Product Information Sheet

CP-1380

Flammable Spray Contact Cement Natural

Application Temperature(s):	NA	
Color:	Natural	
Freeze Thaw Stable:	NO	
Min Use Temperature:	60° F	
Shelf Life:	@ 70F	1 Year
Solids (~):	19.0 +- 1	
Specific Gravity (~):	(H2O=1): 0.80	
Viscosity:	200+- 50	

Characteristics:
Type: Compounded Neoprene Flammable Spray Contact Cement
A high performance, high solids, fast drying contact bond adhesive designed for versatility. It is an excellent hand spray contact bond adhesive with superior initial spot grab and out-standing combinability. This adhesive was developed to meet the need for a spray contact bond adhesive that provides extremely easy and uniform coverage in all types and sizes of spray operations. The wide fan spray pattern that can easily be adjusted for fine or coarse deposition coupled with its high tack, excellent combinability and green strength provides uniform high strength bonds under a wide variety of laminating conditions.
Features:
Excellent adhesion to a wide variety of substrates.
Fast drying with wide fan and good break-up.
Long ‘‘open tack’’ – permits flexibility in production.
Aggressive grab with high green strength.
Designed for maximum sprayability – hot (120° F) or cold.
High solids which gives extended coverage and lower cost per laminated foot.
Excellent long-term bond performance.
High heat resistance – ideal for post forming operations.
Bonds are resistant to humidity, water, oil and aliphatic solvent
Applications:
It has been specifically formulated for use in bonding a wide variety of materials, including, but not limited to, decorative laminates, metals (not copper), plywood, particleboard, foamed polystyrene (using dry spray technique), polyurethane foam and rigid plastics.
Directions:
Coverage: Up to 250-300 sq. ft./gal., depending on application and porosity of materials to be bonded.
Stir adhesive well before using.
Surfaces to be bonded must be free from moisture, dirt, grease, oil, rust, or other contaminants.
Normally applied to both surfaces at a rate of 3.0 dry grams of adhesive per square foot of each surface. As well as spraying, it can be applied by brush, paint roller, notched trowel, roller coater, or curtain coater. Brushes should be firm, 2-4 inch wide, animal hair, or other solvent resistant material. Rollers should be short nap, mohair type, phenolic core. Extremely porous surfaces such as plywood and rough end grain will always require at least two coatings of adhesive.
Spray Information:

	Automatic		Manual	
	Binks	Devilbiss	Binks	Devilbiss
Spray Gun:	21,61,610	AGB	18,62,95 2001	JGA,MGA, MBC

Fluid tip:	63A	FX	63A,63ASS	FX
Fluid Needle:	463A	FX	63A,63ASS	FX
Air cap	66SD-3	770,797	66SD-3, 63SD	770,797

All Guns:
Atomization Pressure: 80-100 PSIG
Flied Pressure: 10-15 PSIG
Hot Spray Temp: 120 F Max.
Bonding Information:
Allow the adhesive to dry until entire coated area is still tacky but does not transfer to the touch. This normally occurs in 4-5 minutes at room temperature. Dry time is longer at high humidity, heavy coating, or low temperature conditions and shorter when force dried using ovens, lamps, etc.
An indication that sufficient adhesive has been applied is to look at reflected light off of the coated dry surface. Contact adhesives dry, under normal conditions, to a high gloss surface. If the coating does not have a high gloss, it is a strong indicator that insufficient adhesive has been applied to obtain a strong, permanent bond.
It is advisable to make bonds as soon as the adhesive is dry, however, bonds made up to an hour after dry will be just as strong as those made immediately after dry.
Position pieces carefully, since a strong bond is made instantly upon contact.
Use sufficient pressure to insure complete mating of the substrates. A nip roll or rotary press is ideal, using as much pressure as possible without crushing the substrates. Minimum recommended pressure would be that applied using a 3-inch J roller.
Laminate can be trimmed, cut, filed, or otherwise machined immediately after bonding.

Clean Up and Storage:

Solvent N, Solvent T, Solvent TH, Lacquer Thinner.
Caution! Flammable! Keep stored above 60F (and below 100F). Do not store directly on floor.

Key Warnings:

NOTE: COPPER AND ITS ALLOYS SHOULD NOT BE USED TO TRANSFER OR CONTAIN ANY CONTACT BOND ADHESIVE. DO NOT LAMINATE COPPER WITH THIS ADHESIVE. ALUMINUM SHOULD NOT BE USED IN TANKS, LINES, PUMPS OR OTHER EQUIPMENT USED TO CONTAIN, TRANSFER OR APPLY NON-FLAMMABLE SOLVENT CONTACT BOND ADHESIVES.
CAUTION:
READ PRECAUTIONS ON CONTAINER BEFORE USING.
READ AND UNDERSTAND MSDS BEFORE USING.

Additional Directions:

Technical Data: Solvent: Blend of hydrocarbons and ketones