Kaiflex adhesive 414 Technical Data

Description	Special adhesive for use with all Kaiflex flexible insulation-systems (excluding Kaiflex EPDM). Perfect adhesion on metallic priming, no adhesion on asphalt, bitumen or lead oxide red coatings (linseed based oil). Contact adhesive – Polychloroprene based, free of aromatics.	
Application range	Kaiflex adhesive 414 is specially formulated for bonding Kaiflex flexible insulation systems (excluding Kaiflex EPDM). It is also ideal for use with other closed cell elastomeric rubber insulation (NBR) material	
Base	Synthetic modified rubber (Chloroprene rubber).	
Colour	yellow-red	
Solid %	18 ±2 %	
Service Temperature	Ideally + 20°C, do not use under 0°C. At temperatures lower +5 °C or relative humidity over 80 % condensate can occur to a heightened degree on the surfaces to be bonded or on the adhesive film.	
Temperature resistance	Up to +110 °C	
Characteristics / Application	Stir up appropriately before use. Easy to spray, very good initial adhesion, good thermal resistance. Apply on both sides with brush or oder air brush. Flash-off time: 5 -20 minutes. After adherence press surfaces firmly together	
Viscosity	ca. 600 mPas (Höppler)	
Density	ca. 0.85 g/cm³	
Cleaning	Kaiflex Cleaner	
Storage	Store dry, cool and frost-free (+15 to +23 °C) in tightly sealed original can	
Shelf Life	Shelf life is up to 12 months in an unopened container when stored as directed. Failure to comply with the recommended storage conditions may result in premature deteriration of the product or packaging. Please, follow the petroleum regulation and law of the land.	
Application	Before use adhesive should be thoroughly stirred. Surfaces to be adhered together must be clean, dry and free of any dust or grease. Use a brush with short stiff bristles (e.g. Kaiflex brush can). Apply a thin even layer of adhesive to both surfaces. Allow the adhesive to become dry to touch. This will take 2 to 8 minutes, depending on ambient conditions. The drying time of adhesive will be adversely affected with high humidity (greater than 85 %) and low temperature (less than +5° C). Check the adhesive surface using the finger test. If the finger does not stick to the surface and the surface does not feel tacky, the joints should be closed. Press both surfaces to be bonded together under firm pressure. Joints made with Kaiflex adhesive 414 shall be allowed a curing time of 36 hours at room temperature. Never allow to cure in bright sunlight. Never use the adhesive whilst installation is in operation. Leave adhesive joints for 36 hours before applying any coatings, jackets or adhesive tape.	
Attention	Adequate ventilation must be maintained, particularly in confined spaces. Due to the volatile nature of the solvent, keep away from any source of ignition such as pilot lights or sparks. Prohibition of smoking must be rigidly enforced in the vicinity of use.	
Health & Safety		As with all chemicals, caution should always be exercised. Protective clothing such as gloves and goggles should be worn. Inhalation: Inhalation of vapour or mist should be avoided. If inhaled symptoms include coughing, wheezing, laryngitis, and shortness of breath, headache, nausea, and vomiting. Immediately shift victim to fresh air and if needed immediately start artificial respiration. Give oxygen if breathing is laboured. Get emergency medical help.
	After inhalation	If inhaled, immediately take the affected person to fresh air. Give sufficient oxygen. If not breathing give artificial respiration. Get medical attention if symptons develop.
	After skin contact	Rinse with running water and soap. Remove all contamined clothing.
	After eye contact	In case of contact with the eyes rinse immediately with plenty of water and seek immediate medical attention.
	After ingestion	Do not induce vomiting, seek medical advice immediately.
	Precaution	Please refer to the appropriate material data sheet (MSDS) prior to using this product.