

#### Description

**AW 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.

AW 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 AW 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

### Properties

<b>Type</b>	Synthetic Rubber / Resin
<b>Colour</b>	Light Yellow / Blue
<b>Solids Content</b>	Approx 30%
<b>Viscosity</b>	Medium to thin consistency
<b>Tack Up Time</b>	1-5 mins @20°C
<b>Touch Dry</b>	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 AW 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	AW 1830 Adhesive 20 L	Clear	
155896	AW 1830 Adhesive 200 L	Clear	
162760	AW 1831 Adhesive 20L	Blue	
162779	AW 1831 Adhesive 200L	Blue	

The representations and recommendations regarding the products are based on tests which we believe to be reliable. However, no guarantee of their accuracy can be made because of the great range of field conditions and variations encountered in raw materials, manufacturing equipment and methods. Thus, the products are sold with a limited warranty only, and on the condition that purchasers will make their own tests to determine the suitability of the product for their particular purposes. Under no circumstances will Bostik Australia Pty Ltd be liable to anyone except for replacement of the products or refund of the purchase price.

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Quality endorsed ISO9001 (Thomastown site)  
TS16949 (Automotive).

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