

## Foam bonding adhesive

# 471.50/54

**Application:** Styrene copolymer adhesive for bonding foam material, also moulded foam and upholstery wadding to each other, as well as to wood, hardboard, chipboard, cardboard, rubberized hair and similar upholstery materials.

**Also for expanded polystyrene.**

**Characteristics/ Directions for Use:** Good spraying performance, one-sided application is possible, very good initial adhesion, practically no post-tack, good heat resistance, minor odour. One-sided application is sufficient, but application to both surfaces is also possible.

To be processed from cup spray gun or from pressurized container or barrel pump directly or via a circulation system. Avoid all contact of pressurized container, pump and ductwork with zinc or galvanized metals and their alloys. The adhesive reacts aggressively with the metal and can no longer be used.

Material pressure [bar]:	0.5 – 3
Spray pressure [bar]:	4 – 6
Nozzle Ø [mm]:	1.0 – 1.5
Open time [min]:	one-sided: 1 – 7 two-sided: 1 – 25

Tested according to Jowat test methods.

Processing temperature:

The processing temperature of the adhesive and of the parts to be coated should be between 15 – 25 °C.

<b>Technical Data:</b>	Viscosity [mPas]:	approx. 300 (Hoeppler)
	Solid content / Jowat method [%]: (amount 2 g/90 °C/120 min)	approx. 50
	Solid content / EN 827 [%]: (amount 1 g/105°C/120 min)	approx. 50*
	Density [g/cm <sup>3</sup> ]:	approx. 0.88
	Appearance:	final digit 0 = colourless final digit 4 = red

\* no release specification

**Cleaning:** Jowat® Cleaner 403.40

**Storage:** May be stored for 6 months after date of delivery ex production site, in properly closed original containers, cool and dry.

**Packaging:** Types of packaging and units upon request.

**Remarks:** For further information concerning handling, transport and disposal, please refer to the Safety Data Sheet.

Our information on this data sheet is based on test results from our laboratories as well as on experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding for us. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from these indications nor from the recommendations made by our free technical advisory service.

03/13 All data indicated are characteristics represented as average values. Our technical data sheets are constantly revised to represent the latest state of technology. This edition is replacing all previous ones, and is valid on the date of compilation.  
**Please turn this page for additional information.**

**Jowat**  
Klebstoffe



## **Jowat Information**

Glueing as one of the most efficient methods of bonding is constantly gaining importance and expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are developed.

The in-house R & D departments of the Jowat AG are responding with intensive efforts to keep pace with these constant changes. A highly qualified team of chemists and engineers is using the latest techniques and brightest ideas to provide the utmost in advice our customers and to make sure that they get the adhesive which meets their needs.

Our information is based on test results from our laboratories as well as on experience gained in the field by our customers. This advice, however, cannot cover all eventualities for each specific application and as such is not binding for us. Please, contact our technical service department in each case to find out what the actual technical state of development for the respective product is, and request the latest data sheet. Any use of our product without this precautionary measure would be your sole responsibility.

The processing company itself must therefore test the adhesives manufactured by us for suitability in each individual case. This applies to the first use of a sample as well as to modifications during an ongoing production.

We are therefore requesting all our new customers to test our adhesives for suitability on original parts at conditions equal to normal processing conditions. The bond has then to be subjected to the actual stress which it would undergo when in use and has to be assessed. This test is absolutely necessary.

Customers who undertake modifications during a running production are requested to pass this information on to us. Please notify us when machines are set to new parameters as well as when the substrates to be bonded are changed. Only then will the Jowat AG be able to provide our most up-to-date information to the processor using our adhesives.

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