



## HTA1000 – Technical Data Sheet

### PRODUCT INFORMATION

HTA1000 has been developed as a multi-purpose contact adhesive where high strength and heat resistant performance is desired. It is an easily applied adhesive with short open time that forms strong and permanent contact bonds. The combination of fast drying, long tack life and excellent hot strength make it an ideal choice for automotive trim bonding.

### KEY INFORMATION

- **Multi-purpose contact adhesive**
- **Excellent high temperature performance**
- **Excellent bond strength**
- **Short open time**
  
- **Easy to use**

### TYPICAL APPLICATIONS

HTA1000 is suitable for the following applications:

- Laminate materials (e.g. Formica, Waverite, Melamine) to wood
- Polyurethane foams or mineral wool panels to plasterboard
- Painted or unpainted metals to most surfaces
- General purpose adhesive for wood, rubber, most plastics, fabrics, cork, linoleum and rigid PVC

### PRODUCT CHARACTERISTICS

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

Property Data Colour Yellow
Base Polychloroprene rubber

Consistency  
Liquid

Specific Gravity (20°C)  
0.880

Total Solids Content  
26.0-30.0 %

Viscosity (20°C)  
5,500 – 6,500 cP

Heat Resistance  
up to 120°C

Open Joint Time  
7 to 20 minutes\*

Coverage  
3 – 4 m<sup>2</sup> of bonded material / 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

180° Peel Test  
Cloth-backed PVC Leather to Painted Steel  
50N/25mm, 7 days testing at Room Temperature

180° Peel Test  
Cloth-backed PVC Leather to Painted Steel  
50N/25mm, 7 days testing at 100°C

180° Peel Test  
Cloth-backed PVC Leather to Painted Steel  
20N/25mm, 72 hours testing at 100% R.H.

## 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

All substrates must be clean of any dust, grit, loose material, wax, grease and oil using Wayside Cleaner or a suitable cleaner. The materials to be bonded should be dry.

##### Adhesive Application

###### TWO-WAY STICK

1. Stir before use. Using a brush or spreader, apply a thin even coating of adhesive to both of the surfaces.
2. Allow the solvent content to evaporate before bonding the materials (touch dry) . The time for this evaporation will depend on the temperature and humidity.
3. Bond the materials under firm pressure.
4. Dried coatings of HTA1000 may be reactivated by wiping over the surfaces with Wayside Solvent. Alternatively, HTA1000 may be treated with infra red heat, exposing one surface at  $95^{\circ}\text{C} \pm 5^{\circ}\text{C}$ .

##### Curing

The immediate high contact bond strength increases appreciably within the next 48 hours and will develop still further in service. For the best heat resistance, leave at room temperature for 7 days, before subjecting to high in-service temperatures up to  $120^{\circ}\text{C}$ .

##### Cleaning

Wayside Cleaner should be used to remove residues from surfaces.

## HEALTH & SAFETY INFORMATION

HTA1000 is classified as hazardous according to Directive EC 1272/2008. Please refer to the HTA1000 Safety Data Sheet for further health & safety information.

## STORAGE

HTA1000 should be stored in its original container, with the lid tightly secured, in dry conditions and at temperatures between  $5^{\circ}\text{C}$  and  $25^{\circ}\text{C}$ . HTA1000 will keep satisfactorily for up to 18 months from date of manufacture if stored according to the recommended conditions.

## PRODUCT AVAILABILITY

HTA1000 -205 L Drum

HTA1000 5 L Tin

HTA1000 1 L Tin 12

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