



Technical Data Sheet

Anchor-Weld™ 1830/1831

Spray Grade Polystyrene Adhesive

Description

Anchor-Weld™ 1830 / 1831 Adhesive is a spray grade adhesive specifically formulated for bonding expanded polystyrene foam and other lightweight materials used in the insulation and air conditioning industries. It has excellent green strength, flexibility and good heat resistance.

Anchor-Weld™ 1830 / 1831 Adhesive can be used with steel, aluminium, galvanised iron, wood, hardboard, particleboard, cement sheet, concrete, masonry, expanded polystyrene, insulation batts and fibreglass reinforced plastics.

Features

- Rapid drying
- Polystyrene foam safe
- Excellent sprayability



Application Instructions

**Ensure adequate tests are conducted before using commercially.
Mix thoroughly before each use.**

Surface Preparation

Surfaces must be clean, dry and free from oil, dust and other foreign materials. Clean metals with Anchor-Weld™ 901 Cleaner/Thinner before applying adhesive as mill process oil is often found on rubber and plastic sheet and castings.

Application

1. Apply by conventional air assisted spray equipment.
General spray gun recommendations:
Tip size: 1.4 mm minimum
Fluid pressure: 30 – 50 psi
Atomizing air pressure: 35 – 70 psi
Fine Spray: 60-70psi
Course Spray: 35 – 50psi
2. Spray adhesive to one surface at a rate that gives satisfactory adhesion. For best results, spray both surfaces (contact bond method) and ensure the spray pattern is uniform and gives complete surface coverage. **For sandwich panel construction, adhesive coverage should be 165 to 250 grams per square metre, wet, ON EACH SIDE.**
3. Allow the adhesive to partially dry so it tacks up. This may only take 30 seconds, depending on the ambient temperature and air movement.
OPEN TIME: 5 minutes maximum, depending on amount of adhesive applied and ambient temperature. More adhesive and lower ambient temperature will extend drying time and open time.
Special precaution for polystyrene: Do not apply excessive adhesive and do not trap wet adhesive between the surfaces, otherwise a small degree of styrene deformation can occur, resulting in a failed bond.
4. Mate the surfaces together before the adhesive has gone tack free, and ensure that the laminate is adequately nip rolled or contacted with sufficient pressure to wet the adhesive onto the other surface. **A MINIMUM contact pressure of 175kPa (25psi) is required for adequate adhesion, especially for sandwich panel construction.**

Limitations

- Not suitable for polyethylene or polypropylene plastic
- Not recommended for bonding laminates or post-forming applications



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Properties

Type	Synthetic Rubber / Resin
Colour	Light Yellow / Blue
Solids Content	Approx 30%
Viscosity	Medium to thin consistency
Tack Up Time	1 –5 mins @20°C
Touch Dry	Approx 5 –10 mins @20°C

Storage & Shelf Life

Store in a cool, dry place, out of direct sunlight and away from all sources of ignition. Storage areas must be well ventilated and comply with Local, State and Federal regulations. For maximum shelf life, store between 5° and 20°C.

Shelf life is up to 12 months when stored in original, unopened containers, under the above conditions.

Health & Safety

Please refer to the Material Safety Data Sheet which is available on request. The solvents contained within this product are Highly Flammable.

Clean-Up

Use Anchor-Weld™ 850 Cleaner/Thinner to clean up equipment and excessive adhesive. Coloured adhesive may cause staining on light coloured upholstery fabrics/materials.

Product Details

Item Number	Size	Colour	Pack Quantity
155888	Anchor-Weld 1830 Adhesive 20 L	Clear	
155896	Anchor-Weld 1830 Adhesive 200 L	Clear	
162760	Anchor-Weld 1831 Adhesive 20L	Blue	
162779	Anchor-Weld 1831 Adhesive 200L	Blue	

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