

Description

A superior E/F brush/roller grade contact adhesive designed for industrial applications that is fast drying with excellent initial tack and long open time.

Benefits

- Excellent room temperature contact bonds.
- Excellent green strength and high heat resistance.
- Fast drying with a long open time.
- Higher viscosity insures good coverage with minimal soak in into porous substrates.
- Excellent bond adhesion to a variety of substrates including but not limited to DHPL, particleboard, plywood, steel, rigid plastics and rigid urethanes, etc.

Specifications

- **Solids Content:** 21.0% +/- 1.0%
- **Viscosity:** 1100 cps +/- 100 cps
- **Weight/Gal:** 6.75 lbs +/- 0.2 lbs
- **Coverage/Gal:** 214 ft² @ 3.0 dry grams
107 ft² completed bond
- **Open Time:** 1 hour
- **Shelf Life:** 1 year
- **Color:** Natural
- **Packaging:** Drums and pails
- **VHAP:** 0.97 lbs/lb of solids
- **VOC:** 4.72 lbs/gal (567 grams/l) < water and exempt solvents

Handling & Storage

- **Do Not** use copper and its alloys to transfer or contain any contact adhesive.
- **Do Not** laminate copper with this adhesive.
- **Do Not** exceed the recommended “open time.”
- **Do Not** use to bond vinyl due to plasticizer migration.
- Thinning the adhesive is not recommended.
- **Never** use lacquer thinner for thinning.
- Consult the Material Safety Data Sheet prior to use.
- Keep adhesive container closed tightly when not in use.

Usage Tip

In times of high humidity, “blushing” may occur. A “blush” is caused from the rapid evaporation of the solvents, which causes the temperature in the immediate area to drop. When the temperature reaches the dew point, moisture will form on the surface of the adhesive. Once the “blush” has formed, the solvent cannot penetrate the moisture, and the moisture will act as a barrier between the two glue lines. The moisture must be allowed to dry before bonding. The best method to help speed drying is with air movement. Once the moisture is removed and you give the solvents time to flash off, the bond can be made.

Statements and recommendations made herein are based on tests believed to be reliable. However, no guarantee of their accuracy or completeness is made. Unless otherwise provided in written contract, products are sold without warranties or conditions express or implied. Purchasers must make their own tests to determine the suitability of our products for their particular purpose. Les affirmations et recommandations ci-dessus sont basées sur des tests éprouvés. Toutefois aucune garantie n'est donnée quant à leur précision ou plénitude. Sauf stipulations contraires dans un contrat écrit, les produits sont vendus sans aucune forme de garantie ou condition. L'acheteur doit faire ses propres essais pour déterminer si notre produit est approprié pour ses fins particulières.

Application Guidelines

1. Agitate adhesive before using.
2. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
3. The adhesive can be applied with a 2" to 4" wide animal hair or solvent resistant brush, a short nap phenolic roller, notched trowel, or a roll coater.
4. The adhesive should be applied at a coating weight of 3.0 dry grams per sq. ft., or 100% coverage. Proper adhesive coating is indicated by a uniform glossy sheen on the adhesive when it is dry, with light reflecting on it. Any dull areas indicate insufficient adhesive and should be reapplied.
5. When applying contact adhesives to porous materials such as plywood and edges, it is advisable to apply two coats. Apply the first coat and allow to dry. This will act as a sealer. When dry, apply the second coat and allow to dry properly before bonding. This helps to insure that the adhesive does not soak-in below board fiber and that you have the proper amount on the surface to achieve a strong, permanent bond.
6. Allow the adhesive to dry properly before bonding. To check for dryness, use the back of your fingers and press into the adhesive and lift up. Any adhesive transfer or legginess indicates that the adhesive requires more time to dry. If the adhesive feels tacky, but there is no transfer or legginess, the adhesive is ready for bonding. If there are heavy areas of adhesive present, press the back of your fingers in the adhesive and twist. If a skin has formed, this will tear it open and allow you to notice that the adhesive requires more dry time. **DO NOT** use the palm of your hand to check for dryness. Dry time can vary depending on temperature, humidity and coating weight. Drying time can be reduced using air movement, drying ovens, lamps, etc.
7. Bonds can be made as soon as the adhesive is dry. However, bonds made anytime in the 1 hour open time will be as strong as those made immediately after dry.
8. Position the pieces carefully, since a strong bond is made instantly upon contact.
9. Use good uniform pressure to insure good film fusion. A pinch roller is the optimum method for applying pressure. Use the maximum possible pressure without damaging the substrates. Minimum recommended pressure is applied with a J-roller.
10. The completed panel can be routed or trimmed, cut, filed and machined immediately.