
EVO-STIK 584

SOLVENTED CONTACT ADHESIVE

EVO-STIK 584 is a single part solvented contact adhesive that has been specially developed for bonding expanded polystyrene. Easily applied **EVO-STIK 584** exhibits fast drying and has a long open time, its initial bond strength allows for immediate handling of assemblies, the resulting bonds involving cellular plastics will generally prove stronger than the cellular components themselves.

RECOMMENDED USE

EVO-STIK 584 has been developed for bonding expanded polystyrene and other rigid and semi rigid cellular plastics to themselves and many other substrates. The solvent system used has no detrimental effects on polystyrene or other expanded materials if used in accordance with the instructions given below.

EVO-STIK 584 is intended for bonding thermal insulation materials in general building construction, in cold storage installations and in refrigeration & chemical plant etc.

BONDING INSTRUCTIONS

SURFACE PREPARATION

- Substrates to be bonded should be perfectly clean dry and free from dust and grease.
- Smooth or polished surfaces should first be roughened with fine abrasive.
- If degreasing is necessary, a detergent/water treatment should first be considered. If this is inappropriate a suitable solvent e.g. cleaner 5 may be used. It is advisable to check the effects of degreasing solvents on plastics, rubber materials and painted surfaces before carrying out the operation. All traces of cleaning solvents must be allowed to evaporate completely before application of the adhesive.

APPLICATION

- **EVO-STIK 584** can be applied by brush or serrated trowel or spreader.
- Apply a thin even film of adhesive to both surfaces to be bonded. Ensure coverage is adequate, and allow to dry until all the solvent has evaporated, when the adhesive will still be sticky.

DRYING

Drying time depends on film thickness, surface porosity, temperature and humidity but is usually in the region of 15 minutes.

BONDING METHOD

- The two adhesive coated surfaces should first be carefully aligned, then brought into contact and pressed firmly together over the whole bond area.
- Apply as much pressure as possible by hand roller, static press or nip roller without causing damage. Sustained pressure is not necessary.

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- Bringing the surfaces together before the surfaces are touch dry will result in solvent being trapped, adversely affecting the final bond, and possibly giving rise to blistering problems.
- The initial bond strength allows immediate handling, but maximum bond strength is reached after 2 - 3 hours at normal temperatures.

GENERAL PRECAUTIONS

- Do not add anything to the adhesive to modify its properties.
- After each use, close the container tightly in order to avoid solvent evaporation.

TYPICAL CHARACTERISTICS

Physical Form:	Moderately viscous liquid
Colour:	Pale yellow
Chemical Type:	Synthetic rubber/resin blend
Solvent:	Aliphatic Hydrocarbon
Viscosity (Brookfield RVT, 10rpm at 25°C):	Approx. 2750 mPas
Solids Content:	Approx. 29%
Specific Gravity:	Approx. 0.76
Flammability:	Highly flammable

PACKAGING

5 litre tin (code No. 744752).

STORAGE

Store in accordance with the requirements of the petroleum regulations in a dry flameproof area between 5 and 25°C.

SHELF LIFE

12 months in its original container stored under the above conditions.

MATERIAL SAFETY DATA

For further information refer to the relevant Health and Safety Data Sheet.

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