



## PRODUCT DATA SHEET

CHOICE BRANDS ADHESIVES, 666 REDNA TERRACE #500, CINCINNATI, OH 45215 513-772-1234

**Product Number:** HS / HSR

**Description:** Neoprene Contact Adhesive, High Solids Spray Grade

### Typical Physical Properties:

<b>Viscosity:</b>	225 cps	<b>Coverage:</b>	192 sq ft/gallon
<b>Dry Time:</b>	3 – 5 Minutes	<b>VOC:</b>	538 g/l (EPA Method 24)
<b>Solids:</b>	26% +/- 1%	<b>Coverage Rate:</b>	2.5 dry grams/sq ft minimum
<b>Open Time:</b>	45 minutes	<b>Clean Up:</b>	Choice Brands 689
<b>Color:</b>	Natural/Red	<b>Shelf Life:</b>	1 Year in unopened container
<b>Solvents:</b>	Organic solvents	<b>Class:</b>	Extremely Flammable
<b>Flash Point:</b>	- 20 deg F	<b>Packaging:</b>	5 gal, 54 gal and tote containers

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

**Meets Wisconsin Standard for minimum solids content of Contact Adhesives**

### Properties:

- High solids flammable spray grade adhesive.
- Excellent adhesion to a variety of substrates including, but not limited to laminates, particle board, plywood, hardwood, rubber and metal.
- Excellent room temperature contact-ability.
- Excellent green strength and high heat resistance.
- 45-min open time.

### Application:

1. Agitate adhesive before use.
2. Substrates should be clean and free of moisture, dirt, oil and other contaminants.
3. For best results, adhesive and substrates should be allowed to acclimate to room temperature (approximately 60°F or above) before application of adhesive.
4. The adhesive should be applied at approximately 2.5 dry grams per square foot. The adhesive should cover 80% of the surface of the substrate. The coated substrate surface should exhibit a uniform glossy sheen when the adhesive is completely dry. Dull areas indicate insufficient coverage. Adhesive should be re-applied to these areas.
5. When bonding porous substrates, it is advisable to apply two coats of adhesive. The first coat will act as a sealer and prevent excessive absorption of the adhesive into the substrate. After the first coat has dried, apply a second coat. Allow the second coat to completely dry before assembly.

NOTICE TO PURCHASER: The information, data and suggestions for use of the materials given here are based on our best experience and knowledge, but we do not guarantee the results to be obtained in customer's processes. The products discussed are sold without any warranty regarding merchantability or fitness for a particular purpose or any other warranty express or implied. Before using, user shall determine the suitability of the product for his intended use, and user assumes all risk and liability whatsoever in connection therewith. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or the inability to use the product. Sellers and manufacturers only obligation shall be to replace such quantity of the product proved to be defective. Since the manufacturer of the described in this data sheet has no means of controlling the final use of the product by the consumer or user, it is the responsibility of the immediate purchaser and any intermediate sellers to inform the user of the purposes for which the product may be fit and suitable, and of the properties of the product, including the precautionary measures which must be taken in order to insure the safety of the user and of other third persons and property.



CHOICE BRANDS ADHESIVES, 666 REDNA TERRACE #500, CINCINNATI, OH 45215 513-772-1234

- 6. Allowing contact adhesive to dry completely before assembly is essential to obtaining a secure, permanent bond. To check for adhesive dryness, press a piece of Kraft paper onto the adhesive surface. If there is transfer of adhesive to the paper, more time is required to let the adhesive dry. If there is no transfer, substrates are ready for bonding.
- 7. If areas exist with excessive adhesive deposition, twist the (gloved) fingers while pressing them onto the adhesive layer. This will break any film that has formed as the adhesive dries from the top surface down. If a skin has been formed, allow more time for evaporation to ensure complete removal of solvent before bonding.
- 8. Dry times can be improved through the use of air movement, drying ovens, lamps, etc.
- 9. Substrates may be indexed together and bonded once the adhesive is dry. Bonds must be made within the open time of the adhesive. (open times may vary by adhesive – see specification on page 1).
- 10. Uniform pressure on the bonded laminates is necessary to create strong, lasting bonds. 40 pounds per linear inch is recommended to insure complete fusion between the two layers of adhesive to be bonded. A pinch roller is ideal for applying uniform pressure. When used properly, a J-roller can also provide adequate pressure for bonding
- 11. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed, and machined.

**Recommended Equipment:**

	Manual	Systems	Automatic	Systems
	Binks	DeVilbiss	Binks	DeVilbiss
Spray Gun	95, 2001,2100	JGA510, MSA510	21,95A	AGX550
Fluid Tip	63B-SS	FX	63C-SS	FX
Fluid Needle	663A, 563A	FX	263A,663A	FX
Air Cap	66SD-3	24	66SD-3	24

**Application Precautions:**

Do not use on polystyrene foams or plasticized vinyls  
Do not mix with other adhesives. Thinning the adhesive is not recommended.

**Storage Conditions:**

Rotate stock, use oldest first.  
Keep covered to prevent solvent loss and contamination.  
Do not freeze. Store product between 60 – 80°F.  
Do not store in direct sunlight.

**Please Refer To The Material Safety Data Sheet For Further Information.**

NOTICE TO PURCHASER: The information, data and suggestions for use of the materials given here are based on our best experience and knowledge, but we do not guarantee the results to be obtained in customer's processes. The products discussed are sold without any warranty regarding merchantability or fitness for a particular purpose or any other warranty express or implied. Before using, user shall determine the suitability of the product for his intended use, and user assumes all risk and liability whatsoever in connection therewith. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or the inability to use the product. Sellers and manufacturers only obligation shall be to replace such quantity of the product proved to be defective. Since the manufacturer of the described in this data sheet has no means of controlling the final use of the product by the consumer or user, it is the responsibility of the immediate purchaser and any intermediate sellers to inform the user of the purposes for which the product may be fit and suitable, and of the properties of the product, including the precautionary measures which must be taken in order to insure the safety of the user and of other third persons and property.