



# Product Data Sheet

**Product Number:** F-190 / F-190G  
**Description:** Water Base Contact Adhesive

**Typical Physical Properties:**

Solids:	55.0% +/- 1%	Shelf Life:	6 months in unopened container
Viscosity:	800 cps	Color:	Natural / Green
VOC:	75 g/l (EPA Method 24)	Packaging:	Drums, pails, gallons
Coverage:	375 bonded ft <sup>2</sup> @ 3.0 dry grams	Clean Up:	Warm, soapy water
Open Time:	60 minutes		

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

**SUGGESTED USE:**

A water-base contact adhesive with superior bonding properties that do not require any forced air-drying equipment. There is no premixing of various components thus eliminating pot life concerns. It is an effective contact cement for various substrates such as high pressure laminate, rigid fiberglass, steel, aluminum, leather, fiberglass insulation, carpet and fiberglass batts, various foams and rubbers just to name a few.

**APPLICATION:**

Please consult with your preferred equipment supplier to obtain best recommendations that will optimize your specific applications. It may be brushed, rolled or spray applied as a one component system. It should be applied to both substrates and allowed to dry. The two sides may then be mated with pressure. If bond is not formed, open time has been exceeded or there was an insufficient amount of glue applied. Substrates may be heat activated to 140° F and then pressed if there is adequate adhesive or recoated as before.

Cover 100% of the surface with at least 3 dry grams per square foot. Porous surfaces may require two coats. It is recommended to always use two coats on wood or particle board. One coat on laminate is usually sufficient, though better results will be obtained with two coats. Allow 5 minutes of drying between coats. Always double coat edges. The adhesive film should be shiny and clear when dry and ready to bond. If surface is dull, an insufficient amount of glue has been applied. When ready to bond, adhesive will be tacky to the touch but will not transfer to the finger. Finish making bonds within an hour after the adhesive is dry.

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666 Redna Terrace, Suite 600  
Cincinnati, OH 45215  
Customer Service: (800) 330-5566

**SUGGESTED EQUIPMENT:**

	<u>Automatic</u> <u>Binks/DeVilbiss</u>	<u>Manual</u> <u>Binks/DeVilbiss</u>
Spray Gun	Mach 1A / Spirit H2000	Mach 1 / V3
Fluid Tip	94 / FF	94 / FF
Fluid Needle	47-478 / FF	54-3941 / FF
Air Cap	94P / 28,33	94P / 28,33A

Spray equipment must have stainless steel fittings, passages, fluid tips and needles. Fluid lines can be nylon lined or PVC. This material should be pumped with a minimum of a 1” double diaphragm pump only. DO NOT use piston/pogo pumps.

**Things to avoid:**

Copper, brass, aluminum, galvanized, zinc or non-stainless steel spray system or fluid components. Spray and transfer components should only be non-reactive materials such as plastic or stainless steel.

- Surfaces with dirt, grease or excessive moisture.
- Vinyl’s with plasticizers which attack the bond line (conduct pre-testing if in doubt).

**SHIPPING CLASSIFICATIONS:**

DOT and IMDG Road, Rail and Water: Adhesives Not Regulated

**PRECAUTIONS:**

**Please refer to the Material Safety Data Sheet for further safety information.**

**STORAGE CONDITIONS:**

Do not freeze material. Keep container sealed when not in use. Do not store in direct sunlight. Do not store below 50 degrees. Rotate stock.

**REFER TO THE MATERIAL SAFETY DATA SHEET PRIOR TO USE.**