



# Anchor-Weld N102L

## Roller/Brush Grade Heat Resistant Laminate Contact Adhesive

### DESCRIPTION

*Anchor-Weld N102L Laminate Contact Adhesive* solvent based (flammable), is a high solids, high heat resistant roller/brush grade adhesive, specifically formulated for use with a number of materials such as: decorative plastic laminates, aluminum, mild steel, wood, wood veneer, particleboard, plywood, gypsum wallboard, linoleum, galvanized steel, paper honey-comb, rigid polyurethane foam and other similar materials in the manufacture of counter tops, table tops, desk tops, vanities, furniture, sandwich panels, doors, cabinets, partitions, wall panels and other laminated products.

*Anchor-Weld N102L Laminate Contact Adhesive* exceeds the Australian Standard 2131-1978 heat resistance test, making it an ideal adhesive for use in heat prone areas.

Not recommended for exterior use, or bonding polystyrene foam, or bonding materials to copper.

### SURFACE PREPARATION

Surfaces must be clean, dry and free from oil, dust and other foreign materials. Wipe metal with *Anchor-Weld 900 Cleaner/Thinner* before applying adhesive as mill process oil is often found on metal. Mould release powders are often found on rubber and plastic castings.

### APPLICATION

Roll or brush adhesive on to both surfaces. Allow surfaces to become touch dry. This will take approximately 10-15 minutes depending on atmospheric conditions and can be tested by placing the knuckles into the adhesive which should feel tacky but not transfer to the knuckles.

Two or more coats may be required on porous surfaces. On extremely porous surfaces we recommend that *Anchor-Weld N102S* be used in conjunction with *Anchor-Weld N103 Contact Gel*. Surfaces should be joined within 45 minutes after application. If the surfaces are not joined within this time, they can be reactivated by applying another coat of adhesive. A minimum of 276KPa (40psi) bond pressure is recommended for best results. Pressure should be applied by using a pinch roller or **Roberts Hand Roller 10.955**, working from the centre towards the edges to remove all air bubbles.

### CLEAN UP

To clean up equipment and adhesive spills use *Anchor-Weld 900 Cleaner/Thinner*. *Anchor-Weld 900* is **not** recommended for removing adhesive from vinyl or lacquered surfaces. Thinning is not recommended.

### TYPICAL PROPERTIES

Appearance	Pale yellow
Base	Neoprene rubber
Solids	Approximately 20%
Viscosity	Thick syrup
Shelf Life	Approximately 1 year in sealed container at 20°C
Flash Point	Less than 0°C
Dry Time/	
Tack Up	Approximately 10-15 minutes at 20°C
Open Time	Approximately 45 minutes
Coverage	Approximately 5m <sup>2</sup> per litre
Available in	200L, 20L, 4L, 1L
Heat Resistance	- exceeds 150°C

### NOTE

The two most common causes of bond failure are:

1. Insufficient adhesive
2. Insufficient pressure

### SAFETY INSTRUCTIONS

#### Product is flammable.

*Storage* - Store inside where possible out of direct sunlight. Storage areas to be well ventilated and kept at a maximum of 20°C. Refer to Local, State and Federal Regulations.

#### IN USE:

**Respiratory Protection** - Not required if ventilation is adequate, otherwise use a half face vapour filter.

**Ventilation** - General dilute ventilation of sufficient volume and pattern to keep vapour concentration below 300p.p.m.

**Protective Gloves** - Solvent resistant

**Eye Protection** - Safety glass with side shield.