

## **TDS: PRODUCT DATA SHEET**

### **315 NON-FLAMMABLE SPRAY ADHESIVE**

A "high solids", spray grade contact bond adhesive in a non-flammable solvent. 315 N/F offers excellent sprayability, high mileage, long open time and good heat resistance along with fire safety and fast dry time.

#### **TECHNICAL DATA:**

BASE:	Compound synthetic rubber.
SOLVENT:	Methylene Chloride, trichloroethylene.
VISCOSITY:	1000 $\pm$ 100 cps.
SOLIDS CONTENT (by wt.):	28.5 $\pm$ 1.0%
WEIGHT PER GALLON:	10.0 $\pm$ 0.2 lbs/gal.
COLOR:	Clear, blue
SHELF LIFE:	Nine months, Sealed container.
COVERAGE:	525-575 sq. ft./gal at 3.0 dry gms./sq.ft.
PACKAGING:	55 gallon drums, 5 gallon pails.

#### **DESCRIPTION:**

315 N/F has been specifically formulated for use in bonding a wide variety of materials, including, but not limited to, decorative laminates, metals (not copper), plywood, particleboard, foamed polystyrene (using dry spray technique), polyurethane foam and rigid plastics.

The consistency of 315 N/F provides easy and uniform coverage, by spray, in all types and sizes of operations. It is high tack plus excellent combinability and green strength provides uniform high bonds under a wide variety of laminating conditions.

#### **FEATURES:**

- Excellent adhesion to a wide variety of substrates.
- Long "open tack" –permits flexibility in production.
- Aggressive grab with high green time.
- Designed for ease of sprayability – hot (120°) or cold.
- Gives significantly better mileage than most contact adhesives- flammable as well as non-flammable.
- Excellent long term bond performance. Bonds are resistant to humidity and water.
- Unharmed by freezing – simply warm water use.
- Non-flammable solvent system – no flash point.
- Non-photochemically reactive solvent – exempt, at this time, from most emission controls required by clean air standards.

#### **APPLICATION INFORMATION:**

Stir adhesive well before using. Surfaces to be bonded must be free from moisture, dirt, grease, oil, rust, or other contaminants. Normally it is applied to both surfaces at a rate of 2.5 – 3.0 dry grams of 315 N/F per foot of each surface. Deposit an even, uniform coating of adhesive with a visual coverage of at least 90% for a flat surface and 100% for edges due to porosity.

**SPRAY INFORMATION:**

	AUTOMATIC		MANUAL	
	BINKS	DEVILBISS	BINKS	DEVILBISS
Spray Gun:	21, 95A	AGB	95, 2001	JGA- A10, MSA- 10
Fluid Tip:	63C, 66	E, FF	63C, 66	E, FF
Fluid Needle:	63C, 66	E, FF	63C, 66	E, FF
Air Cap:	66SD-3	24	66SD-#, 66PJ	24
Atomization Pressure:	80 – 100 PSIG			
Fluid Pressure:	25 – 35 PSIFG			
Hot Spray Temperature:	120°F – 125°F			

**NOTE:** COPPER AND ITS ALLOYS SHOULD NOT BE USED TO TRANSFER OR CONTAIN ALUMINUM SHOULD NOT BE USED IN TANKS, LINES PUMPS OR OTHER EQUIPMENT USED TO CONTAIN, TRANSFER OR APPLY NON-FLAMMABLE SOLVENT ADHESIVES. **DO NOT USE COPPER WITH THIS ADHESIVE.** USE STAINLESS STEEL EQUIPMENT. USE TEFLON GASKETS FOR SPRAYING EQUIPMENT SEALS. DO NOT USE RUBBER SEALS.

**BONDING INFORMATION:**

Allow the adhesive to dry until entire coated area is still tacky but does not transfer to the touch. This normally occurs in 4-5 minutes at room temperature. Dry time is longer at high humidity, heavy coating or low temperature conditions and shorter when force dried using ovens, lamps, etc. An indication that sufficient adhesive has been applied is to look at reflected light off of the coated dry surface. Contact adhesives dry, under normal conditions, to a high gloss surface. If the coating does not have a high gloss, it is a strong indicator that insufficient adhesive has been applied to obtain a strong permanent bond. It is advisable to make bonds as the adhesive is dry, however, bonds made up to 45 minutes after dry time will be just as strong as those made immediately after dry time.

Position pieces carefully, since a strong bond is made instantly upon contact.

Use sufficient pressure to insure complete mating of the substrates. A nip roll or rotary press is ideal, using as much pressure as possible without crushing the substrates. Minimum recommended pressure would be applied using a 3-inch J roller.

Laminate can be trimmed, cut, filed or otherwise machined immediately after bonding.

**CAUTION: VAPORS HARMFUL. USE WITH ADEQUATE VENTILATION. READ PRECAUTIONS ON THE CONTAINER BEFORE USING. READ AND UNDERSTAND THE MSDS BEFORE USING.**

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