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SIMALFA® 321

Technical Data Sheet

Adhesive:

SIMALFA® 321 is a solvent-free, pressure-sensitive dispersion adhesive with a water base used for the bonding of foams, upholstery materials and more. The adhesive has an excellent wet sticking property and high flexibility as well as good heat resistance. The adhesive, depending on the grade, is applied to one or both sides by means of low pressure spray gun (HVLPP).

Specifications:

Composition:	Dispersion of Acrylate / CR polymer in water
Appearance:	white or red
Solid content:	approx. 55 %
Density:	approx. 1.06 g/cm ³
pH-value:	8.0 - 9.0
Viscosity:	200 ... 700 mPas (Brookfield RV, Sp. 2, 20 rpm)
Heat resistance:	approx. 80 - 90°C
Application quantity:	approx. 60 - 150 g/m ²
Open time:	approx. 15 min.
Final adhesion:	approx. 1 - 24 hours, depending on the material
Shelf life:	at temperatures +5°C...+30°C, in unopened original packaging 4 month
Cleaning:	Water (ALFA Cleaner is recommended)

The adhesive is sensitive to frost. Temperatures below 0°C destroy the adhesive!

Features:

Extreme good bonding on polyolefins like PP and PE.
Very high initial adhesive strength immediately after spraying without additional drying time, high heat resistance, solvent-free, no hazards, also one-sided applicable, high solid content, non-flammable

Application:

Foam and upholstery industry
Latex foam, polyether foam, PU foam, PE foam, upholstery material, cardboard, felt, etc.

Application equipment:

SIMALFA® Primus, nozzle size 2.0 - 2.5 mm
SIMALFA® G11, nozzle size 2.0 - 2.5 mm
Wetted parts: Stainless steel (V2A) or plastic

Feeding:

Free Flowing System, pressure pot (max. 1.0 bar)

Processing:

Two-sided, one-sided for parts with low tension

Important notice:

The usual precautionary measures have to be taken, the same as when handling chemical products. This includes a well ventilated working place, particularly when larger quantities are processed. For technical data see according safety data sheet. The particulars on this data sheet are based on our present knowledge and experience. Of course each user has to make his own tests when using our products. Our data sheet cannot be considered legally binding in the case of certain material or suitability for all applications. Rules and legislation in each country have to be taken into consideration and we cannot be held responsible for local regulations unknown to us. In the case of inconsistencies between different translations, the German version shall prevail.

V 11.1 | 21.03.2018