



# Product Data Sheet

**Product Number:** F158 / F-159  
**Description:** Neoprene Contact Adhesive, Spray Grade For Flat Work

## Typical Physical Properties:

Viscosity:	200 cps	Dry Time:	3 – 5 Minutes
Solids:	17.5% +/- 1%	Open Time:	30-45 minutes
Color:	Red / Natural	Solvents:	Organic solvents
Flash Point:	- 20 deg F	Clean Up:	Choice Brands 689
Coverage:	133 sq ft/gallon bonded surfaces	VOC:	586 g/l (EPA Method 24)
Coverage Rate:	2.5 dry grams/sq ft minimum	Packaging:	5 gal, 54 gal and tote containers
Class:	Extremely Flammable	Shelf Life:	1 Year in unopened container

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

## Properties:

- Economy flammable spray grade contact cement
- Excellent adhesion to a variety of substrates including, but not limited to laminates, particle board, plywood, hardwood, leather, rubber, and metal
- Excellent room temperature contact-ability
- Excellent green strength and high heat resistance
- Excellent spray-ability (hot or cold spraying)

## 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 adhesive application.
4. The adhesive should be applied at approximately 2.5 grams/square foot. The adhesive should cover 80% of the substrate surface. The substrate surface should exhibit a uniform glossy sheen when the adhesive is completely dry. Dull areas indicate insufficient coverage. Adhesive should be reapplied 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 adhesive into the substrate. After the first coat has dried, apply a second coat. Allow the second adhesive coating to dry completely before assembly.
6. Allowing the contact adhesive to dry completely before assembly is essential to obtaining a secure, permanent bond. To check for adhesive dryness, press the back of your fingers onto the adhesive surface. If adhesive transfers to fingers, additional dry time is necessary. If there is no adhesive transfer, the substrates are ready for bonding.
7. If areas exist with excessive adhesive deposition, twist the fingers while pressing them onto the adhesive layer. This will break any skin that may have formed as the adhesive dries from the top surface down. If a skin has formed, allow additional dry time to ensure complete evaporation of the solvent before bonding.

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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 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 ensure complete fusion between the two layers of adhesive. A pinch roller is the ideal method for applying uniform pressure. When used properly, a J-roller can also provide sufficient pressure for bonding.
11. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed and machined.

#### **Recommended Equipment:**

	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

#### **Application Precautions:**

Do not use in applications with copper components.  
 Do not use on polystyrene foams or plasticized vinyls  
 Do not mix with other adhesives. Thinning the adhesive is not recommended.

#### **Storage Conditions:**

Rotate stock, use oldest first.  
 Keep covered to prevent solvent loss and contamination.  
 Do not freeze. Store product between 60 – 80°F.  
 Do not store in direct sunlight.

**Please Refer To The Material Safety Data Sheet For Further Information.**