



Wilsonart®

CONTACT ADHESIVE

PREMIUM POSTFORMING SPRAY GRADE



General Description

- Spray applied, solvent-based contact adhesive designed and proven successful on high-speed postforming operations, including ogees
- Low VOCs, aggressive tack and extremely fast dry time
- Professional use only
- Does NOT require stirring before use
- Meets or exceeds:
 - Commercial Item Description A-A-1936A (1996); Type I-B (supersedes Fed. Spec. MMM-A-130b)
 - Woodwork Inst. of Cal. Type II adhesive
 - Mil. Spec. MIL-A-21366A

Applications to Avoid

- Copper or copper alloy substrates
- Copper 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)

Availability

55-gallon drum and 330-gallon tote (returnable)

Storage/Shelf Life

- Rotate stock and close container when not in use. Store off floor in a cool, well ventilated area and away from exterior walls.
- Shelf life expires 1 year from manufacture date.
- Product may separate after exposure to extreme cold requiring agitation after return to normal temperature.

Coverage Instructions

Cover a minimum of 2.0 dry grams/ft² on both surfaces.

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. For best results, do not apply the adhesive at temperatures below 65°F.

- 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 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 two (2) coats.
- Allow approximately 3-5 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. Moisture from condensation must be dried prior to bonding.**
- 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 dried prior to bonding.
- A dull appearance is a symptom of under-applying adhesive.

Physical Properties

Color:	Red (844)
Viscosity:	100 cps (typical)
Density:	6.6 lbs/gallon
Solids Content:	19.0%±1.0%
VOC/liter of material:	372 g/L (Calculated)
VOC(less water & exempt solvents):	575 g/L (calculated)
VHAP Content:	0.39 lbs/lbs of solids
Coverage (Spray):	143 bonded ft ² /gal @ 2.0 dry grams/ft ²
Flashpoint:	-30°C/-34°F (PMCC)
Open Time:	~30 minutes
Dry Time:	3-5 minutes

*Qualifies for LEED®-NC & CI EQ Credit 4.4:
Laminating adhesives shall contain no added urea-formaldehyde resins.

- A very shiny appearance or a failed bond is a symptom of inadequate assembly pressure and/or exceeding the open time.

Spray Equipment Instructions

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

- Binks: Hand Gun: 95, 7B/C, 62, 69, 2001SS or 2001; Auto Gun: M95 Auto, M61, M610; Fluid Tip: 63BSS (Hand or Auto Gun); Air Cap: 66SDJG (Hand or Auto Gun)
- DeVilbiss: Hand Gun: JGA 510 or MSA 510; Auto Gun: AGX 550; Fluid Tip: FF (Hand or Auto Gun); Air Cap: 797 (Hand or Auto Gun)
- General: Fluid Pressure: 10-15 psi; Pump Pressure: 30-50 psi; Air Source: Continuous 100 psi at 20 CFM, Fluid Line: Minimum 3/8" ID

*This line diameter is critical due to thickness of product.

Shipping Information

Ship Domestic Ground: Adhesives, 3, UN 1133, PG II

Primary Contents

Toluene (CAS 108883), Acetone (67641), Light hydrotreated distillate (CAS 68410979), Polychloroprene (CAS 9010984), Resin (CAS 25085501)

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.

More information on page 2



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Clean-up/Disposal

- Clean equipment with Wilsonart WA 110 Solvent and finished assembly with WA 121 Cleaner.
- Dispose of waste in accordance with regulations.

Precautionary Information

Refer to product label and material safety data sheet for Health & Safety information before using this product.

Contact

Customer Service: 1-800-433-3222 or adhesives@wilsonart.com
Visit www.wilsonartadhesives.com for information