



WILSONART[®]
INTERNATIONAL

WATER-BASED CONTACT ADHESIVE

NON-FLAMMABLE!

- Consumer or professional use
- GREENGUARD Indoor Air Quality Certified[®]
- Spray or Roller Applied
- Non-Toxic
- Postforming or Flatwork Applications
- Extremely Low VOC & VHAP Content
- Available sizes:
 - 275-gallon tote (returnable)
 - 55-gallon drum
 - 5-gallon pail
 - 1-gallon jug
 - 1-quart bottle

Physical Properties

Color:	White or Green
Odor:	Slight ammonia
Density:	9.1 pounds/gallon
Solids Content:	52.0% ± 2.0%
pH:	10-12
VOC*:	<0.1 grams/liter (Calculated) *Less water & exempt solvents
VHAP Content:	< 0.035 lbs./lbs. solids
Coverage (Spray):	357 bonded ft ² /gal @ 3 dry grams/ ft ²
Freeze Stable:	No
Dry Time:	20-30 minutes or 8-10 minutes using forced air
Open Time:	Approximately 1 hour

*GREENGUARD[®] Certified

*Complies with SCAQMD, Rule 1168

*Qualifies for LEED[®]-NC & CI EQ Credit 4.1:

Low Emitting Materials: Adhesives & Sealants

*Qualifies for LEED[®]-NC & CI EQ Credit 4.4:

Laminating adhesives shall contain no added urea-formaldehyde resins.



CONTACT ADHESIVE WATER-BASED



CONTACT ADHESIVE WATER-BASED

General Description

A non-flammable waterborne system of polychloroprene rubber and resins. Extremely low VOC and VHAP content. This product does not require stirring before use.

Applications

- Spray or roller applied
- Postforming or flatwork applications
- Consumer or professional use

Specifications

- Meets or exceeds:
 - Woodwork Inst. of Cal. Type II Adhesive
 - Mil. Spec. MIL-A-21366A

Applications to Avoid

- Copper, brass, aluminum, galvanized, zinc or non-stainless steel 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).
- Low pressure melamine surfaces, polyester, metal or painted 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.

When using spray application, use only diaphragm pumps or pressure pots. Do not use pogo (piston) type pumps. Fluid component parts that are in contact with the wet adhesive must be stainless or of other corrosion-proof construction.

- 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 surface is clean and dry.
- Apply 3.0 dry grams of adhesive uniformly and smoothly to both surfaces and ensure each surface receives 100% coverage. Pay special attention to edges. Some porous surfaces (plywood) may require two (2) coats.
- Allow approximately 20-30 minutes to dry after application and before bonding. When ready to bond, surface will be clear and 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 60 minutes.** Forcing warm, moisture-free air over the drying surfaces will speed drying.
- 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.

Coverage Instructions

- **Cover with a minimum of 3.0 dry grams/sq. ft. on both surfaces.**

Usage Tips and Troubleshooting

- Drying time may be shortened using warm air, heat strips or infrared lights. DO NOT ALLOW THE ADHESIVE FILM TO BOIL.
- 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

- *Binks:* Hand Gun: 95, 7B/C, 62, 69, 2001SS or 2001; Auto Gun: M95 Auto, M61, M610; Fluid Tip: 66SS (Hand or Auto Gun); Air Cap: 66SDJG (Hand or Auto Gun), 66SK, 66SD-3.
- *DeVilbiss:* Hand Gun: JGA 510 or MSA 510; Auto Gun: AGX 550; Fluid Tip: FF or FX (Hand or Auto Gun); Air Cap: 797 or 7700 (Hand or Auto Gun).
- *General:* Fluid Pressure: 10-15 psi; Pump Pressure: 10-20 psi; Air Source: Continuous 100 psi at 20 CFM; Fluid Line: ¼" - ⅜" ID.
- *HVLP Spray Equipment:* (Only if required by local air quality districts): Gun: Binks Mach 1 or 2001 HVLP; Fluid Tip: 94S; Air Cap: 95AS; Fluid Pressure: <15 psi; Atomizing Air Pressure: 15-20 psi.

Storage/Shelf Life

- DO NOT ALLOW PRODUCT TO FREEZE. PRODUCT WILL FREEZE AT 32°F - 35°F.
- Close container tightly when not in use and store off the floor in a well ventilated area.
- Rotate stock.
- Shelf life expires 1 year from manufacture date.
- Stirring not required.

Clean-up/Disposal

- FOR BEST RESULTS, CLEAN EQUIPMENT AND EXCESS ADHESIVE IMMEDIATELY WITH COLD WATER. DO NOT ALLOW TO DRY.

- Use ammoniated cleaners before adhesive film cures.
- Use WA 110 solvent to clean dried, cured adhesive from equipment.
- Use WA 121 to clean dried, cured overspray from finished assembly. DO NOT USE WA 121 TO CLEAN EQUIPMENT!
- Dispose of waste in accordance with regulations.

Primary Contents

- Zinc oxide (CAS 1314132)
- Water (CAS 7732185)
- Polychloroprene (CAS 9010984)
- NUTSRN (CAS 16595122P)

GREENGUARD® Indoor Air Quality Standard for Low Emitting Products

GREENGUARD Indoor Air Quality Certified Products meet the following minimum emission requirements:

Category: Adhesives/Sealants

Emission Types	Measure
Individual VOCs	<0.1 TLV
Formaldehyde	<0.05 ppm (<0.06 mg/m ³)
4-phenylcyclohexane	<0.0065 mg/m ³
Styrene	<0.07 mg/m ³
Total VOCs	<0.05 mg/m ³
Total aldehydes	<0.1 ppm

Volatile 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.

Safety

KEEP OUT OF REACH OF CHILDREN! Apply and dry this adhesive only with adequate ventilation and exhaust approved by local authorities. May be irritating to eyes, skin and respiratory tract. See MSDS for complete data.

HMIS Rating: Health 2, Flammability 0, Reactivity 0

24-hour Chemtrec number: US 1-800-242-9300; International 703-527-3887

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.

Shipping Information

- Ship Domestic Ground
- DOT Non-regulated

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: Tech Data Sheets, Material Safety Data Sheets (MSDS), Adhesive Quick Reference Chart, Certified Product Data Sheets (CPDS)
- Customer Service Line 1-800-433-3222
- Wilsonart Adhesives Division
10601 NW HK Dodgen Loop
Temple, Texas 76503-6110