



General Description

- A blend of polychloroprene rubbers and phenolic resins in a solvent system of toluene, acetone and light hydrotreated distillate.
- Rapid high strength postforming bonds with enhanced sprayability.

Applications

- Spray applied
- Postforming or self-edge
- Professional use only

Specifications

- 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

- 330-gallon totes (returnable)
- 55-gallon drums
- 5-gallon pails

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.
- If product is exposed to extremely cold temperatures and separates, stir before use.

Coverage Instructions

Cover with 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 2.0 dry grams 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.

Physical Properties	
Color:	Red (850); Natural (851)
Viscosity:	200 cps (typical)
Density:	6.6 lbs/gallon
Solids Content:	18.0% ± 1.0%
VOC/liter of material:	417 g/L (Calculated)
VHAP Content:	0.68 lbs/lbs solids
VOC*:	602 g/L (Calculated) *Less water & exempt solvents
Coverage (Spray):	135 bonded ft ² /gal @ 2.0 dry grams/ft ²
Flashpoint:	-15.0° C/-5.0° F (Closed cup)

- Allow approx. 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 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 30 minutes.**
- Apply uniform downward (30-40 psi minimum) pressure 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.



**Extremely Flammable
Premium Spray Grade**

**CONTACT ADHESIVE
FOR POSTFORMING**



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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.

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)
- *Graco*: Gun: P700, P800, P900; Fluid Tip: 03; Air Cap: 03
- *Spee Flo*: Gun: 501-149; Fluid Tip: 501-122; Air Cap: 501-122
- *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.**

Clean-up/Disposal

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

Shipping Information

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

Primary Contents

- Light hydrotreated distillate (CAS 68410979), Acetone (CAS 67641), Toluene (CAS 108883), Polychloroprene (CAS 9010984), Resin (CAS 26022004)

California Proposition 65 Warning

This product contains toluene, a chemical known to the State of California to cause birth defects or other reproductive harm.

Health Hazard Data/Target Organ Effects

Contains materials that may cause lung, liver, kidney and central and peripheral nerve system damage. Inhalation of vapors may cause central nervous system depression (anesthetic effect) with headache, nausea and dizziness. Continued breathing of excessive amounts may be fatal. Prolonged or repeated skin contact may result in dermatitis. Ingestion may cause vomiting, dizziness and gastrointestinal irritation. Chronic exposure may include liver and kidney damage and may cause nerve damage.

Safety

- **FLAMMABLE LIQUID AND VAPOR. VAPOR MAY CAUSE FLASH FIRE. VAPOR MAY TRAVEL TO AREAS AWAY FROM WORK SITE BEFORE IGNITING/FLASHING BACK TO VAPOR SOURCE. USE ONLY IN WELL-VENTILATED AREA. DANGER! VAPOR HARMFUL. WARNING – FLAMMABLE. MAY BE HARMFUL BY SKIN CONTACT. HARMFUL OR FATAL IF SWALLOWED. KEEP OUT OF REACH OF CHILDREN.**
- Keep away from heat, sparks and open flame. Prevent buildup of vapors. Open all windows and doors. Do not smoke when vapors are present.
- Avoid repeated breathing of vapors. Avoid contact with skin. Do not take internally.
- Extinguish all flames and pilot lights. Turn off stoves, heaters, electric motors. Turn off all potential ignition sources during use and until vapors are gone.
- Extremely flammable; Class 1B Flammable Liquid
- NFPA 33 states non-ASME pressure-pot pressure shall not exceed 15 psi when filled with flammable liquids
- See MSDS for complete data
- **HMIS Rating: Health 2, Flammability 3, Reactivity 0;**
24 hr. Chemtrec emergency number:
1-800-424-9300 (US); 703-527-3887 (International)

First Aid

Inhalation: At the first sign of overexposure (headache, nausea, dizziness), seek fresh air immediately. If not breathing, give artificial respiration. If breathing is difficult, give oxygen. Call physician immediately. *Eye Contact*: Immediately flush eyes with running water for at least 15 minutes. Get medical attention. *Skin Contact*: Immediately wash contacted areas of skin with soap and water. Remove contaminated clothing immediately; launder prior to reuse. *Swallowing*: If swallowed, call physician immediately. Do NOT induce vomiting unless directed to do so by a physician. NEVER give anything by mouth to an unconscious person.

Warranty

Wilsonart International, Inc. warrants to the user that this product is free of defects for a period of one (1) year from the date of manufacture when it is applied in accordance with manufacturer's instructions or the manufacturer will replace the container at no cost or additional charge to the user, provided the unused portion of the product is returned to the place of purchase within 15 days of the date of purchase. This warranty does not apply to (I) products that are purchased after the expiration of the manufacturer's recommended shelf life as stated on this technical data sheet, (II) misuse or mishandling of the product, (III) improper storage, or (IV) improper fabrication using this product. NO OTHER WARRANTIES, EXPRESS OR IMPLIED ARE MADE, INCLUDING MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. UNDER NO CIRCUMSTANCES SHALL THE MANUFACTURER BE LIABLE FOR ANY LOSS OR DAMAGE ARISING FROM THE PURCHASE, USE, OR INABILITY TO USE THIS PRODUCT, OR FOR ANY SPECIAL, INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES. NO FABRICATOR, INSTALLER, DEALER, AGENT OR EMPLOYEE OF WILSONART INTERNATIONAL, INC. HAS THE AUTHORITY TO MODIFY THE OBLIGATIONS OR LIMITATION OF THIS WARRANTY. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state, therefore, some of the limitations stated above may not apply to you. It is to your benefit to save your documentation upon purchase of product.

For More Information

- www.wilsonartadhesives.com for:
 - Tech Data Sheets
 - Material Safety Data Sheets (MSDS)
 - Adhesive Use Quick Reference Charts
 - Certified Product Data Sheets (CPDS)
- Customer Service Line 1-800-433-3222
- Wilsonart International Adhesives Division
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