



# F-150R / F-151

## Product Data Sheet

### Description:

F-150R/F-151 is a premium spray grade contact adhesive.

### Benefits:

- Excellent adhesion to a variety of substrates including, but not limited to laminates, particle board, plywood, hardwood, leather, rubber and metal
- Excellent room temperature contactability
- Postformable in manual and heated spray systems
- Excellent green strength and high heat resistance
- Excellent sprayability (hot or cold spraying)
- Meets or exceeds
  - Spec A-A-1936 (1996);
  - Type II (supersedes Fed. Spec. MMM-A-130B)

### Availability:

Pail, Drum

### Coverage Instructions:

Cover a minimum of 2.0-2.5 dry grams/sq. ft. on both surfaces.

### Storage Conditions:

- Rotate stock; use oldest first (FIFO)
- Keep container closed tightly when not in use
- Shelf life expires 1 year from manufacture date
- Do not store in direct sunlight
- If frozen, return to room temperature. Some agitation may be required

### Typical Physical Properties:

<b>Viscosity</b>	125 cps
<b>Dry Time</b>	3-5 Minutes
<b>Solids</b>	18% +/- 1%
<b>Open Time</b>	60 minutes
<b>Color</b>	Natural / Red
<b>Solvents</b>	Organic solvents
<b>Flash Point</b>	-20 deg F
<b>Coverage</b>	110-135 sq. ft./gallon
<b>VOC</b>	588 g/l (EPA Method 24)
<b>Coverage Rate</b>	2.0-2.5 dry grams/sq. ft. minimum
<b>Clean Up</b>	Choice Brands 689
<b>Shelf Life</b>	1 Year in unopened container
<b>VHAP</b>	2.35 lbs/lbs of solids
<b>Density</b>	6.7 wt/gl

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

### Application Precautions:

- Avoid application equipment containing aluminum or copper.
- Avoid copper or copper alloy substrates.
- Do not use on polystyrene foams or plasticized vinyls
- Do not mix with other adhesives.
- Do not use lacquer thinner for thinning.
- Thinning the adhesive is not recommended.
- **Please refer to the Safety Data Sheet (SDS) for further information.**

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**Application:**

1. For best results, agitate adhesive before use.
2. Substrates should be clean and free of moisture, dirt, oil and other contaminates.
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 2.0-2.5 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.
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.)
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

**Suggested Equipment:**

Product Specifications				
Typical Fluid Pressure		Atomization Pressure		Spray Pattern
10-15 psi		30-50 psi		Pebble
Spray Equipment				
Binks				
<i>Manual</i>	<i>Auto</i>	<i>Fluid Tip</i>	<i>Needle</i>	<i>Air Cap</i>
95, 2100	21, 95	63ASS	663A, 563A	66SD-3
Devilbiss				
<i>Manual</i>	<i>Auto</i>	<i>Fluid Tip &amp; Needle</i>		<i>Air Cap</i>
JGA-510, MBC-510	AGX	FX, FF		24, 797
CA Technologies				
<i>Gun</i>			<i>Set Up</i>	
Panther			1.5 x 2266-3T	
Tomcat			1.5 x 2266-3	