



PRODUCT DATA SHEET

CHOICE BRANDS ADHESIVES, 666 REDNA TERRACE #500, CINCINNATI, OH 45214 513-772-1234

PRODUCT NUMBER: 661

TYPE OF ADHESIVE: Canister Contact Adhesive, Spray Grade Clear

TYPICAL TECHNICAL DATA:

Adhesive:	Flam/Flam (propellant/adhesive)	Pattern:	Web
Dry Time:	3 – 5 Minutes	Solvents:	Methyl Acetate, Hexane
Open Time:	30 minutes	Flash Point:	-156 deg F
Color:	Clear	VOC:	518 grams/liter (EPA Method 24)
Coverage Rate:	2.5 dry grams/sq ft minimum	Clean Up:	Choice Brands 689 or Citrus Cleaner
Shelf Life:	1 Year in unopened container	Class:	EXTREMELY FLAMMABLE
Availability:	10, 30, 140 and 300 lb canisters	Shipping:	Liquified gas, flammable, 2.1, UN3161

Approximate Coverages – single surface application:

10 lb canister - 455 sq ft

140 lb canister – 7600 sq ft

30 lb canister – 1600 sq ft

300 lb canister – 16,300 sq ft

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

PROPERTIES:

- Excellent adhesion to a variety of substrates including, but not limited to laminates, particle board, plywood, hardwood, leather, rubber, and metal
- Excellent room temperature contactability
- Excellent green strength and high heat resistance
- Portable system

CANISTER SET UP AND PRECAUTIONS:

Attach and securely tighten a hose, in your length of choice to the matching fitting provided on the gun. Attach the other end of the hose to the matching fitting on the canister. It is recommended that plumbers tape be used on the fittings to assure an air tight seal. Check the fittings again for tightness. Slowly open the valve on the top of the canister and check for leaks. Half way is recommended at first.

When hose is connected, keep canister valve open and hose pressurized at all times. Do not disconnect the hose until ready connect to new canister. Release pressure in hose before disconnecting from canister. For optimum performance, store at 70° F (18°C) during use. Canister must be above 50° F (10° C). Do not use in applications with copper or aluminum components. This adhesive is not recommended for use with plasticized vinyl, flexible

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plastics, expanded/extruded polystyrene, polyethylene, or polypropylene. Use only in well ventilated areas. Do not use near ignition sources

PROPER APPLICATION OF CANISTER ADHESIVE:

1. Prepare the surface to be bonded. Ensure both faces are clean and free of dust, dirt and grease. If necessary, wipe clean with SIA Citrus Cleaner.
2. Hold spray gun at a constant distance of between 6-10 inches (150-250mm) from the surface, allowing adhesive to cobweb across the surface with minimal overlap for thick laminates. For thin laminates allow for approximately 50% overlap of successive passes to prevent telegraphing.
3. Maintain a constant hand speed during spraying. Apply a consistent and thorough coating without allowing the adhesive to puddle or heavily wet the surface. Maximum bond strength is achieved with substrate coverage between 80-100% with a recommended coat weight minimum of 2 dry grams per square foot.
4. Maximum adhesion will be obtained by spraying opposing mating faces with an adhesive pattern at 90° angles to each other. (Example: Face one substrate vertically while spraying. Face the other substrate horizontally.) Extra coverage is recommended at substrate edges.
5. Hold spray gun at 90° to substrate surface while spraying. Release trigger at end of each pass to optimize coverage.
6. Allow adhesive to dry completely before attempting assembly. (Dry time may vary due to humidity and temperature variations.) Test for dryness using back of hand only – surface should be tacky, but adhesive should not transfer to the skin.
7. Position substrates carefully and apply pressure. Work from the center of the substrate, out to prevent bubbles and wrinkles. Apply adequate pressure (40 PLI) using a nip roller. Proper use of a 3" J-roller will also provide proper pressure.
8. The bonded assembly is immediately able to be trimmed or routed. Full bond strength is achieved after 24-48 hours depending on temperature and humidity.

STORAGE CONDITIONS: Store between 60 and 90 degrees F for best performance. Do not expose to direct sunlight. Diminished performance may occur below 60 degrees. If so, warm canister to room temperature. Remove directly from concrete floor in cold temps. Do not freeze.

ATTENTION: Empty container remains hazardous until all flammable vapors, which may explode upon ignition, are gone from residue and container. Observe all labeled hazard precautions. Do not cut, puncture, or weld while hazard exists. Do not reuse empty container. Recycle, or dispose of, according to all federal, state, and local regulations.

Use in conjunction with: Adjustable Spray Gun (part no LJC6106) w/ 6501 Tip and hose

Please refer to the Material Safety Data sheet for further information.

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