

# **CASA ADHESIVE, INC.**

## **CASA 409 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. Too much glue slows drying time and does not improve the bond. Too little glue can lead to bond failure. Set glue at 20 to 30 psi., Set spray gun atomization pressure at 30 to 40 psi.

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 409 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 409 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 409 adhesive to totally dry 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, diaphragm pumps or pressure pots.

Casa's 409 water-based, non-toxic adhesives eliminate associate health issues, flash fire issues and eliminate environmental VOC emissions.

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