

C5100 – Technical Data Sheet



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Description

C5100 is a general-purpose contact adhesive based on polychloroprene rubber. It is suitable for use in a wide range of internal applications, forming strong, permanent bonds to a wide variety of materials.

C5100 adhesive forms a strong permanent contact bond between the following materials: laminates (e.g. Formica, Melamine), wood (e.g. MDF, plywood, hardboard), rubber, most plastics, metals, fabrics etc.

Key information

- General purpose
- Bonds to a wide variety of materials
- Easy to apply
- Short open time

Typical Uses

C5100 adhesive forms a strong, permanent, contact bond between the following materials:

- Bonding laminate materials (e.g. Formica, Waverite, Melamine) to wood
- Interior trimming in the automotive, marine and transportation industries
- All purpose adhesive for wood, rubber, most plastics, fabrics, cork etc.

Technical Data

Colour	Yellow
Base	Polychloroprene
Consistency	Liquid
Specific Gravity (20°C)	0.845
Total Solids Content	19-21%
Viscosity (20°C)	4000-5000 cP
Heat Resistance	Up to 70°C
Open Joint Time	6-25 minutes*
Coverage	2-3 m ² of bonded material / litre*

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

Product Performance

The performance data presented here 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 wood	> 20N / 50mm
180° Peel Test	Cloth-backed PVC leather to painted steel	> 20N / 25mm

Handling and Applications

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 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. Bring the surfaces together (avoid any trapped air bubbles) and apply as much pressure as possible to the whole area. The use of a hand roller is recommended.
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 100°C.
Cleaning	A suitable cleaner, such as C1013, should be used to remove residues from surfaces.

Precaution

- C5100** is classified as hazardous according to Directive EC 1272/2008. Please refer to the C5100 Safety Data Sheet for further health & safety information.
- Stored in well-sealed containers, **C5100** will keep satisfactorily for up to 18 months, from date of manufacture. **C5100** must be protected from frost and stored between 5 – 25°C.

Please consult the C5100 Health & Safety Data Sheet for statutory regulation information.

Information relating to the products of Bondrite Adhesive Limited is based on tests carried out under laboratory conditions. If any of our products are not used in accordance with our instructions or are used under conditions which vary from our laboratory, they may not perform in accordance with any information provided and Bondrite shall not have any liability in this case. Bondrite will accordingly provide samples of our products, on request and free of charge, for Customers to carry out their own tests as to suitability of our product for their purposes and as used in their intended environment.

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