

## EVO-STIK 5696

### SOLVENTED CONTACT ADHESIVE

**EVO-STIK 5696** is a solvented contact adhesive which can be applied by hot or cold techniques, it has excellent hot spraying properties is fast drying and gives a rapid build up of adhesion, the resultant bonds have good durability and excellent heat resistance.

#### RECOMMENDED USE

**EVO-STIK 5696** is a multipurpose, sprayable contact adhesive particularly suitable for bonding laminates on particle board, MDF, woods and metals.

**EVO-STIK 5696** can also be used for postforming.

#### BONDING INSTRUCTIONS

##### SURFACE PREPARATION

- Substrates to be bonded should be perfectly clean dry and free from dust and grease.
- Smooth or polished surfaces should first be roughened with fine abrasive.
- If degreasing is necessary, a detergent/water treatment should first be considered. If this is inappropriate a suitable solvent e.g. cleaner 5 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 completely before application of the adhesive.

##### APPLICATION

**EVO-STIK 5696** is suitable for application by automated spray equipment or by spray gun. One combination, which has been found particularly suitable, is a Kremlin M18 gun fitted with an N3 air cap and size 15 fluid tip and needle. Similar equipment supplied by other manufacturers can also be used successfully.

Both surfaces to be bonded should be coated with adhesive. To obtain good coalescence, it is advisable that the coating be of a fine stippled pattern, covering the majority of the surface

Coverage: Approx. 9m<sup>2</sup>/litre on a non-porous substrate.

**Cold spray method:** (recommended starting point for large areas)

Pot pressure: 70 -100 kPa (or by gravity feed)  
Atomisation pressure: 500 - 600 kPa  
Fan width: up to 450mm (600mm from the work)  
Drying time: Approx. 2 minutes

For small areas or flimsy materials, satisfactory results can be obtained using lower pressure.

Suitable spray pattern and pressure conditions should always be assessed by means of a test specimen.

**Hot spray method:**

Recirculation temperature: 55 - 65°C  
Pressure: 200 - 240 kPa  
Drying time: < 1 minute

### BONDING

- Bring the two dry, coated surfaces into contact within 15 minutes of application and press together over the entire bond area.
- To obtain optimum initial bond strength, surfaces should be bonded as soon as possible after drying.
- Apply as much pressure as possible by hand roller, static press or nip roller without causing damage. Sustained pressure is not necessary.

### GENERAL PRECAUTIONS

- Do not add anything to the adhesive to modify its properties.
- After each use, close the container tightly in order to avoid solvent evaporation.

### **TYPICAL CHARACTERISTICS**

Physical Form:	Low viscosity liquid
Colour:	Red or Beige
Chemical Type:	Polychloroprene rubber/synthetic resin blend
Solvent:	Acetone/hydrocarbon blend
Viscosity (Brookfield RVT, 10rpm at 25°C):	Approx. 150 mPas
Solids Content:	Approx. 21%
Specific Gravity:	Approx. 0.8
Flammability:	Highly flammable

### **PACKAGING**

25 litre drum (code No. Beige - 951808, Red - 952003), 200 litre drum (code No. Red - 952058).

### **STORAGE**

Store in accordance with the requirements of the petroleum regulations in a dry flameproof area between 5 and 25°C.

### **SHELF LIFE**

6 months in its original container stored under the above conditions.

### **MATERIAL SAFETY DATA**

For further information refer to the relevant Health and Safety Data Sheet.