

ADBOND 1540
Hybrid adhesive for metals and plastics

DESCRIPTION

ADBOND 1540 is a hybrid single component elastomeric adhesive that was design for transport vehicle assembly and sealing or other industrial application. ADBOND 1540 provides a permanently flexible bond and can be used to attach materials that have dissimilar coefficient of expansion. It adheres to a wide variety of substrates without the need of primer. It is non-staining and low odor.

FEATURES

- Permanent elasticity from -40°C to 90°C (-40°F to 194°F)
- Application temperature range from -5°C to 35°C (23°F to 95°F)
- Isocyanate free
- Compatible with most industrial paints (always test before use)
- Paintable after skin formation (wet to tacky)
- Excellent UV resistance and very good aging properties

LIMITATIONS

- Not designed for permanent immersion joints
- Where the sealant is encapsulated and does not have access to ambient humidity
- In contact with strongly acidic or alkaline products
- Joint less than 1/4 "(6 mm) wide and deep

PHYSICAL PROPERTIES

Uncured @ 23 °C (73°F) 50% R.H.			
Test	Standard	Unit	Results
Appearance			Pasty
Color			Lilly White (1542) Black (1543)
Density	INRD-016	g/cm ³	1.278
Skin time	INRD-008	minutes	30 – 40
Depth of cure	INRD-077	mm	3.1 @ 24 hours 5 @ 3 days 8 @ 7 days
Extrusion rate @ 50 psi	INRD-005	gr/minute	224
Sag (triangular bead)	INRD-068		None
Shelf life	INRD-078	months	12

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Cured @ 23 °C (73°F) 50% R.H.			
Test	Standard	Unit	
Hardness	ASTM C661	shore A	42.9 @ 7 days 47 @ 14 days 46.5 @ 28 days
Tensile strength at 100%	ASTM D412	psi	90 @ 7 days 92 @ 21 days
Ultimate Tensile strength	ASTM D412	psi	331 @ 7 days 402 @ 21 days
Elongation at break	ASTM D412	%	385 @ 7 days 454 @ 21 days
Lap shear strength on stainless steel	ASTM D1002	psi	175 (cohesive failure) @ 7 days 196 (cohesive failure) @ 21 days
Water absorption	ASTM D570	%	0.5% @ 2 hours 1.32% @ 24 hours
Catapasm	INRD-070		Pass 100% CF (cohesive failure) on stainless steel Pass 100% CF (cohesive failure) on fiberglass except for step 4 100% FAF (film adhesive failure)

APPLICATION

- Adhesive for coachwork, portable building, recreational vehicle, buses, railcars, trailer, and truck bodies
- Vibration suppression between metals, wood and combinations of wood and metal
- Sealing welded seams in sheet metal
- Sealing sandwich panels and bonding metal strips on sandwich panels
- Sealing cold storage containers, metal tanks, etc.
- Elastic / cohesive bonding of metals on wood, metal, some plastics, and glass

SURFACE PREPARATION

Surface must be free of dust, oil, grease, frost, or any other contaminant. On porous surface, first use mechanical tool such as grinder to remove old sealant or any other contaminant. Use ADSEAL CLEANER 6003 to clean all surfaces. Let it evaporate 20 minutes before sealant application. Ensure that the backer rod ADSEAL BACKER ROD is friction fitted properly and ADSEAL PRIMER have been applied if necessary. For the complete procedure and the type of primer to use, consult our [ADSEAL PRIMER Guide](#).

ADBOND 1540
Hybrid adhesive for metals and plastics**METHOD OF USE**

ADBOND 1540 is easy to apply with a conventional manual, electric or pneumatic applicator (do not exceed 45 psi for a cartridge). Always perform a test on painted surfaces to ensure the adhesion.

STORAGE

12 months in closed original packaging stored in dry premises at a temperature lower than 77°F (25°C). In cold weather, store the packaging at about 68°F (20°C) before use.

CLEANING

Sealant should be clean with solvent before curing. After curing, abrasion is necessary.

PACKAGING

- 304ml cartridge
- 600ml sausage
- Pail
- Drum

CAUTION

Always consult SDS (Safety Data Sheet) before using the adhesive. For industrial use only. For more information, please contact your technical representative.

IMPORTANT**READ CAREFULLY**

The information and recommendations contained herein are derived from our research and information from other reliable sources. This data applies only to our products and not when used with other products. We believe in the reliability of our information. However, no guarantee is offered to that effect. It is the responsibility of the buyer to verify this data according to their own operating conditions to ensure that they conform to the purpose for which the product is intended, even before using it.

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