

# CASA ADSEVIVE, INC

## CASA 309 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. Glue coating should look like a “not quite a good paint job” Too much glue will slow the drying time. Too little glue can lead to bond failure. Set glue pot pressure at 20 to 30 PSI., Set spray gun atomization pressure at 30 to 40 PSI.

Spray the high pressure laminate first because the time required to reach tack time takes longer on non-porous surfaces. Spray the wood substrate next. The wood substrate normally “tacks up” in ½ the time as the HPL.

CASA 309 is ready to bond when both surfaces are very tacky. Adhesive must dry long enough so that no wet adhesive transfers to your finger upon touching it, yet it is still very sticky. This normally provides for bonds to be made in 2 to 7 minute. Cold wet conditions will slow drying times. Do not allow adhesive to dry beyond 20 minutes. If left open longer than 20 minutes, reactivate with a thin coating of new adhesive. Cold wet conditions slow tack time and lengthen open time.

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 309 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 309 adhesive to become tacky prior to bonding the substrates.

Casa’s water-based adhesives must be used in conjunction with stainless steel or plastic parts where the adhesive comes in contact with hose fittings, spray guns, pumps or pressure pots.

Casa’s water-based, non-toxic adhesives eliminate associate health issues, flash fire issues and greatly reduce environmental VOC emissions.

**206 Nance Rd NE Calhoun GA 30701**  
**Phone: 888-685-0025 Fax: 888-781-5255**