

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION:

ITW STA'-PUT® S200 is designed specifically for bonding high pressure laminates to various substrates. S200 is also suitable for a variety of applications in woodworking, manufactured housing, general construction, recreational vehicle, marine, furniture, textile, HVAC, upholstery and more. It can be used on many porous or non-porous surfaces where a permanent bond is required.

ADVANTAGE:

- Aggressive Grab Tack
- Quick Dry Time
- Long Open Time
- Excellent adhesion to many substrates
- High Green Strength
- High Strength Bonds
- Flatwork Applications (non-postforming)
- Self-Contained Portable Spray System

TYPICAL PROPERTIES:

Property	Typical Value
Base:	Synthetic Polymer
Solvent:	Methylene Chloride*
Shelf Life:	1 year from Date of Manufacture**
Colors:	Clear/ Red
Flash Point:	-156°F (-104°C)
Weight / Gallon	6.93 lbs/ gallon
VOC Content	436.2 g/L (EPA Method 24)
Open Time	30 minutes
Dry Time	2 - 5 minutes
Formaldehyde	No urea formaldehyde added during adhesive manufacturing

* Reports have associated repeated and prolonged occupational exposure to solvents with permanent brain and nervous system damage

** The shelf life for an unopened container of this adhesive stored at temperatures between 60°F (15.6°C) and 95°F (35°C) is 1 year from date of manufacture. Store out of direct sunlight in a cool, well-ventilated area. Avoid storing container directly on the floor or against an outside wall

APPROVED EQUIPMENT:

Surface Preparation:

- Spray gun: SG200
- Spray Tip: ST6501
- Hoses: MH973 (12'), MH978 (25')
- T-Bar: MH976

DIRECTIONS FOR USE:

- Use only after careful consideration of the warnings, directions, and first aid instructions given. Do not thin.
- Surfaces to be bonded should be clean, dry and free of any dust, loose paint, wax, moisture, dirt, grease, oil, rust, or other contaminants.
- Before initial use securely attach gun to hose, then hose to canister. Fully open canister valve; do NOT close valve until empty.
- Adhesive should be at 60°F to 95°F. For best results, adhesive and materials to be bonded should be 60°F (15.6°C) to 95°F (35°C) during application.
- Allow substrates to acclimate to room temperature for 48 hours before bonding.
- Spraying from 8 to 12 inches away, apply adhesive uniformly to both surfaces and cover each surface a minimum of 80%. Some porous surfaces may require two coats. 100% coverage is recommended for the edges. Use only approved equipment.
- For typical applications a coating weight of 2.5 dry grams per square foot is recommended.
- Both surfaces must be allowed to dry before bonding. This will usually take from 2 to 5 minutes at room temperature under normal conditions. Heat and humidity, or cold weather can effect drying times. Surfaces are dry if adhesive is tacky, but no adhesive transfers to the hand when touched.
- Complete the bond within 30 minutes (under normal conditions) after the adhesive is dry. If the two surfaces don't grab immediately when brought into contact, they have dried too long.
- Position coated surfaces carefully before putting them together since no shifting is possible once contact is made.
- Bring surfaces together and immediately apply firm pressure over entire surface working from the center to the edges. Apply a minimum of 30 psi uniform pressure over 100% of the area being bonded.
- Let bonded parts cure for at least 72 hours before exposing to direct sunlight of temperatures over 150°F (65.6°C).
- Do not use on some vinyls or polystyrene foam. Some vinyls contain plasticizers, which can, over time, soften and dissolve the bond, or bleed through/discolor. When in doubt, or if product is to be used on vinyls, or other light colored materials, conduct compatibility testing on the product to be bonded before use.



- After initial assembly, leave the hose and gun attached to the canister with the valve open.
- After safely releasing line pressure, detach gun and hose only when transferring to a new canister.
- Reattach gun and hose immediately.

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. Follow solvent manufacture's recommendations and instructions for safe handling.

**KEEP OUT OF REACH OF CHILDREN
FOR PROFESSIONAL OR INDUSTRIAL USE ONLY
USE ONLY WITH APPROVED EQUIPMENT**

NOTICE TO PURCHASER:

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Complete technical information is available from
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