Product Data Sheet

Product Number: **F-180 / F-180G**
Description: **Neoprene Water Base Contact Adhesive**

Typical Physical Properties:

Solids:	50.0% +/- 1%	Shelf Life:	6 months in unopened container
Viscosity:	600 cps	Color:	Natural/Clear(when dry) / Green
Coverage:	375 bonded ft2 @ 3.0 dry grams	Packaging:	Drums, pails, gallons
Open Time:	60 minutes	VOC:	53 g/l (EPA Method 24)
		Clean Up:	Warm, soapy water
		Flash Point:	N/A

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

Properties:

- Excellent room temperature contactability
- Excellent mileage,
- Excellent bond adhesion to a variety of substrates including decorative, laminates, particleboard, plywood, metal, honeycomb and leather.
- Provides good uniform coverage in hand and automatic spray applications.
- Excellent green strength and high heat resistance for high speed postforming applications.
- Extremely low VOC content
- OTC and SCAQMD compliant
- Meets or exceeds Spec A-A-1936 (1996); Type II (supersedes Fed. Spec. MMM-A-130B)

Application:

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Temperature of adhesive and substrates during fabrication should be at least 65°F (18°C) for best results.
3. F-180 can be brushed, rolled and sprayed. If bushing and rolling, apply 100% coverage (3.0 dry grams/sq. ft. or higher). If spraying, coating weight of 2.5 to 3.5 dry grams should be applied. The atomization pressure at the gun should be 5 to 20 psi and the fluid pressure should be 10 to 15 psi.
4. When applying contact adhesives to porous materials such as plywood and edges, it is advisable to apply two coats. Apply the first coat and allow to dry. This will act as a sealer. When dry, apply the second coat and allow to dry properly before bonding. This helps to insure that the adhesive does not soak-in below board fiber and that you have the proper amount on the surface to achieve a strong, permanent bond.
5. Allow the adhesive to dry properly before bonding. Water borne contact adhesives will change color when dry. However, to check for dryness, use the back of your fingers and press into the adhesive and lift up. Any adhesive transfer indicates that the adhesive requires more time to dry. If the adhesive feels tacky, but there is no

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transfer to the fingers or opaque areas in the adhesive, the adhesive is ready for bonding. Dry time can vary depending on temperature, humidity and coating weight. Drying time can be reduced using air movement, drying ovens, lamps, etc.

6. Typical drying will occur in 30 minutes, however, dry time can vary depending on temperature. Bonds can be made as soon as the adhesive is dry. However, bonds made any time in the one hour open time will be as strong as those made immediately after dry.
7. Position the pieces carefully, since a strong bond is made instantly upon contact. Spacers such as dowels or strips of laminate should be used to prevent contact prior to proper positioning.
8. Use good uniform pressure. Use the maximum possible pressure without damaging the substrates. Minimum recommended pressure is applied with a J-roller.
9. The completed panel can be routed or trimmed, cut, filed and machined immediately.

SUGGESTED EQUIPMENT:

	Automatic Binks/DeVilbiss	**Manual Binks/DeVilbiss**
Spray Gun	Mach 1A / Spirit H2000	Mach 1 / V3
Fluid Tip	94 / FF	94 / FF
Fluid Needle	47-478 / FF	54-3941 / FF
Air Cap	94P / 28,33	94P / 28,33A

Application Precautions:

DO NOT use copper and its alloys to transfer or contain any contact adhesive.
DO NOT laminate copper with this adhesive.
DO NOT exceed the recommended “open time.”
Thinning the adhesive is not recommended. .
DO NOT use on plasticized vinyls.

Storage Conditions:

Keep adhesive container closed tightly when not in use.
Store closed, lined containers where temperature will be between 50°F and 80°F
Product should not be stored in direct sunlight.
Product is not freeze/thaw stable. Protect from freezing.
Product should not be used after being frozen.

REFER TO THE MATERIAL SAFETY DATA SHEET PRIOR TO USE.