

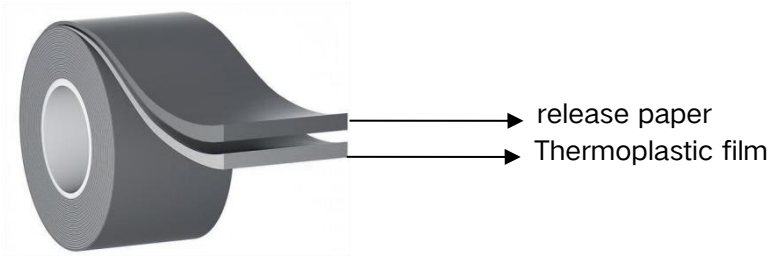
# Low-Temperature Thermosetting Adhesive Film

## SAF 50

### Product Introduction

SAF50 is a non-sticky film at room temperature. When applied, it needs to be heated and immersed in the bonded surface. After heating to a certain temperature and time, chemical cross-linking is produced and gradually hardened into shape. This product is mainly used for bonding different substrates, including nylon fabric, leather and PC, etc.

### Product Structure



Note: The release paper with this model may not be suitable for die-cutting. It is recommended that customers change the release paper when die-cutting.

### Typical performance

Item	Representative value	Test Method
Resin system	Thermosetting polyurethane	/
Film thickness (mm)	0.05	GB/T 7125-2014
Color	translucent	visual
PC/MX test standard leather 180° peel strength (N/cm)	18	Internal standards
PC/PC, dynamic shear force (MPa)	16	GB/T 7124-2008
condition of cure	100℃ / 0.4MPa/ 30 s	Internal standards

Note: This performance represents typical results obtained using internal standard materials and equipment in the AlphaPro laboratory and should not be considered as product specifications.

## Product Features

- High bonding performance
- Excellent impact resistance
- Low rubber leakage rate
- Excellent resistance to yellowing

## Applications

SAF50 is especially suitable for bonding structural parts of the following substrates, including nylon cloth, leather, P C board, etc.

## Suggestions

SAF50 requires two process processes, namely pre-bonding and hot pressing. The pre-bonding and hot pressing conditions are as follows:

Pre-set the suggested value of parameters

Preheating temperature: 60℃~70℃

Pre-sticking time: 5~15s

Pre-stress: 0.3~0.6MPa

Recommended values for thermal pressure parameters

Hot fitting temperature: 90-120℃

Hot pressing time: 30~60s

Hot press pressure: 0.3~0.6MPa

It should be noted that for different project requirements and bonding substrates, reducing the hot pressing temperature and simultaneously extending the hot pressing time may also eventually achieve good bonding effect, vice versa.

In order to achieve the bonding purpose, the bonded surface must be clean and dry. The pre-applied components should be stored under recommended storage conditions before final pressing. Excessive storage temperature will reduce the final bonding strength after hot pressing. Under normal circumstances, the final pressure strength can be completely established after hot pressing and leaving at room temperature for 24H. After pre-adhesive, leave for 3 days and avoid direct sunlight during application of the film.

## Storage and Shelf Life

The original packaging film should be stored at 6~25° C/ 50±20% RH to avoid direct sunlight. The product performance shelf life is 9 months when the original packaging film is stored under the above recommended conditions.

## Precautionary Information

The data in the technical data are representative typical values and shall not be used for control of shipment. Before using the product, the user shall determine the applicability of the product to its intended use. The user assumes all risks and liabilities associated with such use.

## Disclaimer

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