

# CONAP AD1147



CONAP AD-1147 are high strength adhesives for bonding liquid urethanes to various substrates during the curing process. These systems are a stable solution of polymers in a solvent blend which requires heat to effect cure.

An extensive evaluation program has shown AD-1147 to be capable of bonding an exceptional variety of inorganic and organic materials together. Bonds to aluminum alloys, magnesium, iron, steel, glass, glass-fiber laminates, wood, and leather have high strength and excellent resistance to hydrolysis and environmental extremes.

	CONAP® AD-1147
Viscosity (cps)	2000
Colour	Amber
Solids Content %	25
Specific Gravity @ 25c	0.90
Weight per gallon (lb/gal)	7.50
Shelf Stability (Months)	12

High strength bonds can only be obtained if all surfaces to be bonded are free of dirt, rust, chemicals, and mould releases. In addition, surfaces to be bonded should be sandblasted, etched, or degreased.

## RECOMMENDED PROCESSING PROCEDURES

Apply one or two coats of AD-1147 with a soft brush, allowing the adhesive to flow on the surface. Application may also be accomplished by spraying, roller coating, or by doctor-blade. Air-dry ½ hour between coats and one-hour or longer after the final coat.

NOTE: For optimum results, primer film thickness should be 0.0005 inches to 0.0015 inches. Under no circumstances should film thickness be less than 0.0005 inches.

Since these coatings contain a solvent, it is important that all residual solvent in the film be removed to obtain high bond strengths. A drying period of ½ hour at 70°C (158°F) is sufficient to accomplish solvent evaporation.

When bonding urethanes to metals, the drying period can be part of the preheat cycle used to bring the mould and part to the desired curing temperature. Preheat temperatures of 90-100°C (194-212°F) for 2 to 3 hours are not detrimental. The adhesion of the urethane to the primer film is excellent, and the adhesion of the primer to the metal is improved.

## HANDLING INSTRUCTIONS

CONAP AD-1147 are stable solutions of polymers in a solvent blend. They do not require agitation prior to use. AD-1147 has a 12 month Shelf Life. The applied adhesive film should not be exposed to temperatures above 150°C (203°F) for excessive periods of time. If this occurs, the film will be converted to the insoluble state and the adhesion of the polyurethane will be reduced. CONAP AD-1147 remain active when normal preheat temperatures for moulds or components are used.

**CAUTION: FOR INDUSTRIAL USE ONLY! THESE PRODUCTS ARE FLAMMABLE AND SHOULD NOT BE USED IN AREAS WHERE OPEN FLAMES ARE PRESENT. USE ONLY IN WELL-VENTILATED AREAS AND WITHIN 12 MONTHS OF SUPPLY. AVOID BREATHING OF VAPOURS AND PROTECT SKIN AND EYES FROM CONTACT WITH MATERIAL. SHOULD SKIN CONTACT OCCUR, WASH IMMEDIATELY WITH SOAP AND WATER. IN CASE OF EYE CONTACT, IMMEDIATELY FLUSH WITH PLENTY OF WATER AND OBTAIN MEDICAL ATTENTION**

The information contained herein is true and accurate, based on laboratory conditions. It is recommended that the user contact the manufacturer to confirm suitability as field conditions may vary and yield different results. Testing of this product is strongly recommended to confirm suitability for specific applications. Data should not be used for specification purposes. DO NOT COMMENCE OPENING / HANDLING RAW MATERIALS WITHOUT: GOOD VENTILATION, SAFETY GOGGLES, RUBBER GLOVES AND FULL SKIN PROTECTION.

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