

CASA ADHESIVE, INC.

CASA 246 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, spray it first because tack time will take longer on this surface, generally 2 to 7 minutes. Porous surfaces such as fabrics and carpets will often tack up within 60 seconds, so spray your substrates accordingly.

CASA 246 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 and bonds can be made for up to 20 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" rubber roller. If surface can not be rolled, apply heavy hand pressure. This should be done immediately.

CASA 246 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 246 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 wet adhesive comes in contact with fittings, spray guns and pressure pots.

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

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