

TYPE OF ADHESIVE:

Solvent-based Rubber Solution

FIELD OF APPLICATION:

General Contact Adhesive

TYPICAL TECHNICAL DATA:

Viscosity: 250 cps

Solids: 18.0%

Color: Natural

Density: 6.8 lbs/gallon

Coverage: 185 sq. ft./gallon

Open time: 1 hour

VOC: 594 g/L

PROPERTIES:

- ⊕ Excellent adhesion to a variety of substrates including, but not limited to laminates, particle board, plywood, hardwood, leather, rubber, and metal
- ⊕ Excellent room temperature contactability
- ⊕ Excellent green strength and high heat resistance
- ⊕ Excellent sprayability (hot or cold spraying)

HANDLING AND APPLICATION:

Do not use in applications with copper or aluminum components. Beware of "blushing." This phenomenon generally occurs when the ambient humidity is high. The evaporation of solvent from the substrates causes the temperature in the immediate area to drop. When the temperature reaches the dew point, moisture will collect on the surface of the adhesive. This moisture layer both prevents complete evaporation of the solvent and creates a barrier between the mating adhesive surfaces. Slight air movement over the substrates is the best method for preventing blushing. After the moisture is removed from the adhesive surface, the solvent will finish evaporating and the bond can be made. Thoroughly agitate the adhesive before use. Because some adhesive components may settle during shipping and storage, stirring the adhesive is recommended. This agitation will ensure optimum adhesive performance by creating a uniform solution. Recommended Cleaning Solution: 689 Solvent.

PRECAUTIONS:

Do not mix with other adhesives. Thinning the adhesive is not recommended. **Please refer to the Material Safety Data Sheet for further information.**

STORAGE CONDITIONS:

Rotate stock, use oldest first. 180-day shelf life. Keep covered to prevent solvent loss and contamination. Do not freeze. Do not store at high temperatures.

PROPER APPLICATION OF CONTACT ADHESIVE

1. Agitate adhesive before use.

2. Substrates should be clean and free of moisture, dirt, oil and other contaminants.
3. For best results, adhesive and substrates should be allowed to acclimate to room temperature (approximately 60oF or above) before adhesive application.
4. The adhesive should be applied at approximately 3.0 grams/square foot. The adhesive should cover 80% of the substrate surface. The substrate surface should exhibit a uniform glossy sheen when the adhesive is completely dry. Dull areas indicate insufficient coverage. Adhesive should be reapplied to these areas.
5. When bonding porous substrates, it is advisable to apply two coats of adhesive. The first coat will act as a sealer and prevent excessive absorption of adhesive into the substrate. After the first coat has dried, apply a second coat. Allow the second adhesive coating to dry completely before assembly.
6. Allowing the contact adhesive to dry completely before assembly is essential to obtaining a secure, permanent bond. To check for adhesive dryness, press the back of your fingers onto the adhesive surface. If adhesive transfers to fingers, additional dry time is necessary. If there is no adhesive transfer, the substrates are ready for bonding.
7. If areas exist with excessive adhesive deposition, twist the fingers while pressing them onto the adhesive layer. This will break any skin that may have formed as the adhesive dries from the top surface down. If a skin has formed, allow additional dry time to ensure complete evaporation of the solvent before bonding.
8. Dry times can be improved through the use of air movement, drying ovens, lamps, etc.
9. Substrates may be indexed together and bonded once the adhesive is dry. Bonds must be made within the open time of the adhesive. (Open times vary by adhesive. See specification on Page 1.)
10. Uniform pressure on the bonded laminates is necessary to create strong, lasting bonds. 40 pounds per linear inch is recommended to ensure complete fusion between the two layers of adhesive. A pinch roller is the ideal method for applying uniform pressure. When used properly, a J-roller can also provide sufficient pressure for bonding.
11. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed and machined.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as



LOCTITE S 565

Formerly known as
DORUS S 565

July 2013

may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

Except as otherwise noted, all marks used are trademarks of Henkel or its affiliates in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Henkel Corporation

Tel: 1.888.480.6889

Email: bw.nacustomerservice@henkel.com

www.henkelna.com

