



Formica F-200XM

Canister Adhesive

PRODUCT DATA SHEET

DESCRIPTION

Formica F-200XM is non-methylene chloride canister contact adhesive.

BENEFITS

- Product is free of methylene chloride
- Excellent adhesion to a variety of substrates including, but not limited to laminates, particle board, plywood, hardwood, leather rubber and metal
- High solids mean extended mileage
- Soft spray allows for greater control of pattern and application rates
- Portable system

HANDLING & APPLICATION

- Attach and securely tighten a hose to the matching fitting provided on the gun. Attach the other end of the hose to the matching fitting on the canister.
- It is recommended that plumber's tape be used on the fittings to ensure an airtight seal. Check the fittings again for tightness.
- Slowly open the valve on the top of the canister and check for leaks. Halfway is recommended at first.
- When the hose is connected, keep canister valve open and hose pressurized at all times.
- Do not disconnect the hose until ready to connect to new canister. Close valve and release pressure in hose before disconnecting from canister.
- Do not use with spray equipment containing copper or aluminum components.
- This adhesive is not recommended for use with plasticized vinyl, flexible plastics, expanded/extruded polystyrene, polyethylene, or polypropylene.
- Use only in well-ventilated areas.
- Do not use near ignition sources.

ATTENTION

- Empty container remains hazardous until all 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.

PLEASE REFER TO THE SAFETY DATA SHEET FOR FURTHER INFORMATION.

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

TYPICAL PHYSICAL PROPERTIES

Adhesive	Flam/Flam Propellant/Adhesive
Dry Time	2-3 minutes
Open Time	30-45 minutes
Color	Natural, Red and Green
Flash Point	-156°F
VOC	384 g/L
Coverage Rate	2.5-3.0 dry grams/sq. ft. minimum
Clean Up	CBA689 Citrus Cleaner (gun/hose)
Shelf Life	1 year in unopened container
VHAP	VHAP Free
Pattern	Web

SIZE AVAILABILITY

Formica F-200XM -030	30 lbs.
Formica F-200XM -140	140 lbs.
Formica F-200XM -300	300 lbs.

STORAGE CONDITIONS

- Rotate stock; use oldest first (FIFO)
- Store between 60 and 90°F
- Shelf life expires 1 year from manufacture date
- Do not store in direct sunlight
- Diminished performance may occur below 60° F. If so, Remove from concrete floor in cold temps.
- If frozen, return to room temperature. Some agitation may be required

Use in conjunction with: Adjustable Spray Gun (part no LIC6106) w/ 6501 Tip and hose

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3.2 and 4.4: laminating adhesives shall

contain no added urea formaldehyde resins





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 (150-250mm) 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 per square foot.
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.
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 back of hand only - surface should be tacky, but adhesive should not transfer to the skin.
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 is immediately able to be trimmed or routed. Full bond strength is achieved after 24-48 hours depending on temperature and humidity.

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