

CASA ADHESIVE, INC.

CASA 246-B 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 flow to the gun and atomization pressure accordingly.
- ✓ If one substrate is non-porous like fiberglass, HPL or foams, spray it first because tack time will take longer on this type surface. Porous substrates such as fabrics and carpets should be sprayed last and often are ready to bond in 2 minutes or less.
- ✓ CASA 246-B is ready to bond when both surfaces are very tacky. Adhesive must dry long enough so that no adhesive transfers to your finger upon touching it. Adhesive must not dry to long. This normally provides for bonds to be made in 2 to 7 minute. Cold wet conditions will slow drying times. Substrates should be mated within 20 minutes of becoming tacky. If left to dry too long, re-activate adhesive with a light re-coating.
- ✓ Once the surfaces are laminated, the strength of the bond can be greatly enhanced by rolling the laminated surface with a 3" rubber roller. This should be done right away. If a roller cannot be used, strong hand pressure will suffice.
- ✓ CASA 246-B water-based adhesive provides strong bonds with immediate high shear strength. These bonds are strong enough for finish work such as trimming, cutting or routing to be done immediately. No test of peel strength should be made for at least 48 hours, the time required for the product to reach 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 246-B adhesive to become tacky prior to bonding the substrates.
- ✓ Casa's water-based adhesives can only be exposed to stainless steel or plastic parts where the adhesive comes in contact with fittings, spray guns and pressure pots. Spray pot pressure should be set at 20 PSI or less. Spray atomization pressure should be at 30 PSI to control over-spray.
- ✓ Casa's water-based, non-toxic adhesives eliminate associate health issues, flash fire issues and greatly reduce environmental VOC emissions.

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