

SIMALFA 321

SIMALFA 321 is a super instant tack, high yielding, and fast drying one-part water based adhesive that can be used in a wide variety of applications. While primarily designed for the bedding industry (pillow tops, foam layers, foam encased), Simalfa 321 has exceptional characteristics that allow foam and fabrics to instantly bond to many different materials including wood and plastic.

Key Properties

- Super Instant Tack
- Very-Fast Drying
- High Yield
- Instant Bond
- Fast Processing
- One-Sided Application
- Repositionability
- Soft Bond Line
- Solvent Free

Physical Properties

Composition:	Dispersion of acrylic resin, and synthetic rubber in water.
Color:	Red, Natural (white), and Custom
Odor:	Slight
Solids Content: .	~ 54%
Specific Gravity:	~ 1.06 g/cm ³ at 68°F C20°C)
pH Value 73°F C23°C)	7.0-9.2
Viscosity Brookfield	Range 400 . 1000 cP (Spindal 3/63, 20 RPM>
Break Elongation:	~ 600%
Heat Resistance:	1 76°F -194 °F (80°C -90°C)
Boiling Point:	212°F C 100°C)
Freezing Point:	32°F C 0°C>
Storage and Handling:	Minimum 40°F (5°C) and maximum 104°F (40°C). Store In a dry place. Keep lightly closed to prevent loss of moisture.
Shelf Life:	6 months In unopened container.
Cleaning:	Washable with water

Surface Preparation

Surfaces must be clean, dry and dust free. Any petroleum based product such as oil or grease can prevent suitable bonding.

Application

Never agitate or mix before using. Simalfa can be applied to both surfaces with a spray gun. However, in many instances, single sided application is the preferred method. Hold the spray gun between 6" - 12" (15cm - 25cm) from the surface and be sure to overlap the pattern slightly with each pass to ensure uniform coverage.

Coverage

Coverage will vary depending on the porosity of substrates and strength of adhesive bond desired. Typical users will cover up to 1000 square feet per gallon. In all cases, user evaluation will be required to determine the optimum coverage levels for their application.

Assembly and Bonding Time

Simalfa bonds immediately after spraying. Users can reposition the substrates, to maximize the quality of their product, without re-spraying. Pressure may be applied via manual or mechanical methods to enhance the initial bond. In addition, the user can place the substrates together immediately or up to 15 minutes after spraying if required by their production process. After 15 minutes the adhesive may dry and the final adhesion can suffer, or a pseudo.adhesion could take place.

The final bond is achieved once the residual water has evaporated. Although water evaporation happens quickly, it is recommended users wait 24 hours before performing any final bond testing.

Cleanup

In some cases wet adhesive may be removed with water. Dry adhesive cannot be removed from porous substrates such as foams or fabrics. It is recommended that users prevent adhesive from getting on surfaces where it's not wanted.