



# EVO-STIK TX 528

## THIXOTROPIC SOLVENTED CONTACT ADHESIVE

Date: 29 September 2015

Fact Sheet No.: TDS00019

### YOUR SMART ADVANTAGES

- High initial grab, with excellent final bond strength
- Non-drip, non-stringing formulation
- Ideal for vertical and overhead surfaces

### USES

EVO-STIK TX 528 Thixotropic Contact Adhesive is a general purpose, contact adhesive, which is clean and easy to apply. Being non-drip, it is ideal for use on vertical as well as horizontal surfaces. The resultant bonds have excellent strength and good temperature resistance.

It is particularly suitable for bonding decorative plastic sheets and other rigid plastics such as PVC and ABS to wood, metal and wood composite boards. It may also be used to bond cane fibre boards and acoustic tiles to suspended or vertical surfaces such as dry cement/sand renders. Most types of plastic nosing and coving may also be bonded.

### PRODUCT CHARACTERISTICS

Colour	Translucent amber
Form	Thixotropic gel
Specific Gravity	Approx. 0.84
Composition	Blend of polychloroprene rubber and synthetic resins, in a mixture of petroleum solvents.
Product Code	30603375 1 Litre x 12 30812991 5 Litre x 1

Storage/Shelf Life	Store for up to 18 months from date of manufacture when stored in original, unopened packaging under dry conditions within the temperature range of +5°C to +25°C.
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Odour	Sweet hydrocarbon
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### TYPICAL PERFORMANCE DATA (Approx.)

Application Temperature	+5°C to +30°C
Service Temperature	-40°C to +65°C
Coverage	4 - 6m <sup>2</sup> per litre per coat. Depending upon surface type.
Drying Times	Porous surfaces : 15 to 20 minutes Non-porous surfaces: 25 to 35 minutes Dependent upon film thickness, surface porosity and ambient conditions.
Open Time	Up to 45 minutes

### DIRECTIONS FOR USE

Before using EVO-STIK TX 528 Thixotropic Contact Adhesive refer to the relevant Health & Safety Data Sheet, available at [www.bostik.co.uk](http://www.bostik.co.uk).

### PREPARATION

1. EVO-STIK TX 528 Thixotropic Contact Adhesive is not gap-filling. Surfaces must be flat and close fitting.
2. Substrates to be bonded must be perfectly clean, dry and free from dust and grease. If degreasing is necessary, use EVO-STIK Adhesive Cleaner. Always check the effects of the solvent on sensitive substrates such as plastics and rubber. Do not use petrol, diesel or white spirits as they leave an oily surface.



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- Smooth or polished surfaces must first be roughened with fine abrasive paper or pad.
- Excessively porous surfaces soak up the adhesive and lead to the risk of poor bonding. In such cases, prime with some of the adhesive diluted 50 : 50 by volume with EVO-STIK Adhesive Cleaner. Allow to dry completely before proceeding as below.

#### APPLICATION

- Apply an even ribbed coat of adhesive to both surfaces using a serrated trowel or spreader. For correct coverage use the spreader at an angle to give good rib formation after drying. Work in warm, dry and well-ventilated conditions. Cold and or high humidity will lead to poor drying and hence a poor bond.
- Allow the adhesive to become just touch dry. The drying time will depend upon film thickness, surface porosity, temperature; humidity and ventilation. In good conditions the approximate drying times for porous surfaces are 15 to 20 minutes and for non-porous surfaces 25 to 35 minutes.
- For best results bring the two dry, coated surfaces into contact within 10 minutes of the adhesive films becoming 'touch dry' and press together over the entire bond area. Apply as much pressure as possible by hand or roller. Sustained pressure is unnecessary.
- 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.
- Bonding too late will leave large areas un-bonded which will later give rise to blisters, due to differential movement.
- A bond is formed as soon as the two surfaces touch. It is hence essential with large areas to avoid contact before the parts are in alignment.
- The initial bond strength allows for immediate handling of the assembly, but maximum bond strength is reached after approx. 24 hours at normal temperatures.

#### CLEANING

- Remove as much of the adhesive as possible by mechanical means.
- The remainder of the adhesive can be removed using a cloth dampened with acetone or EVO-STIK Adhesive Cleaner.
- Always check if the cleaning solvent might damage a nearby surface by testing.

#### PRECAUTIONS IN USE

Highly flammable. The adhesive is unsuitable for use with expanded polystyrene or non cellulose painted surfaces, due to solvent attack. Do not use on soft PVC or vinyl plastics as the bond degrades, by softening, over time. Clamping is not necessary. Do not use on or near bituminous substrates. It will not bond polyolefins such as polyethylene and polypropylene. Avoid uneven application of the adhesive as this will lead to some areas being too dry whilst others are still wet. This will reduce the final bond strength.

For any application not covered please contact Technical Services on +44 (0)1785 272625 or visit [www.bostik.co.uk](http://www.bostik.co.uk) for advice.

Recommendations and suggestions are for guidance only, since conditions of use are completely beyond our control.

For health and safety instruction, first aid measures and spillage and disposal instructions, see separate Health and Safety Data Sheet for EVO-STIK TX 528 Thixotropic Contact Adhesive, available at [www.bostik.co.uk](http://www.bostik.co.uk).

BOSTIK HOTLINE

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