

## C5006 – Technical Data Sheet



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### Description

**C5006** has been developed specifically for post-forming operations, including the manufacture of counter tops, kitchen worktops and desks.

**C5006** is a high-strength sprayable contact adhesive that offers the manufacturer many benefits:

- Ideal for post-forming of decorative laminates onto chipboard and MDF cores using a range of both static and continuous equipment. This is due to its hot-bond strength, high heat-resistance and fast drying properties. The hot-bond strength and high green-strength also make **C5006** perfect for the post-forming of edge details.
- Allows for flexibility in the manufacturing process - Its high initial bond strength allows the immediate handling of materials without clamping, whilst its long open-tack-life provides you with the flexibility you may need to account for unforeseen delays.
- Extremely economical and efficient - The very nature in which **C5006** is applied, i.e. spraying, is extremely economical. Spraying **C5006** allows an excellent coverage rate, with minimal mess or waste. It also enables a rapid application time, which helps to improve production efficiency.

### Physical Properties – Component A

<b>Base</b>	Polychloroprene
<b>Colour</b>	Neutral or tinted
<b>Temperature Resistance</b>	-30 to 90°C
<b>Coverage</b>	8-10m <sup>2</sup> /litre
<b>Application temperature</b>	5-25°C
<b>Viscosity</b>	200-300cps (20°C)
<b>Solids</b>	16-20%
<b>Tack-life</b>	2-10 minutes
<b>Shelf Life</b>	6 months
<b>Storage</b>	5-25°C
<b>Health and Safety</b>	See MSDS
<b>Cleaner</b>	C1013

### Directions for Use

1. Surfaces to be bonded should be clean, dry and free from loose particles dust and grease.
2. **C5006** may be sprayed through most equipment, but for best results a 'Devilbiss JGV-562' gun fitted with FX fluid tip and needle, and a 777 air-cap is recommended. Atomising pressures of 50-80psi and fluid pressures of 10-30psi are required.
3. Apply an even coat of adhesive to both surfaces to be bonded at a coat weight of 30-40 grams per square metre (dry). Allow a minimum of 2 minutes before mating surfaces.
4. Ensure intimate contact and coalescence of the adhesive films by passing the laminate through nip rollers or by platen pressing, using as much pressure as possible without crushing the components. Sustained pressure is not necessary. The high initial strength of the adhesive allows panels to be handled immediately.

## **Precaution**

1. Store at temperatures above 5°C (40°F). Prolonged storage at lower temperatures may cause the formation of a 'gel', which will then necessitate re-processing.
2. In conditions of high humidity, a 'bloom' may form on the surface which reduces tack and coalescence. Bonds should not be made when this occurs.

### **Please consult the C5006 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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