

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION:

ITW STA'-PUT® SP80 is a high performance contact adhesive that can be used on a variety of substrates. SP80 is high solids and provides a high yield with a smooth spray pattern that reduces telegraphing on thin laminates. It gives a water-resistant, non-staining bond for common HPL applications. Formulated for use in bonding a wide variety of materials, including, but not limited to: decorative laminates, metals (not copper or its alloys), plywood, particle board, polyurethane foam, and rigid plastics.

ADVANTAGE:

- Quick Grab Tack
- High Strength bonds
- Smooth, flat spray pattern
- High Green Strength
- Excellent adhesion to many substrates
- OTC States Compliant

REGULATORY COMPLIANCE:

- SCAQMD (South Coast Air Quality Management District), Rule 1168
- California Air District Regulations
- Ozone Transport Commission (OTC) Rule for Adhesives and Sealants

SUSTAINABLE GUIDE:

- GREENGUARD® Children & Schools Certified
- GREENGUARD® Indoor Air Quality Certified
- Contributes to LEED® and other green building rating system credits:
 - LEED-NC and LEED-CI EQ Credits 4.1
 - LEED-EB MR Credit 3
 - LEED for Schools EQ Credit 4
 - LEED Core & Shell EQ Credit 4
 - Green Guide for Health Care EQ Credit 4.1
 - NAHB Model Green Home Bldg Guidelines – Sect 7, Global Impact 7.1.3

APPROVED EQUIPMENT:

Automatic		
	BINKS	DEVILBISS
Spray gun	21,95A	AGX-550
Fluid Tip	63ASS	FX
Fluid Needle	263A, 763A	FX
Air Cap	66SD-3	24
Manual		
	BINKS	DEVILBISS
Spray gun	95, 2100	JGA-510, MSA-510
Fluid Tip	63ASS	FX
Fluid Needle	663A, 563A	FX
Air Cap	66SD-3	24

Air Atomization Pressure: 40 – 60 psi, Fluid Pressure: 6 – 10 psi
Hot spray Temperature: 120°F (93.3°C) maximum

TYPICAL PROPERTIES:

Property	Typical Value
Base:	Synthetic Polymer
Shelf Life:	1 year from Date of Manufacture*
Colors:	Clear/ Red
Flash Point:	8.6°F (-13°C)
Solids	32.0% ± 2.0%
Weight / Gallon	7.90 lbs/ gallon
VOC Content	2.30 g/L (EPA Method 24)
Viscosity	50 - 300cps
Open Time	20 - 30 minutes
Dry Time	2 - 5 minutes
Coverage	460 ft ² / gallon @ 2.5 dry grams/ ft ²
Formaldehyde	No urea formaldehyde added during adhesive manufacturing
* The shelf life for an unopened container of this adhesive stored at temperatures between 60°F (15.6°C) and 95°F (35°C) is 1 year from date of manufacture. Store out of direct sunlight in a cool, well-ventilated area. Avoid storing container directly on the floor or against an outside wall	

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.
- Stir thoroughly before using.
- For best results, adhesive and materials to be bonded should be 60°F (15.6°C) to 95°F (35°C) during application.
- Allow substrates to acclimate to room temperature for 48 hours before bonding.

SPRAY APPLICATIONS

- 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. Use only approved equipment.
- Use only approved equipment. Using lower atomization air will increase open time.
- Adhesive should be wet when applied and not immediately dry to the touch.
- 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. 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.
- Complete the bond within 30 minutes (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.

BRUSH APPLICATIONS

- Apply the adhesive with a brush or solvent-resistant medium nap roller.
- Apply adhesive uniformly to both surfaces and cover each surface 100%. Some porous surface may require two coats. Double coat all edges.
- 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 - 15 minutes at room temperature under normal conditions. 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.
- Complete the bond within 30 minutes (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 a minimum of 30 psi uniform pressure over 100% of the area being bonded.
- Let bonded parts cure for at least 72 hours before exposing to direct sunlight of temperatures over 150° F (65.6°C).
- Replace the lid after each use and secure tightly for storage.
- Do not use on some vinyls or polystyrene foam. Some vinyls contain plasticizers, which can, over time, soften and dissolve the bond, or bleed through/dicolor.

When in doubt, or if product is to be used on vinyls, or other light colored materials, conduct compatibility testing on the product to be bonded before use.

ATTENTION:

- Empty container remains hazardous until all flammable vapors, which may explode upon ignition, are gone from residue and container. Observe all labeled hazard precautions. Do not cut, puncture, or weld while hazard exists.
- Do not reuse empty container. Recycle, or dispose of, according to all federal, state, and local regulations. Follow solvent manufacture's recommendations and instructions for safe handling.

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

NOTICE TO PURCHASER:

NO WARRANTIES, EXPRESS OR IMPLIED, ARE MADE INCLUDING MERCHANTABILITY AND/OR FITNESS FOR A PARTICULAR PURPOSE. EXCEPT FOR PERSONAL INJURY RESULTING FROM USE OF THE PRODUCT AS DIRECTED, ITW POLYMERS SEALANTS NORTH AMERICA, INC. SHALL NOT BE LIABLE IN TORT OR CONTRACT FOR ANY LOSS OR DAMAGE. UNDER NO CIRCUMSTANCES SHALL ITW POLYMERS SEALANTS NORTH AMERICA, INC., A DIVISION OF ILLINOIS TOOL WORKS INC., OR ITS AFFILIATES ("ITW POLYMERS SEALANTS NORTH AMERICA, INC.") BE LIABLE FOR ANY LOSS OR DAMAGE ARISING FROM THE PURCHASE, USE, OR INABILITY TO USE THIS PRODUCT, OR FOR ANY SPECIAL, INDIRECT, INCIDENTAL, OR CONSEQUENTIAL DAMAGES. THE USER MAY SEND A SAMPLE OF PRODUCT TO ITW POLYMERS SEALANTS NORTH AMERICA, INC. FOR TESTING. IF SUCH TESTING PROVES A PRODUCT DEFECTIVE, THE USER'S SOLE AND EXCLUSIVE REMEDY IS EITHER REIMBURSEMENT OF THE PURCHASE PRICE OF THE PRODUCT OR REPLACEMENT OF THE CONTAINER OF PRODUCT. NO FABRICATOR, INSTALLER, DEALER, AGENT OR EMPLOYEE OF ITW POLYMERS SEALANTS NORTH AMERICA, INC. HAS THE AUTHORITY TO MODIFY THE OBLIGATIONS OR LIMITATIONS OF THIS.

WARRANTY:

THIS WARRANTY GIVES YOU SPECIFIC LEGAL RIGHTS, AND YOU MAY ALSO HAVE OTHER RIGHTS, WHICH VARY FROM STATE TO STATE; THEREFORE, SOME OF THE LIMITATIONS STATED ABOVE MAY NOT APPLY TO YOU. IT IS TO YOUR BENEFIT TO SAVE YOUR DOCUMENTATION UPON PURCHASE OF A PRODUCT. THE INFORMATION AND SUGGESTIONS FOR USE CONTAINED HEREIN ARE BELIEVED TO BE ACCURATE, BUT ARE NOT TO BE CONSTRUED AS WARRANTIES. USER SHALL DETERMINE THE SUITABILITY OF THE PRODUCT FOR HIS OR HER INTENDED USE AND SHALL ASSUME ALL RISK ASSOCIATED THEREWITH.

Complete technical information is available from
ITW Polymers Sealants North America, Inc.