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# CONTACT ADHESIVE

## WATER-BASED

### General Description

- Non-flammable, water-based contact adhesive
- Bonds postforming or flatwork applications
- Extremely low VOC and VHAP content
- Non-toxic
- Spray, brush or roller applied
- Consumer or Professional use
- Does NOT require stirring before use
- Meets or exceeds:
  - Woodwork Inst. of California Type II Adhesive
  - Mil. Spec. MIL-A-21366A

### Applications to Avoid

- Copper, brass, aluminum, galvanized, zinc or non-stainless steel spray system or fluid components.
- Surfaces with dirt, grease or excessive moisture.
- Vinyls with plasticizers which attack the bond line (conduct pre-testing if in doubt).
- Low pressure melamine surfaces, polyester, metal or painted surfaces.

### Availability

- 1-gallon jug, 5-gallon pail, 55-gallon drum and 275-gallon tote (returnable)

### Storage/Shelf Life

- DO NOT ALLOW PRODUCT TO FREEZE. PRODUCT WILL FREEZE AT 32 F - 35 F.
- Close container tightly when not in use and store off the floor in a well ventilated area.
- Rotate stock. Stirring not required.
- Shelf life expires 1 year from manufacture date.

### General Use Instructions

- DO NOT USE THIS PRODUCT IF YOU HAVE NOT READ OR DO NOT UNDERSTAND THE WARNINGS, SAFETY MEASURES AND FIRST AID INSTRUCTIONS PRINTED ON THE CONTAINER OR LABEL. When using spray application, use only diaphragm pumps or pressure pots. Do not use pogo (piston) type pumps. Fluid component parts that are in contact with the wet adhesive must be stainless or of other corrosion-proof construction.
- Ensure spray system oil and water traps are functioning and are at least 25' from compressor. Allow substrates to acclimate to room temperature for 48 hours before bonding. Assemble glued parts at or above 65 F and ensure surface is clean and dry.
  - Apply 3.0 dry grams of adhesive uniformly and smoothly to both surfaces and ensure each surface receives 100% coverage. Pay special attention to edges. Some porous surfaces (plywood) may require two (2) coats.
  - Allow approximately 20-30 minutes to dry after application and before bonding. When ready to bond, surface will be clear and tacky but should not transfer or "leg" to a firmly pressed fingertip. If parts do not stick immediately, they are over-dry and can be reactivated by applying a light coat of fresh adhesive on both parts. Open time is approximately 60 minutes. Forcing warm, moisture-free air over the drying surfaces will speed drying.
  - Apply uniform downward pressure (30-40 psi minimum) over the entire bonded surface by mechanical pinch roller (recommended) or by using a 3" wide rubber J-roller. Use of a wooden block or other hand rollers is not recommended.
  - Immediate trimming, routing or finishing is possible.
  - DO NOT THIN THIS PRODUCT.

### Physical Properties

Color:	White or Green
Density:	9.1 pounds/gallon
Solids Content:	17.5% ±1.0%
VOC/liter of material:	52.0% ± 2.0%
pH:	10-12
VOC (less water & exempt solvents):	<0.1 grams/liter (Calculated)
VHAP Content:	< 0.035 lbs./lbs. solids
Coverage (Spray):	357 bonded ft <sup>2</sup> /gal @ 3 dry grams/ ft <sup>2</sup>
Open Time:	~60 minutes
Dry Time:	20-30 minutes or 8-10 minutes using forced air

\*GREENGUARD® Certified

\*Complies with SCAQMD, Rule 1168

\*Complies with the Ozone Transport Commission (OTC)

\*Qualifies for LEED®-NC & CI EQ Credit 4.1:

*Low Emitting Materials: Adhesives & Sealants*

\*Qualifies for LEED®-NC & CI EQ Credit 4.4:

*Laminating adhesives shall contain no added urea-formaldehyde resins.*

### Coverage Instructions

Cover with a minimum of 3.0 dry grams/ sq. ft. on both surfaces.

### Usage Tips and Troubleshooting

- Drying time may be shortened using warm air, heat strips or infrared lights. DO NOT ALLOW THE ADHESIVE FILM TO BOIL.
- Moisture from condensation must be dried prior to bonding. • A dull appearance is a symptom of under-applying adhesive. • A very shiny appearance or a failed bond is a symptom of inadequate assembly pressure and/or exceeding the open time.

### Spray Equipment Instructions

- Binks: Hand Gun: 95, 7B/C, 62, 69, 2001SS or 2001; Auto Gun: M95 Auto, M61, M610; Fluid Tip: 66SS (Hand or Auto Gun); Air Cap: 66SDJG (Hand or Auto Gun), 66SK, 66SD-3.
- DeVilbiss: Hand Gun: JGA 510 or MSA 510; Auto Gun: AGX 550; Fluid Tip: FF or FX (Hand or Auto Gun); Air Cap: 797 or 7700 (Hand or Auto Gun).
- General: Fluid Pressure: 10-15 psi; Atomizing Air Pressure: 16-30 psi.
- HVLP Spray Equipment: (Only if required by local air quality districts): Gun: Binks Mach 1 or 2001 HVLP; Fluid Tip: 94S; Air Cap: 95AS; Fluid Pressure: <15 psi; Atomizing Air Pressure: 16-30 psi.

### Clean-up/Disposal

- FOR BEST RESULTS, CLEAN EQUIPMENT AND EXCESS ADHESIVE IMMEDIATELY WITH COLD WATER. DO NOT ALLOW TO DRY.
- Use ammoniated cleaners before adhesive film cures.
- Use WA 110 solvent to clean dried, cured adhesive from equipment. • Use WA 121 to clean dried, cured overspray from finished assembly. DONOTUSE WA121TOCLEANEQUIPMENT! • Dispose of waste in accordance with regulations.