30°C
Maximum Service Temperature	+ 90°C
Number of Coats	minimum 2

Method of use

1. All surfaces must be clean, dry and dust free. Abrade surfaces with wire brush then remove all traces of grease, oil and release agents with Alpha T559.
2. Mix 100 parts A to 6 parts B by weight until a creamy consistency.
3. Spread an even coat to each surface and allowing them to become touch dry (approx. 10-20 mins). Spread a further coating to each surface and allowing them to become tacky (5- 15ins).
4. Position carefully and consolidate bond by firm even pressure over the whole area. (A hand roller is recommended wherever possible).

Health & Safety

See separate health and safety data sheet.

Storage and Shelf Life

Stored in well sealed containers, S 2193 will keep satisfactorily for up to 12 months, from date of manufacture S 2193 must be protected from frost and stored between 5 . 25°C.

Important Notice

Whilst all reasonable care is taken in the compilation of this data sheet, it is the customer's responsibility to determine the suitability of the product for the desired application.

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