



Anchor-Weld N177 CLEAR

Spray Grade Heat Resistant Contact Adhesive

DESCRIPTION

Anchor-Weld N177 Clear Contact Adhesive solvent based (flammable), is a high solids, heat resistant spray grade adhesive, specifically formulated to stay in solution in hot and cold conditions.

Anchor-Weld N177 Clear has a lower viscosity than *Anchor-Weld N150* to enable it to be used with low volume spraying equipment.

Anchor-Weld N177 Clear Contact Adhesive exceeds the Australian Standard 2131-1978 heat resistance test, making it an ideal adhesive for use in heat prone areas.

It is used for bonding decorative plastic laminates, aluminum, mild steel, wood, wood veneer, particleboard, plywood, gypsum wallboard, linoleum, galvanised steel, paper honeycomb, 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. Not recommended for bonding polystyrene foam, materials to copper or for exterior use.

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

Anchor-Weld N177 Clear Contact Adhesive can be applied using standard spray equipment such as 200 litre pumps, 20 litre pressure pots and one litre suction cup guns.

Apply adhesive to approximately 80% of the surface area to be bonded with an additional build up of adhesive towards edges. Spray adhesive to both surfaces. Allow adhesive to become touch dry. This will take approximately 10-15 minutes depending on atmospheric conditions and can be tested by placing knuckles into the adhesive which should feel tacky but not transfer to knuckles.

Two or more coats may be required on porous surfaces. 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 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 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	Clear
Base	Neoprene rubber
Solids	Approximately 16%
Viscosity	Thin 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 6m ² per litre
Available in	200L and 20L
Heat Resistance -	Exceeds 155°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, council and government 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.