

Altuglas® Adhesive S2002 is a single-component liquid, transparent, solvent adhesive.

## APPLICATIONS

For bonding Altuglas® CN and EX in various applications such as POS displays, signs, display cases, etc.

This adhesive can also be used for bonding other plastic materials, such as polystyrene and ABS, after they have first been annealed as a precaution. In such cases, prior testing is recommended.

## TYPES OF BOND

- Edge-to-edge bonding (covers, boxes)
- Angle bonding (POS)
- Edge-to-surface bonding (raised lettering on signs)

This list is not exhaustive.

The fluidity of Altuglas Adhesive 2002 means it can be applied by capillary action, using a syringe.

## PROPERTIES

Viscosity at 20°C (Brookfield):	200 - 300 mPa.s
Density at 20°C :	1.05 g/cm <sup>3</sup>
Flash point:	6°C
Solids content:	≈ 25%
Storage temperature:	between 15° and 30°C

## PRECAUTIONS IN USE

Special care Adhesive S2002 is extremely volatile. Evaporation resulting from prolonged exposure to the air causes the adhesive to thicken. We strongly recommend that you close the receptacle tightly as soon as you have taken the quantity you require. Caps should be fitted to applicator tubes to avoid them becoming blocked. Adhesive should not be left in applicator tubes for longer than 24 hours.

## TOXICITY AND SAFETY

Special care Adhesive S2002 contains a small quantity of chlorinated solvent. The presence of this chlorinated solvent means that the adhesive is poisonous if consumed and likely to cause irreversible effects:

- Do not inhale the vapour
  - Work in a well-ventilated area
  - Avoid all contact with the skin and eyes
- Special care Adhesive S2002 is classed as highly flammable (F) and irritant (Xi). Store well away from heat and do not smoke whilst using the product. For further information, see the Safety Data Sheet.

## STORAGE PRECAUTIONS

Unopened packages should be stored in a cool, dry, well-ventilated place. If stored in its original packaging, hermetically sealed and at a maximum temperature of 30°C, Special care Adhesive S2002 can be kept for up to two years from the date of packaging.

## PACKAGING

Special care Adhesive S2002 is packed in full cartons of 12 containers, each holding 1 kg. Full cartons cannot be split. Alternative packaging may be possible to order, subject to minimum quantities and delivery times. Containers are made of aluminium for safety and corrosion reasons. Each individual package carries important information from the Safety Data Sheet and the production batch number.

## Guidelines for use

### Releasing internal strains:

The Altuglas® CN and EX components to be glued can be subject to internal strains, caused by various machining or forming operations. Internal strains must therefore be released by annealing, otherwise cracking (crazing) will occur during contact with solvents in the adhesive. If machining (cutting or milling) operations have been performed with efficient cooling (clean water, water + air), simply roughen the surfaces to be glued.

Disc polishing, forming and hot bending lead to an increased risk of crazing, which justifies annealing (see Altuglas® Technical Brochure).

With laser cutting and flame polishing, it is essential that parts be annealed before bonding.

### Preparation of surfaces:

Speed is one of the key benefits of solvent-type adhesives. Also, after parts have been annealed, it is only necessary to roughen the edges.

The surfaces to be glued must be completely dry and clean. Remove all traces of grease from the parts to be glued, using petroleum ether or a 50/50 mixture of water/methylated spirit. If necessary, areas adjacent to the area being glued can be protected by a special adhesive tape made of adhesive-resistant material (e.g. polypropylene). If necessary, pre-assemble parts using the same adhesive tape.

### Applying the adhesive:

Where there is no pre-assembly, use a polyethylene bottle fitted with a nozzle to apply a thin line of glue to one of the two surfaces to be glued. Exert gentle and even pressure while it is setting, to avoid squeezing all the glue out of the joint and the formation of shrinkage bubbles caused by solvent evaporating.

When pre-assembling, Altuglas® Adhesive S2002, applied with a syringe, is spread through the joint by capillary action.

Altuglas® Adhesive S2002 cannot be used for bonding large surfaces, as the solvent cannot evaporate.

To avoid frequent clogging of the nozzle, replace the cap each time after use. When pre-assembling, adhesive can be applied to the area of the joint using a syringe.

### Drying and hardening time:

The external surface of the glued joints will dry in approximately 25 to 30 minutes at 20°C (guide time). Hardening varies with thickness, temperature and humidity. It is usually possible to handle glued objects (carefully) after 60 to 90 minutes, but a minimum of 48 hours must be left before any machining.

Complete hardening is achieved after 15 to 20 days at a temperature of 20°C.

If necessary, this can be accelerated by heating for several hours at 80°C (or only 60°C for a thermoformed part).

### PROPERTIES OF JOINTS MADE WITH SPECIAL CARE ADHESIVE S2002

Mechanical strength is determined by traction applied to test samples formed by end-to-end bonding. Measurements have been made using test samples heated for 4 hours at 60°C as well as test samples left to harden naturally for 4 days at room temperature. The values below are given purely for guidance and do not in any way constitute a guarantee.

#### Tensile strength:

After 4 days of natural hardening: 28 to 32 Mpa

After heating at 60°C: 38 to 45 Mpa