

## USF Contract Propack Contact Adhesive 30-NF Green

## Application

### Features

- Non-flammable in the wet state
- Post-formable and heat resistant
- **Certified to GREENGUARD® Product Emission Standard For Children and Schools(SM) for low emitting interior building materials:**
  - Addresses or Contributes to LEED™ EQ Credit 4.1: Low Emitting Materials: Adhesive and Sealants

### Product Description

- Water-dispersed, spray-able contact adhesives for high immediate bond strength and long bonding range.

### Typical Physical Properties

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

- Product Contract Pro-pack Contact Adhesive 30H
- Base: Polychloroprene
- Color: Green, Blue (Wet), Green (Dry) Blue (Wet), Green (Dry) Neutral, White (Wet), Clear (Dry)
- Net Weight: 8.9 - 9.3 lbs./gal. 8.9 - 9.3 lbs/gal
- Solids (by wt): 47-51% 45-50%
- Solvent: Water, less than 5% Water, less than 5% Toluene and Methanol Toluene and Methanol
- Flash Point: None – Setaflash® closed cup tester
- Coverage: 680 sq. ft/gal 680 sq. ft/gal (@ 3 gms/ft.2 dry wt.)
- Viscosity: 200-750 cps 5500-9500 cps
- Brookfield Viscometer: RVF #2 sp. @ 20 rpm @ 80°F RVF #4 sp. @ 20 rpm @ 77°F
- Handling/Application

### Directions for Use:

#### Surface Preparation:

- Surfaces must be clean, dry and dust free. Wiping with a solvent such as 3M™ Scotch-Grip™ Solvent No. 3\* will aid in removing oil and dirt.
- Temperature of adhesive and surfaces during fabrication should be at least 65°F (18°C).

#### Application:

- Apply a uniform, generous coat of adhesive to both surfaces with a nylon brush, roller (texturing type), or spray. One coat is usually sufficient on most surfaces. Dull spots when dry indicate insufficient adhesive. Very porous material may require more than one coat.
- Allow adhesive to dry completely between coats. A uniform, glossy film indicates sufficient adhesive.

#### Coverage:

- Coverage is dependent upon porosity of the substrate and the method by which the adhesive is applied.
- Use 3.0-3.5 gms/ft<sup>2</sup> of dry adhesive per surface for wood, particleboard and high-pressure laminates with the adhesive applied by spray or roller. More adhesive (lower coverage) is recommended if very soft wood, fabrics, foams, etc. are to be bonded, or if the adhesive is applied by brushing.

#### Drying Time:

- The adhesive dries sufficiently in 30 minutes under normal temperatures and humidity to make bonds. High humidity will slow the drying; high temperature will speed the drying.
- After the adhesive is dry the bond must be completed within four hours.

#### Assembly:

- Spacers, such as dowels or strips of laminate, may be used to help prevent premature adhesive to adhesive contact and bonding prior to positioning. Slide out the spacers and apply uniform pressure, working toward the edges.

- A 3 in. wide (maximum) roller with maximum body pressure should be used to help ensure adequate contact and bonding, especially on edges. Bonded assemblies may be machined, trimmed, etc. immediately after bonding.
- The use of a pinch or nip roll is preferred for optimum performance.

**Cleanup:**

- If adhesive has not dried, clean equipment with water containing a small amount of detergent.
- When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.
- Cleaning solution: One pint of cleaner to five gallons of water. Flush with clean water.

\*\* Adhesive cannot be cleaned off rollers or brushes after it has dried.

**Application Tips for Using USF Contact Adhesive**

**(1) Working Temperature:**

The adhesive and both surfaces to be bonded should be 65°F (18°C) or above at the time of bonding. After storage at low temperature and before using, the adhesive must be warmed to room temperature. Do not place in oven or on stove; bring to temperature by placing in a warm room. If this is not done, the open time and other working properties of the adhesive may be adversely affected.

**(2) Use Enough Adhesive:**

It is important to remember that it is difficult to use too much adhesive, but you can have problems if you don't use enough. USF Contract Pro-pack Adhesive must be applied to both surfaces. Adhesive can be applied by spray (see Application Equipment Suggestions), brush or a texturing type roller. Non-porous surfaces should require only one coat, while porous surfaces may require two coats. Wherever you use more than one coat, be sure to let the adhesive dry completely between coats. Hardwoods, tempered hardboard and decorative laminates are non-porous. Soft woods, un-tempered hardboard, plywood and plaster are typical porous surfaces which may require two coats.

**Note:** USF Contract Pro-pack contact adhesives should never be thinned.

**(3) Let Adhesive Dry Completely:**

Under normal temperature and humidity conditions, Fastbond contact adhesive 30 will dry in approximately 30 minutes. In very warm, low humidity conditions, drying may take as little as 10-15 minutes. Lower temperatures and higher humidity mean slower drying. When the adhesive coating completely loses its milky appearance and becomes clear, it is ready to bond. You have four (4) hours after the adhesive is dry in which to complete the bonding job. You can bond as soon as it is dry, but the longer you wait the stronger the initial bond will be. To speed drying, infrared heat lamps may be used. When force drying is used, assembly and bonding must be completed while one or both of the bonding surfaces is warm. If both surfaces are cold, reheat either or both before bonding. If your two surfaces do not grab onto each other immediately when brought into contact, the adhesive has dried too long or not enough adhesive was applied. In either case, another coat of adhesive over each surface will remedy the problem.

**(4) Apply Pressure Thoroughly:**

Bonding is immediate upon contact. Sustained pressure is not required, but good uniform pressure must be applied to every square inch of the surface. Apply pressure by using heavy body pressure on a small (not over 3") hand "J"-roller. The use of a pinch roll is preferred for optimum performance.

**Note:** Rolling pins and other wide rollers are unsatisfactory because they bridge low spots and because they distribute the pressure over too large an area.

**(5) Assembling:**

Position the surfaces carefully before assembly. No adjustment is possible after the adhesive films make contact. Use the paper slip-sheet method or spacers to position large pieces.

**(6) Finishing:**

Bonded assemblies can be machined, trimmed and finished immediately after bonding.

**Application Equipment Suggestions**

**Hand Held Spray Air Fluid Air Approximate Fluid Flow\* Applicators Cap Tip Pressure Air Requirement**

Binks 2001SS, 95 66SD 65SS 10-15 psi 6 scfm @ 20 psi 9-12 fl. oz./min.

DeVilbiss MSA-510 #30 FF 10-15 psi 6 scfm @ 20 psi 9-12 fl. oz./min.

**H.V.L.P. (high volume, low pressure)**

Binks Mach 1 95P 94F 30 psi 11 scfm @ 30 psi 9-12 fl. oz./min.

**Automatic Spray Applicators**

Binks No. 95A 66SD 65SS 10-15 psi 6 scfm @ 20 psi 9-12 fl. oz./min.

H.V.L.P. Mach 1A 95P 94F 30 psi 11 scfm @ 30 psi 9-12 fl. oz./min.

**Note:** Appropriate application equipment can enhance adhesive performance. We suggest the following application equipment for the user's evaluation in light of the user's particular purpose and method of application.

**(7) Cleaning:**

Brushes or rollers which are to be reused should be wrapped with plastic wrap to keep adhesive wet as complete cleaning is difficult.

**Note:** Never pour solvent onto a bonded surface; it will attack the adhesive line and weaken the bond. Just wipe with cloth dampened in solvent or cleaner such as 3M™ Citrus Base Cleaner. \* Turpentine will not dissolve the adhesive.

\*When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

**(8) Air Atomizing Spray Equipment**

\*To measure fluid flow: Pressurize fluid source only; pull trigger; flow material into measuring device for 60 seconds; increase or decrease fluid source pressure to obtain desired fluid flow.

**Note:** Low pressure, air operated piston pumps should not be used with these products.

**(9) Pressure Pot:** Polyethylene liner. Dip tube and fittings should be plastic or stainless steel.

**(10) Pumping Equipment:** 1 in. plastic diaphragm pump with Teflon® checks and diaphragms such as manufactured by Warren Rupp Co.

**(11) Filter:** (pump output) Graco model 12 (stainless steel) with filter bag #521-264 or equivalent.

**(12) Airless Spray:** This product can be airless sprayed. Fluid tips ranging from .018 in. to .031 in. at fluid pressures up to 1,100 psi are normally used.

**(13) Hoses:** All material hoses should be nylon or polyethylene lined with plastic or stainless steel fittings.

**(14) Roll Coating:** 3M™ USF ContractContact Adhesive 30H may be coated with a machine type roll coater such as manufactured by Black Bros., Mendota, IL. Roll covering should be urethane with 24 grooves per inch for most applications.