

TECHNICAL DATA SHEET

DEKAPREN 3649-2 CONTACT ADHESIVE

PRODUCT

Dekapren 3649-2 is a contact adhesive with good ageing properties. Its main applications can be found in repair work, bodywork and in vehicle construction.

APPLICATIONS

- Bonding of profile rubbers.
- Bonding of linings.
- Bonding of leather, artificial leather with textile backside.
- Bonding of textiles and felt on metal, painted metal, wood and plastics such as hard PVC, ABS and PA.

FEATURES

- **Dekapren 3649-2** has a high initial adhesion.
- **Dekapren 3649-2** has no aromatic substances.
- Approved according to specification of Daimler Chrysler (A 003 989 5971 and A 000 989 8271).
- Proven track records.
- **Dekapren 3649-2** is fast drying and reaches final strength after 24 hours.
- Colourless after drying.

TECHNICAL DATA

Basic material	: Polychloroprene, synthetic resins, solvents (no aromatic substances)
Consistency	: brushable
Curing/setting method	: emission of solvent
Specific density (20°C), DIN 51757	: ca. 0.88 kg/liter
Drying time (20°C/65%R.H.)	: 5 minutes up to 10 minutes
Thinning and cleaning agent	: thinner
Flash point	: below +21°C
Solid content (DIN 53216, 3 hours at 120°C)	: ca. 26%
Viscosity (20°C)	: ca. 1,200 mPas (Epprecht-Rheomat STV,MS 3,200 rpm)
Temperature resistance (cured)	: up to +90°C
Resistance against (20°C, cured)	: water, oils, diluted acids and alkaline solutions
Usage	: ± 200 g/m ²
Colours (standard)	: yellow/transparant
Packaging	: 200 ml

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ADHESION

The surfaces to be treated must be flat, dry and free of dust, oil and grease. Profile rubbers have to be washed with White Spirit before bonding. For not mentioned substrates and additional information please consult Dekalin.

METHOD OF USE

Stir **Dekapren 3649-2** well before use. Normally only apply to non-absorbent surfaces by brush. To improve adhesion to very absorbent surfaces we recommend applying the material to both surfaces. Allow the wet film to dry for 5 - 10 min, before the two pieces should be firmly pressed together for a short period. The maximum adhesive strength is reached after 24 hours.

STORAGE STABILITY

Dekapren 3649-2 should be stored at temperatures between +15°C and +25°C. The packs should be protected from direct sunlight and heat. If kept cool and dry the original unopened packs can be stored for 12 months.

SAFETY PRECAUTIONS

Consult our latest safety data sheet for more details.

TRANSPORT CLASSIFICATION

Consult our latest safety data sheet for more details.

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