

## C330

# Water Based Contact Adhesive

**C330** is a non-flammable neoprene based water-borne contact bond adhesive. **C330** has been formulated to retain the versatility and performance of traditional flammable and non-flammable solvent-based Neoprene contact adhesives yet allows the safety and non-toxicity of using a water-borne adhesive. It is suitable for use in bonding a wide variety of materials including, but not limited to, decorative laminated, particleboard, plywood, rigid plastics, leather, etc.

### FEATURES

- ◆ High Bond Strength
- ◆ High Heat Resistance
- ◆ High Yield
- ◆ Non-flammable
- ◆ Low VOC
- ◆ SCAQMD Compliant
- ◆ OTC Model Rule Compliant

### SUSTAINABILITY GUIDE

- Contributes to **LEED®** and other green building rating system credits:
  - *LEED-NC EQ Credit 4.1*
  - *LEED-CI EQ Credit 4.1*
  - *LEED Core & Shell EQ Credit 4.1*
  - *LEED-EB MR Credit 3*
  - *Green Guide for Health Care EQ Credit 4.1*



### REGULATORY COMPLIANCE

- SCAQMD (South Coast Air Quality Management District), Rule 1168
- California Air District Regulations
- Ozone Transport Commission (OTC) Rule for Adhesives and Sealants
- NAHB Model Green Home Building Guidelines Sect. 7, Global Impact 7.1.3

### DIRECTIONS FOR USE

Use only after careful consideration of the warnings, directions, and first aid instructions given. Do not thin. Surfaces to be bonded should be clean, dry and free of any dust, loose paint, wax, moisture, dirt, grease, oil, rust, or other contaminants. Non-porous surfaces should be thoroughly roughened by sanding and wiped free of dust. Stir thoroughly before using. Adhesive should be at 65°F or higher. For best results, adhesive and materials to be bonded should be 65°F or higher. Working at lower temperatures will slow the rate of drying and may also affect the final bond. Do not freeze. Apply a uniform coat of adhesive to both surfaces by using a brush, paint roller, or stainless steel spray equipment. Spray equipment must have stainless steel fittings, passages, fluid nozzles and needles. Hoses must be nylon lined or plastic. Apply 2.5 to 3.5 dry grams of adhesive per square foot on both surfaces to be bonded. Be sure to have complete coverage of the surfaces. If brush or paint roller applied, or substrates are porous, apply two coats of adhesive to avoid soak in. Allow the first coat of adhesive to dry completely before applying the second coat. Do not apply adhesive in the direct sunlight. Both surfaces must be allowed to dry before bonding. This will usually take from 5 to 30 minutes at room temperature under normal conditions. Heat and humidity, or cold weather can cause longer drying times. Preheating substrates and the use of ovens, fans, or lamps will result in shorter drying times. Daily pretesting is recommended prior to use. The adhesive is dry when a translucent, glossy coat is obtained. Cloudy or opaque areas indicate incomplete drying. Dull areas indicate insufficient adhesive. Complete the bond within 1 hour (under normal conditions) after the adhesive is dry. If the two surfaces don't grab immediately when brought into contact, they have dried too long. Position coated surfaces carefully before putting them together since no shifting is possible once contact is made. Bring surfaces together and immediately apply firm pressure over entire surface working from the center to the edges. Apply uniform pressure over 100% of the area to be bonded. A pinch roller or rotary press is ideal, using as much pressure as possible

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without crushing the substrates. The minimum recommended pressure would be a 3-inch rubber "J" roller used attentively (30 – 40 psi). Replace lid after each use and secure tightly for storage. For best results store between 60°F and 95°F. Store out of direct sunlight in a cool, well-ventilated area. Avoid storing container directly on the floor or against an outside wall. Do not freeze. Do not expose bonded parts to direct sunlight or excessive heat for at least 72 hours. Do not use on some vinyls or polystyrene foam. Some vinyls contain plasticizers, which can, over time, soften and dissolve the bond. When in doubt, or if product is to be used on light colored vinyls, or other light colored materials, conduct test on the product to be bonded before use. Copper or its alloys should not be used to transfer or contain this adhesive. Do not laminate copper or its alloys with this adhesive.

**CLEAN-UP:** Use warm, soapy water to clean wet adhesive from spray equipment, brushes or rollers. Use an ITW TACC brand biodegradable citrus solvent to remove dried adhesive.

### PHYSICAL PROPERTIES

BASE:	Compounded Polychloroprene	WEIGHT/GALLON:	9.05 lbs/gallon
SOLVENT:	Water	VOC CONTENT:	43.1 g/L (EPA Method 24)
SHELF LIFE:	1 year from date of manufacture	VISCOSITY:	400-600 cps
SOLIDS:	49.0 +/- 2.0%	OPEN TIME:	60 minutes
FLASHPOINT:	N/A	DRY TIME:	20-30 minutes
COLORS:	Clear / Green	COVERAGE	675ft <sup>2</sup> /gallon @3.0 dry grams/ft <sup>2</sup>
FORMALDEHYDE:	No urea formaldehyde added during adhesive manufacturing		

### APPROVED EQUIPMENT

#### MANUAL

US Legends

95 Tornado Gun

System 500 – 5 gallon pressure pot

Fluid Pressure: 5-15 psi

Atomization Pressure: 20-40 psi

System 5000 – 55 gallon drum pressure system

Fluid Pressure: 2-8 psi

Atomization Pressure: 20-40 psi

#### AUTOMATIC

Binks

Mach 1A HVLP spray gun

94 fluid tip, 47 – 478 needle

94P air cap

#### MANUAL

C.A. Technologies

Panther P100G 1.8 X 1590 spray gun.

Pressure pot and hoses with non-corrosive fluid paths.

Fluid Pressure: 5-15 psi

Atomization Pressure: 20-40 psi

#### MANUAL

Binks

Mach 1 HVLP spray gun

94 fluid tip, 54 – 3941 needle

94P air cap

Fluid Pressure: 10-30 psi Atomization Pressure: 10-30 psi

Spray Equipment must have stainless steel fittings, passages, fluid nozzles and needles. Hoses must be nylon lined or plastic. An in-line filter between the pump and spray gun is required. Apply a uniform, finely atomized, spray coating covering 100% of the surface.

**KEEP OUT OF REACH OF CHILDREN  
FOR PROFESSIONAL OR INDUSTRIAL USE ONLY  
USE ONLY WITH APPROVED EQUIPMENT**

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