

DESCRIPTION

Chem-SetTM 3079 is a methylene chloride free, OTC compliant canister contact adhesive.

BENEFITS

- Non-flammable, non-methylene chloride containing canister
- Portable system
- High bond strength and high heat resistance
- High temperature flammable canister contact cement
- Fast Drying
- Excellent adhesion to a variety of substrates including but not limited to laminates, particle board, plywood, hardwood, leather, rubber, and metal
- Excellent room temperature adhesion

HANDLING & APPLICATION

- Use only in well-ventilated areas.
- Do not use near ignition sources.

ATTENTION

- Always wear proper protective equipment.
- After use, treat remaining material as hazardous; observe all labeled hazard precautions.
- Do not cut, puncture, or weld.
- Do not reuse empty containers.
- Recycle or dispose of according to all federal, state, and local regulations.

PLEASE REFER TO THE SAFETY DATA SHEET FOR FURTHER INFORMATION.

STORAGE CONDITIONS

- Do not expose to direct sunlight.
- Diminished performance may occur below 60° F chemical temperature. If so, warm canister to room temperature.
- Insulate from concrete floor in cold temps.
- Do not freeze.

Use in conjunction with: Adjustable Spray Gun (part no LJC6106) w/ 6501 Tip or 9501 tip and hose.

AVOID APPLICATION EQUIPMENT CONTAINING ALUMINUM OR COPPER. AVOID COPPER OR COPPER ALLOY SUBSTRATES.

TYPICAL PHYSICAL PROPERTIES

Adhesive	Non-Flam/Non-Flam Propellant/Adhesive
Dry Time	1–2 minutes
Open Time	1 hour
Color	Natural
Flash Point	No Flash
VOC	194 g/L
Coverage Rate	1031 sq. ft. single sided
Clean Up	CBA689 Citrus Cleaner (gun/hose)
Shelf Life	1 year in unopened container
VHAP	<0.1%
Pattern	Web

SIZE AVAILABILITY

9 lbs.
30 lbs.
177 lbs.
350 lbs.

APPLICATION

1. Prepare the surface to be bonded. Ensure both surfaces are clean and free of dust, dirt, and grease. If necessary, wipe clean with CBA Citrus Cleaner.
2. Hold spray gun at a constant distance of between 6-10 inches (15-25cm) from the surface, allowing adhesive to cobweb across the surface with minimal overlap for thick laminates. For thin laminates, allow for approximately 50% overlap of successive passes to prevent telegraphing.
3. Maintain a constant hand speed during spraying. Apply a consistent and thorough coating without allowing the adhesive to puddle or heavily wet the surface. Maximum bond strength is achieved with substrate coverage between 80-100% and a recommended coat weight minimum of 2.5-3.0 dry grams/sq. ft.
4. Maximum adhesion will be obtained by spraying opposing mating faces with an adhesive pattern at 90° angles to each other. (Example: Face one substrate vertically while spraying and face the other substrate horizontally.) Extra coverage is recommended at substrate edges. (continued on page 2)

5. Hold spray gun at 90° angle to substrate surface while spraying. Release trigger at end of each pass to optimize coverage.
6. Apply a minimum of 2.5-3.0 dry grams/sq. ft. For best results, apply two coats of adhesive to any porous surface: one base coat and a secondary topcoat. This ensures adequate layup, particularly on CARB 2 particleboard and other similar surfaces. Allow the second coat to completely dry before assembly. 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.
7. Make sure to coat all exposed edges and corners with two coats of adhesives. Allow the adhesive to dry completely before attempting assembly. (Dry time may vary due to humidity and temperature variations.) Test for dryness using gloved hand only - surface should be tacky, but adhesive should not transfer.
8. Position substrates carefully and apply pressure. Work from the center of the substrate out to prevent bubbles and wrinkles. Apply adequate pressure (40-60 PLI) using nip roller. Proper use of a 3" J-roller will also provide proper pressure.
9. The bonded assembly can immediately be trimmed or routed. Full bond strength is achieved after 24-48 hours depending on temperature and humidity.

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