



## Product Data Sheet

FORMICA is a registered trademark of the Formica Corporation  
Manufactured by: Choice Brands Adhesives

666 Redna Terrace, Suite 500  
Cincinnati, OH 45215  
Customer Service: (800) 330-5566

### Product: F-270/F-270R Flammable Contact Adhesive

#### **BENEFITS:**

VOC Free  
Good Open Time (1 hour)  
CAL/SCQAMD Compliant  
OTC Compliant

#### **TYPICAL PHYSICAL PROPERTIES**

Base: Synthetic Rubber  
Flammability: Highly Flammable  
Solids: 37%  
Viscosity: 200 cps  
Color: Clear/Red  
VOC: 0 g/l (EPA method 24)  
Packaging: 5 and 54 gl containers  
Clean Up: 689  
Shelf Life: 1 Year

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

#### **SUGGESTED USE:**

F-270 is a VOC free, fast-drying, contact adhesive designed to produce a strong permanent bond in the decorative laminate industry. It can also be used for general purpose applications such as headliners, carpeting & foam fabrication. Its outstanding features include high initial tack, high green strength and long open time. It is also VOC free.

#### **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 3.0 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.
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.

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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

### SUGGESTED EQUIPMENT:

	Manual ms		Automatic ms	
	Binks	DeVilbiss	Binks	DeVilbiss
Spray Gun	95, 2001,	A510, MSA510	21,95A	AGX550
Fluid Tip	63ASS	FX	63ASS	FX
Fluid Needle	663A, 563A	FX	263A, 763A	FX
Air Cap	66SD-3	24	66SD-3	24

### SHIPPING CLASSIFICATION:

DOT and IMDG Road, Rail and Water: UN1133, PG 11, Class 3

### PRECAUTIONS:

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

### STORAGE CONDITIONS:

Store between 60 and 90°F. Do not store in direct sunlight  
If exposed to freezing temperatures, return product to room temperature.

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