

CASA ADHESIVE, INC.

CASA 1212B-PT Adhesive

Application Procedures

- ❑ Ambient conditions should be 60 degrees F or above for adhesive to perform per data sheet information.
- ❑ Materials to be bonded should be clean and dry.
- ❑ Adhesive spray pattern should be an even, small particle spattering using a **6501** tip. Too much glue slows drying time and does not improve the bond. Too little glue can lead to bond failure.
- ❑ Make sure the flow valve on the adhesive hose is in the off position. Attach hose and gun assembly to the adhesive canister making sure it is secured tight with a wrench. Slowly open the valve canister making sure there are no leaks. Open the flow valve on the adhesive hose. Spray a small test amount of adhesive into a box or garbage receptacle to make sure all PT Cleaner fluid is purged and that the gun is spraying adhesive normally.
- ❑ If one substrate is non-porous, spray it first because drying time takes longer on non-porous surfaces. The two surfaces should be bonded immediately when dry.
- ❑ CASA 1212B-PT is ready to bond when both surfaces are dry to the touch. Adhesive must dry long enough so that no adhesive transfers to your finger upon touching it. Adhesive will usually dry in 5 to 15 minutes. Cold wet conditions will slow drying times.
- ❑ Once the surfaces are laminated, the strength of the bond can be greatly enhanced by rolling the laminated surface with a 3" or 9" rubber roller. This should be done immediately.
- ❑ CASA 1212B-PT water-based adhesive provides bonds that are strong enough for finish work such as trimming and cutting to be done immediately. However, no test of peel strength should be made for at least 48 hours, the time required for the product to 80 % of total cure strength.
- ❑ New associates assigned to adhesive laminating positions should be trained in all required procedures. Work procedures should be staged to allow CASA 1212B-PT adhesive to totally dry prior to bonding the substrates.
- ❑ While not in use, the spray tip of the gun should be allowed to soak in soapy water, preferably a diluted solution of Casa's Quick Clean. The hose and gun assembly should be flushed and cleaned with Casa' PT Cleaner canister at the end of the workweek, or anytime the equipment will sit idle for more than 24 hours. To clean, close the valve on the canister. Pointing the gun into a box, relieve the pressure left in the hose and gun. Shutoff adhesive flow valve on the hose. Disconnect the hose with a wrench at the canister. Attach the hose to the Casa PT Cleaner canister. Open the canister valve, open the hose flow valve and pull the trigger while pointing the gun into a box or refuse container. After 30 to 40 seconds, the gun, and hose are clean. Re-attach the hose to the adhesive canister over the non-use period making sure the system is airtight. Make sure all Casa PT Cleaner fluid is purged from the hose prior to spraying more adhesive.
- ❑ Casa's 1212B-PT water-based, non-toxic adhesives eliminate associate health issues, flash fire issues and eliminate environmental VOC emissions.