

Apollo (A7002)

One-Way Stick Sprayable Laminating Adhesive

Apollo (A7002) is a non-flammable single-component sprayable polyurethane-based laminating adhesive. It combines high solids content with low viscosity, thus ensuring excellent coverage and fast production throughput. Apollo (A7002) has been developed for applications in the panel manufacturing and laminating industries, where it is required to bond all types of plastic foam and other insulating materials to a wide variety of both flexible and rigid facing materials such as metals, plywood, GRP, etc. It is also suitable for semi-structural applications involving the bonding of metal and plastic sheet to plywood or timber composites. It also cures rapidly at elevated temperatures; Apollo (A7002) will withstand temperatures in the range -30°C to above 150°C for extended periods.

Technical Data

Base	Polyurethane	Tack-Life	n/a
Appearance	Brown or tinted	Open-Time	20 minutes
Temperature Resistance	-30°C to +90°C	Shelf Life	3 months
Coverage	9-17m ² /L approx.	Storage	5-25°C
Application Temperature	5-25°C	Health & Safety	See MSDS
Viscosity	100-200cps	Cleaner	Solvent 3 or 6

Instructions for Use:

APPLICATION - Spraying

1. The adhesive is applied by conventional air-spray, air-mix or airless equipment to one surface only of each glue line.
2. The amount required will vary according to the porosity of the substrate and will normally be in the range 30-160 grams (dry) per square metre.
3. The adhesive has been specially developed for use on high speed automatic lines and the solvent system is designed to keep solvent retention to a minimum. However, when very rapid cure times are required the coated panels should be passed under infra-red or hot air heaters for several seconds prior to assembly.

APPLICATION - Pressing

1. Once the adhesive has been applied, the panel should be assembled and pressed within 20 minutes. The pressure should be even and sufficient to keep the components in intimate contact (normally 5-10 psi) and should be maintained for at least 60 minutes.
2. Such pressure may be obtained using a platen press or air bag but a vacuum table normally proves most suitable. Provided they are flat and a similar size, several panels may be pressed simultaneously in a stack. The open and press times depend on the temperature and humidity, the figures quoted being for 20°C, 50% R.H.



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General Notes:

- At temperatures below 15°C, cure times become inconveniently long and this should therefore be regarded as a practical minimum working temperature.
- Using heated presses, it is possible to achieve cure times of as short as 2 minutes at 70°. Pressing at such temperatures is, however, only suitable for panels with identical facings or those which have similar thermal expansion coefficients.
- Two-ply or unbalanced panels should not be pressed above 30°C or excessive bowing will result.
- A slower curing version of Apollo (A7002) is available. This has an open time of about 40 minutes (thus allowing a number of panels to be prepared before pressing), and a press time of about 90 minutes at 20°C, 50% R.H.

IMPORTANT NOTES

Storage and handling: The product should be stored unopened in a dry condition at a temperature of 5-25°C. This will ensure the stated shelf-life. The adhesive will have a limited life once the container is opened.

Temperature and timings: All information on temperature and timings represent normal working conditions and is provided as a guideline only. However, please contact Apollo for advice if you wish to operate outside of these parameters.

Disclaimer: Apollo has taken care to ensure that the information provided in the literature is correct and up to date. However, it is not intended to form any part of a contract or provide a guarantee. Purchasers/intending purchasers should contact Apollo to check whether there have been any changes to the information since publication of the literature. Please ensure you have read the hazard labels and material safety data sheet before using this product.



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