

1. Manufacturer

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2. Product Overview

General Description

- OTC (Ozone Transport Commission) compliant, low VOC, spray applied, solvent-based contact adhesive
- Rapid high strength postforming or flat work application bonds
- Versatile, all-weather, fast drying, easy application by hand or automated equipment
- Product may separate. Agitate well prior to use.
- Professional use only

Availability

5 gallon pail and 55 gallon drum

3. Technical Data

Physical Properties

Color	Red (1800) Natural (1801)
Viscosity	450 cps (typical)
Density	7.4 lbs./gallon
Solids Content	18.5% ± 0.5%
VOC¹ (less water & exempt solvent)	249 g/Liter (Calculated)
VOC/liter of material¹	46 g/Liter (Calculated)
VHAP Content	0.07 lbs./lbs. solid
Coverage (Spray)	152 bonded sq.ft./gal. @ 2.0 dry grams/sq.ft.
Flashpoint	-14.4 °C/6.0 °F(closed cup)
Open Time	30 min.
Dry Time	3 – 5 min.

*GREENGUARD® Gold Certified

¹TBAC IS RECOGNIZED IN 40 C.F.R.51.100(s) AND BY THE EPA AS A VOC EXEMPT COMPOUND. ALASKA, CALIFORNIA, KANSAS, SOUTH DAKOTA, WASHINGTON, WYOMING AND WASHINGTON D.C. HAVE NOT FORMALLY RECOGNIZED THIS EXEMPTION. CONTACT YOUR LOCAL REGULATORY AGENCY TO PROVIDE CLARIFICATION ON THE EXEMPTION STATUS.

Primary Contents

Tert-Butyl Acetate (CAS 540-88-5), Acetone (CAS 67-64-1), Tert-Butyl Alcohol (CAS 75-65-0), Polychloroprene (CAS 9010984), Rosin (CAS 8050-09-7)

4. General Use Instructions

Agitation/Stir Well Instructions

This adhesive product may separate due to prolong storage or storage at low temperatures. Agitate and stir vigorously at or above 65 °F until the entire container regains its original viscosity and blended appearance. Proper agitation and remixing can be performed by various instruments including a standard paint paddle or stirring stick for smaller containers or an approved drum mixer for 55 gallon drums. A well-mixed product will have a smooth consistency with no discernable layers. The same viscosity of 450 cps will be found throughout the entire container.

Coverage Instructions

Apply a minimum of **2.0 dry grams/sq. ft.** on both surfaces

Recommended Tools and Equipment:

NFPA 33 states non-ASME rated pressure-pot shall not exceed 15 psi when filled with flammable liquids.

- CA Technology Hand Gun; Panther; Fluid Tip 1.5; Air Cap: 2266-3T

Fluid Pot Pressure	Pogo Pump Pressure	Atomizing Air Pressure (with Trigger Pull)	Air Source	Fluid Line
10 - 15 psi	30 - 50 psi	80 - 90 psi	Continuous 100 psi at 20 cfm	Minimum 3/8" ID*

*This line diameter is critical due to thickness of product

For additional recommended tools and equipment manufacturers, visit <https://wilsonart.box.com/v/AdhesiveToolsandEquipment>.

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.

- For best results, do not apply the adhesive at temperatures below 65-degrees Fahrenheit.
- Ensure spray system oil and water traps are functioning, and are a minimum of 25-feet in distance from the compressor.
- Allow substrates to acclimate to room temperature for 48 hours before bonding.
- Assemble glued parts at or above 65 °F, and ensure each surface is clean and dry.
- Apply adhesive uniformly to both surfaces in a smooth, pebbled pattern, and cover each surface a minimum of 80%. Cover edges 100%. Some porous surfaces may require 2 coats.
- Allow approximately 3 to 5 minutes to dry after application and before bonding. When ready to bond, surface will be 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 30 minutes.
- 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.**

Usage Tips and Troubleshooting

- Moisture from condensation must be dry prior to bonding.
- A dull appearance is a symptom of under-applying adhesive.
- A shiny appearance or a failed bond is a symptom of inadequate assembly pressure and/or exceeding the open time.

Clean-Up and Disposal

- Clean equipment with Wilsonart® WA-130 Solvent and finished assembly with WA 131 Cleaner (OTC); Wilsonart® WA-110 Solvent and finished assembly with Wilsonart WA-121 Cleaner.

Applications to Avoid

- Copper or copper alloy substrates;
- Use of copper-containing application systems or components
- Surfaces with dirt, grease, or excessive moisture
- Vinyl surfaces containing plasticizers that may attack the bond (conduct pre-testing if in doubt)
- Dispose of waste in accordance with regulations.

Storage/Shelf Life

- Rotate stock and close container when not in use.
- Store off of the floor in a cool, well-ventilated area and away from exterior walls.
- Product may separate. Agitate well prior to use.
- Shelf life expires 1 year from manufacture date.

Shipping Information

Ships domestic ground: Adhesives, 3, UN 1133, PG II

Precautionary Information

Refer to product label and Safety Data Sheet for health and safety information before using this product.

5. Warranty

No Warranty

WILSONART MAKES NO WARRANTIES, EXPRESS OR IMPLIED. NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE SHALL APPLY. The person using the product (the "User") is solely responsible for determining whether the Wilsonart product is appropriate and/or suitable for User's purpose and method of application.

Limitation and Exclusion of Remedies and Damages

The exclusive and sole remedy, and Wilsonart's exclusive and sole obligation, for any defect of this Wilsonart product is the refund of the purchase price of the product. Wilsonart shall not, under any circumstances or under any legal theory, be liable to the Purchaser or any other person for special, incidental or consequential damages of any nature, including without limitation damages to, or loss of use of, property, damages for loss of profits or revenues or any other damages arising from the purchase or use of the product. Wilsonart's liability will in no event exceed the purchase price of the product.

6. Technical Services

Customer Service: 1-800-433-3222 or Adhesives@Wilsonart.com. Visit [Wilsonart Adhesives](#) online for more information.

Specification Form:

Adhesive shall be Wilsonart® 1800 or 1801, produced by Wilsonart LLC, Temple, Texas 76503-6110

Wilsonart® 1800/1801 OTC Compliant Postforming Spray-Grade Contact Adhesive

Technical Data

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