

ITW TACC – STA'-PUT SP80 LIQUID Guide Specification

SECTION 061123

CONTACT ADHESIVE

PART 1 - GENERAL

1.1 SUMMARY

- A. This Section includes contact adhesive.

1.2 SUBMITTALS

- A. Product Data: For each type of product indicated.
- B. Certificates:
 - 1. GREENGUARD Children & Schools.
 - 2. GREENGUARD Indoor Air Quality.

1.3 REGULARY REQUIREMENTS

- A. SCAQMD (South Coast Air Quality Management District), Rule 1168 – Adhesive and Sealant Applications.
- B. California Air District Regulations.
- C. Ozone Transport Commission (OTC) model Rule for Adhesives and Sealants.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Contact Adhesive:
 - 1. STA'-PUT SP80 Low VOC Contact Adhesive manufactured by ITW TACC (Basis of Design).
 - a. 56 Air Station Industrial Park, Rockland, MA 02370.
 - 2. Or equal.

2.2 CONTACT ADHESIVE

- A. Description:

1. High performance contact adhesive that can be used on a variety of substrates.
2. High-solids, and provides a high yield with a smooth spray pattern that reduces telegraphing on thin laminates.
3. Water-resistant, non-staining bond for common HPL applications.
4. Formulated for use in bonding a wide variety of materials, including, but not limited to: decorative laminates, metals (not copper), plywood, particleboard, polyurethane foam, and rigid plastics.

B. Advantages:

1. Quick dry time.
2. High strength bonds.
3. Aggressive grab tack.
4. Smooth, flat spray pattern.
5. High green strength.
6. Long open time.
7. Excellent adhesion to many substrates.
8. OTC states compliant.

C. Physical Properties:

1. Base: Synthetic Polymer.
2. Solids: 31.0 +/- 1.5%.
3. VOC Content: 2.30g/L (EPA Method 24).
4. Shelf Life: 12 months, unopened.
5. Open Time: 30 minutes.
6. Viscosity: 75-225 cps.
7. Flashpoint: 8.6°F (-13°C).
8. Dry Time: 2-5 minutes.
9. Colors: Clear /Red.
10. Coverage 445 ft²/gallon @2.5 dry grams/ft² (one side).
11. Formaldehyde: No urea formaldehyde added during adhesive manufacturing.

D. Certification:

1. GREENGUARD Children & Schools Certified.
2. GREENGUARD Indoor Air Quality Certified.

E. Contributes to LEED and other green building rating system credits:

1. LEED-NC and LEED-CI EQ Credits 4.1.
2. LEED for Schools EQ Credit 4.
3. LEED Core & Shell EQ Credit 4.
4. LEED-EB MR Credit 3.
5. CHPS® (Collaborative for High Performance Schools) EQ Credit 2.2.
6. Green Guide for Health Care EQ Credit 4.1.
7. NAHB Model Green Home Bldg Guidelines – Sect 7, Global Impact 7.1.3.

2.3 APPROVED SPRAY EQUIPMENT

A. Manual Spray:

1. Binks:
 - a. Spray Gun: 95, 2100.

- b. Fluid Tip: 63ASS.
- c. Fluid Needle: 663A, 563A.
- d. Air Cap: 66SD-3.
- 2. Devilbiss:
 - a. Spray Gun: JGA-510, MSA-510.
 - b. Fluid Tip: FX.
 - c. Fluid Needle: FX.
 - d. Air Cap: 24.
- B. Automatic Spray:
 - 1. Binks:
 - a. Spray Gun: 21, 95A.
 - b. Fluid Tip: 63ASS.
 - c. Fluid Needle: 263A, 763A.
 - d. Air Cap: 66SD-3.
 - 2. Devilbiss:
 - a. Spray Gun: AGX-550.
 - b. Fluid Tip: FX.
 - c. Fluid Needle: FX.
 - d. Air Cap: 24.
- C. Air Atomization Pressure: 80-100 psi.
- D. Fluid Pressure: 10-15 psi.
- E. Hot Spray Temperature: 120°F maximum.

PART 3 - EXECUTION

3.1 APPLICATION, GENERAL

- A. Comply with adhesive manufacturer's written instructions for installation.

3.2 ADHESIVE APPLICATION

- A. Use only after careful consideration of the warnings, directions, and first aid instructions given.
- B. Surfaces to be bonded should be clean, dry and free of any dust, loose paint, wax, moisture, dirt, grease, oil, rust, or other contaminants.
- C. Stir thoroughly before using. Adhesive should be at 60°F to 80°F. For best results, adhesive and materials to be bonded should be 60°F (15.6°C) to 80°F (26.7°C) during application. Allow substrates to acclimate to room temperature for 48 hours before bonding.

3.3 SPRAY APPLICATIONS

- A. Apply adhesive uniformly to both surfaces and cover each surface a minimum of 80%. Some porous surfaces may require two coats. 100% coverage is recommended for the edges.
- B. Use only approved equipment. For typical applications a coating weight of 2.5 - 3.5 dry grams per square foot is recommended. Both surfaces must be allowed to dry before bonding. This will usually take from 2 to 5 minutes at room temperature under normal conditions.
- C. Heat and humidity, or cold weather can effect drying times. Surfaces are dry if adhesive is tacky, but no adhesive transfers to the hand when touched.
- D. Complete the bond within 30 minutes (under normal conditions) after the adhesive is dry.

3.4 BRUSH APPLICATIONS

- A. Apply the adhesive with a brush or solvent-resistant medium nap roller. Apply adhesive uniformly to both surfaces and cover each surface 100%.
- B. Some porous surfaces may require two coats. Double coat all edges.
- C. For typical applications a coating weight of 3.0 dry grams per square foot is recommended. Both surfaces must be allowed to dry before bonding. This will usually take from 10 to 15 minutes at room temperature under normal conditions.
- D. Heat and humidity, or cold weather can effect drying times.
- E. Surfaces are dry if adhesive is tacky, but no adhesive transfers to the hand when touched.
- F. Complete the bond within 60 minutes (under normal conditions) after the adhesive is dry.

END OF SECTION 061123