

Technical Instruction Sheet

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Characteristics: AKEMI AKEMIX 15 is a solvent-containing, 1-component contact adhesive based on polychloroprene. The product is distinguished by the following qualities:

- good resistance to ageing
- high stability to heat (up to approx. 90°C)
- spread easily due to moderately viscous consistency
- high bond strength (shear strength)
- good resistance to humidity

Field of Application: AKEMIX 15 is an adhesive for universal use in industry, trade and hobby for bonding polyurethane-elastomer, foam, latex, felt, carpets, linen, rigid and flexible PVC, natural rubber, butyl caoutchouc, synthetic rubber, plastic laminating plates and cardboard as well as wood, steel, aluminium and stone. The product is not suited to bond expanded polystyrene, polyolefin (e.g. polyethylene) and PTFE.

Instructions for Use:

1. The surface to be treated must be free from rust, grease and dust. We recommend to slightly roughen smooth surfaces and to clean them with AKEMIX 15 - Dilution before bonding.
2. Stir up well; thickened adhesive can be diluted with AKEMIX 15 - Dilution.
3. Apply adhesive with a brush or a spatula:
 - a) for vapour-permeable material: apply adhesive only to one part and immediately press both parts to be bonded together.
 - b) for vapour-impermeable material: apply adhesive to both parts, allow to dry for about 10-50 minutes and press both parts together. The film must still be sticky, but not stick to the finger.
4. After complete drying of the adhesive it is also possible to bond at a temperature of 60-80°C.
5. The hardening process is accelerated by heat and delayed by cold.
6. Tools can be cleaned with AKEMIX 15 - Dilution.

Special Hints:

- Use AKEMI Liquid Glove to protect your hands.
- Hardened adhesive can be removed with AKEMIX 15 - Dilution.

Safety Measures: see EC Safety Data Sheet

Technical Data:

Colour:	golden-brown, opalescent		
Density:	0.88 g/cm ³		
Viscosity:	1200-1600 mPas		
Thermal stability:	approx. 90°C		
Shear strength	-20°C: 8.0 N/mm ² }		
	0°C: 7.5 N/mm ² }		after 3 days at RT
	+20°C: 4.7 N/mm ² }		
Peel strength:	10.0 N/mm ²		after 24 hrs at RT
Shelf life:	1 year approx. if stored in cool place free from frost in its tightly closed original container.		

Notice: The above information is based on the latest stage of technical progress. It is to be considered as a non-binding hint and does not release the user from a performance test, since application, processing and environmental influences are beyond our realm of control.