



Wilsonart®

CONTACT ADHESIVE

LOW VOC



General Description

- Low VOC, HAPs-free solvent-based contact adhesive designed with outstanding bond and heat strength
- Bonds flatwork (non-postforming) applications
- Minimizes telegraphing
- Spray, brush or roll applied
- Professional use only
- Does NOT require stirring before use

Applications to Avoid

- Copper or copper alloy substrates
- Copper spray system or fluid components
- Surfaces with dirt, grease or excessive moisture
- Vinyl surfaces containing plasticizers which may attack the bond line (conduct pre-testing if in doubt)

Availability

5-gallon pail and 55-gallon drum

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

- Spray: Cover a minimum of 2.5 dry grams/ft² on each surface.
- Brush/Roll: Cover a minimum of 3.0 dry grams/ft² on each surface.

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 (Spray) 3-5 minutes or (Brush/Roll) 10-15 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 don't 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 40 minutes.
- Apply uniform downward pressure (30-40 psi minimum) across 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:	Red (1700); Natural (1701)
Viscosity:	760 cps (typical)
Density:	7.7 lbs/gallon
Solids Content:	36.0% ± 1.0%
VOC (Less water & exempt solvent) ¹ :	8 g/L (Calculated)
VOC/liter of material ¹ :	3 g/L (Calculated)
VHAP Content:	None
Coverage (Spray):	254 bonded ft ² /gal
Coverage (Brush/Roll):	212 bonded ft ² /gal
Flashpoint:	3.3°C/38°F (Closed cup)
Dry Time (Spray):	3 - 5 minutes
Dry Time (Brush/Roller):	10 - 15 minutes
Open Time:	~40 minutes

*GREENGUARD® Certified

*Complies with the Ozone Transport Commission (OTC)

*Qualifies for LEED®-NC & CI EQ Credit 3.2:
Construction Indoor Air Quality Management Plan-Before Occupancy

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

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

Usage Tips and Troubleshooting

- 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.

Shipping Information

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

Primary Contents

Tert-Butyl Acetate (CAS 540-88-5), Parachlorobenzotrifluoride (CAS 98-56-6), Tert-Butyl Alcohol (CAS 75-65-0), Synthetic Rubbers (Mixture), Resins (Mixture)

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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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: 97S (HVL), 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 60 psi at 20 CFM; Fluid Line: Minimum 3/8" ID*
- *This line diameter is critical due to thickness of product.

Clean-up/Disposal

- Clean equipment with finished assembly with WA 130 Adhesive Solvent.
- Dispose of waste in accordance with regulations.
- Extremely flammable liquefied gas under pressure. Do not cut, puncture, drill, grind or weld on or near this container.

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