



# Product Data Sheet

**Product Number:** F-270AC  
**Description:** Cal & OTC Complaint Canister Contact Adhesive, Air Assisted

**Typical Physical Properties:**

<b>Adhesive:</b> Flam/Flam (propellant/adhesives)	<b>Spray Pattern:</b> Mist or Web
<b>Dry Time:</b> 2 - 3 Minutes	<b>Solvents:</b> compressed air
<b>Open Time:</b> 30-45 minutes	<b>VOC:</b> 0 g/l (EPA Method 24)
<b>Color:</b> Natural	<b>Clean Up:</b> Choice 689 or Citrus Cleaner
<b>Coverage Rate:</b> 2.5-3.0 dry grams/sq ft minimum	
<b>Shelf Life:</b> 1 Year in unopened container	<b>Packaging:</b> 9, 27,130, 250 lb canisters

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

**Properties:**

- OTC & Cal Compliant, Leed Compliant 4.4: No-Urea Formaldehyde added.
- Mist spray pattern eliminates telegraphing
- Soft spray allows for greater control of pattern and application rates
- High solids means extended mileage
- Excellent Heat resistance and bond strength

**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. 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 (21°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 plastics, expanded/extruded polystyrene, polyethylene, or polypropylene. Use only in well ventilated areas. Do not use near ignition sources.

Modify existing fluid line fitting to attach to the back of Devilbis or Binks Conventional spray gun. This fitting can be obtained by your spray equipment distribution. Attach atomizing air line with air regulator to your spray gun. Open fluid line at canister and adjust fluid and air pressure at gun to achieve spray fan patterns of 8 to 12 inches.

Typical atomization pressure of 50-65 psi.

	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

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666 Redna Terrace, Suite 600  
Cincinnati, OH 45215  
Customer Service: (800) 330-5566

## **Application:**

1. Prepare the surface to be bonded. Ensure both faces are clean and free of dust, dirt and grease. If necessary, wipe clean with CBA 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 2.5-3.0 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. Apply a minimum of 3.0 dry grams/sq. ft. For best results, apply two coats of adhesive to any porous surface; one base coat and a secondary top coat. This ensures adequate layup particularly on CARB 2 PARTICLEBOARD and other similar surfaces. Allow the second coat to completely dry before assembly. 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.
7. Make sure to coat all exposed edges and corners with two coats of adhesives. 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.
8. 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
9. 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° 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.

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