



**840**  
**841**

### General Description

- A blend of polychloroprene rubbers and phenolic resins in a solvent system of toluene, acetone and light hydrotreated distillate.
- Aggressive tack and rapid high strength postforming bonds allow for high speed operations.
- This product does not require stirring before use.

### Applications

- Spray applied
- Designed for high speed operations
- 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

### 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 with a minimum of 2.0 dry grams/ft<sup>2</sup> 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.

### Physical Properties

<b>Color:</b>	Red (840); Natural (841)
<b>Viscosity:</b>	140 cps (typical)
<b>Density:</b>	6.6 lbs/gallon
<b>Solids Content:</b>	19.0% ± 1.0%
<b>VOC/liter of material:</b>	374 g/L (Calculated)
<b>VHAP Content:</b>	0.38 lbs/lbs solids
<b>VOC*:</b>	577 g/L (Calculated) *Less water & exempt solvents
<b>Coverage (Spray):</b>	143 bonded ft <sup>2</sup> /gal @ 2.0 dry grams/ft <sup>2</sup>
<b>Flashpoint:</b>	-30.6°C/-23.1°F (PMCC)

### \*Qualifies for LEED®-NC & CI EQ Credit 4.4:

Laminating adhesives shall contain no added urea-formaldehyde resins.

- 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 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. Moisture from condensation must be dried prior to bonding.**
- 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.



**Extremely Flammable**  
**Low-VHAP Spray Grade**

# CONTACT ADHESIVE

## FOR HIGH-SPEED POSTFORMING



## CONTACT ADHESIVE FOR HIGH-SPEED POSTFORMING

### 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

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

### Proposition 65 Warning

This product contains substances known to the State of California to cause cancer or reproductive harm.

### Volatil Organic Compounds (VOC):

The use, supply, sale or offer for sale of this product in certain states and localities may be prohibited if it exceeds certain VOC limits. Please check state and local regulations for any prohibitions on the sale and use of this product.

### 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.

### 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)

### 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](http://www.wilsonartadhesives.com) for:
  - Tech Data Sheets
  - Material Safety Data Sheets (MSDS)
  - Adhesive Quick Reference Charts
  - Certified Product Data Sheets (CPDS)
- Customer Service Line 1-800-433-3222
- Wilsonart Adhesives Division  
10601 NW HK Dodgen Loop  
Temple, TX 76503-6110