

## Technical Data Sheet

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# Zelugen S 1579

## 1 Description

Zelugen S 1579 is used to bond foils of soft-PVC, ABS/PVC and textile with moulded parts of wood fibre and plastic injection moulding parts in a deep drawing process. Furthermore, this adhesive can be used in the automotive industry (contact adhesive) to bond interiors like sun-roofs, side frames and consoles (edge wrapping).

Zelugen S 1579 is a two component deep drawing adhesive for laminations. It has a fine regular spraying pattern and a high initial bonding strength.

## 2 Technical Data

Basis	TPU
Solid Content	approx. 20%
Density	approx. 0.83 g/cm <sup>3</sup>
Viscosity	900-1000 mPas
Colour	Colorless
Pretreatment	Substrates must be clean and free from oil and grease
Nozzle size	1.0-2.0 mm
Material pressure	0.5-1.5 bar
Atomizing pressure	4-6 bar
Recommended processing temperature	18-22 °C
Open time	approx. 15 min
Hardener	Zeludur 400 (5wt%)

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### 3 Application

Generally, Zelugen S 1579 is applied to both surfaces using a standard spraying gun. However, one-side applications can also be effected but in this case it is absolutely necessary to reactivate the adhesive at a minimum temperature of 70 °C latest after 2-3 hours after application. In the case of contact bonding a flash-off time of one minute should be observed. The open time is from one to 15 minutes. After bonding, press the two parts together (1-3 bar). The hardening process is completed after about 72 h. We recommend the addition of 5wt% Zeludur 400 as curing agent (component 2). This will improve bonding and heat resistance.

### 4 Shelf life

Store in a cool, well-ventilated place. The shelf life in the original packaging is 6 months.

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