

Technical Data Sheet

Zeluflex 4745/1

1 Description

Zeluflex 4745/1 is a solvent containing adhesive based on polychloroprene (PCR) and used in the manufacturing industries of seatings, automotive and pipe insulation. It can also be utilized for bonding foam blocks and moulded foam or to bond textiles, wood, pasteboard, jute and other materials. It is free of toluene. The adhesive enables an equal spraying pattern and has a high initial tack. The seam of the adhesive is very soft and elastic. Zeluflex 4745/1 has high heat-and light resistances and good aging properties.

2 Technical Data

Basis	Polychloroprene rubber
Solid content	17 – 19%
Density	approx. 0.84 g/cm ³
Viscosity	approx. 450 mPa·s
Color	colorless, red
Pretreatment	Substrates must be clean and free from oil and grease
Nozzle size	1.5 – 2.0 mm
Material pressure	0.5 – 2.0 bar
Atomizing pressure	4 – 6 bar
Recommended application temperature	15 – 25 °C
Open time (two side)	approx. 30 min
Heat resistance	approx. 170 °C (depending on stress)
Final strength	after at least 24 h
Cleaning agent	Lösungsmittel AF

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3 Application

Zeluflex 4745/1 is usually applied on both substrates to be bonded (contact sticking). Spray on both sides and allow the adhesive to dry for 1-2 minutes. The best time for bonding is when the adhesive stops to pull threads when being touched with the fingers but still feels sticky. Open time depends on the applied quantity, application temperature, spraying settings of the spray gun and substrates to be bonded. For bonding, press both surfaces strongly together. The final strength of the adhesive is reached after at least 24 hours.

4 Shelf life

Store in a cool, well-ventilated place. The shelf life is at least 12 months in the original packaging.

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