



## **HTA 1000 WB SPRAYABLE**

### **ONE PART WATER-BASED ADHESIVE FOR HIGH TEMPERATURE APPLICATIONS**

#### **PRODUCT INFORMATION**

HTA1000WB is a single component sprayable adhesive that provides instant grab and high heat resistant bonding. HTA1000WB is sprayable through air assisted equipment free of copper & brass.

For best results or large production runs we advise using a pressurised spray / pot system.

For smaller areas and for trials a gravity fed spray gun with a stainless steel nozzle and 1.4- 2.0 needle. We can supply either set up.

It is based on novel water-based dispersion technology that is safe to use. It contains no solvents or isocyanates and conforms to the latest environmental legislation.

HTA1000WB can be used on a variety of substrates to give instant bonds characterised by high strength once fully cured. HTAWB- Can be applied to a surface and left to cure, when required this at a later date can be reactivated by the introduction of heat.

#### **KEY INFORMATION**

**Water-based adhesive – safe to use and environmentally friendly**

**Instant hold**

#### **HEAT REACTIVE TECHNOLOGY**

**Ideal for applications involving porous substrates**

**Heat resistance up to 140°C**

**Cold resistance down to -40°C**

**Good adhesion when bonding porous materials to non-porous substrates**

#### **TYPICAL APPLICATIONS**

Automotive industry for the production of trim application such as car panels, seats, headrests and headliners.

Marine industry for trimming applications on a wide variety of fabrics to wood, metal and composite materials.

Bonding foam-based insulation panels to plasterboard.

It can also be used as a general purpose adhesive where high temperature resistance is a preference.

## **PRODUCT CHARACTERISTICS**

The following technical information and data should be considered representative or typical only. Therefore, the information should not be used for specification purpose.

### **Property Data**

**Colour** White

**Base** Polychloroprene latex

**Consistency** Liquid

**Specific Gravity (20°C)** 1.10

**Total Solids Content** 53 ± 2 %

**Viscosity (20°C)** 250-550 cP

**Open Joint Time** Porous Substrates: Instant to 5 minutes\*

Non-Porous Substrates: 15 to 20 minutes\*

**Heat Resistance** – 40 to 140°C

**Coverage** 10 – 15 square metres / litre\*

\* dependent upon ambient temperature, relative humidity and the materials used.

## **PRODUCT PERFORMANCE**

The performance data presented here has been determined by Wayside Adhesives Ltd standard test methods and are average values that should not be used for specification purposes. Our recommendations on the use of this product are based on tests believed to be reliable. It is advised that users conduct their own tests to determine the suitability of the product for their specific application.

### **Test Substrates Results/Observations**

**Bull Nose Joint Adhesion Test** PU Foam to PU Foam Instant grab; substrate failure at 5 mins

**T-Peel Adhesion Test** Leather Cloth to Leather Cloth 35 N / 25mm (20°C) 25 N / 25mm (120°C)

**90° Peel Adhesion Test** Leather to Steel 20 N / 25mm — substrate failure (Leather)

**90° Peel Adhesion Test** Leather Cloth to Steel 30 N / 25mm

**180° Peel Adhesion Test** Leather to Steel 20 N / 50mm — substrate failure (Leather)

**180° Peel Adhesion Test** Leather Cloth to Steel 50 N / 50mm

**180° Peel Adhesion Test** Leather Cloth to Wood 75 N / 50mm

## **HANDLING & APPLICATIONS**

The general application information presented here is based upon typical conditions determined by Wayside Adhesives Ltd testing. Our recommendations on the use of this product are based on methods believed to be reliable. It is advised that users conduct their own tests to determine the suitability of the product for their specific application.

### **Process Step Guidelines**

**Surface Preparation** Mechanical abrasion is advised when using non-porous substrates such as metals, plastics etc. All surfaces to be bonded should be dry, clean and free from dust, grit, wax, grease or oil.

**Adhesive Application** Using a suitable spray delivery system, apply an even coat of HTA100WB adhesive to both substrates that are to be bonded. Ensure that spray equipment is free of copper and brass pipework or fittings.

Non-porous substrates (e.g. metal, plastics) – two to three thin layers should be applied, allowing 10 to 15 minutes in between coats. Porous substrates (e.g. wood, leather) – two to three layers should be applied, allowing 5 to 10 minutes in between coats. Allow the final coat to achieve a touch dry state. Assemble the bond and consolidate with pressure to assure a good contact across the bond line. The use of a nip-roller is recommended for ensuring optimum contact is achieved across the bonded area.

**Curing** The bonded assemblies will have enough strength for moving, machining and trimming within 15 minutes depending upon the porosity of the substrates. Bonded assemblies should be left for 24 hours before physical testing is conducted.

**Cleaning** For wet material, it is advised that any spillages be cleaned up immediately with soapy water before the adhesive can fully dry.

## **HEALTHY & SAFETY INFORMATION**

**HTA1000WB** is not classified as hazardous according to Directive EC 1272/2008.

### **STORAGE**

HTA1000WB should be stored in its original container, with the lid tightly secured, in dry conditions and at temperatures between 5°C and 25°C. Will keep satisfactorily for up to 6 months from date of manufacture if stored according to the recommended conditions.

### **PRODUCT AVAILABILITY**

Product Reference Pack Size Container Box Quantity 1 X 20L

Wayside Adhesives Ltd [www.waysideadhesives.com](http://www.waysideadhesives.com) [info@waysideadhesives.com](mailto:info@waysideadhesives.com) 0115 9 333 321