

## TECHNICAL DATA SHEET

### PRODUCT DESCRIPTION:

ITW STA'-PUT® 1535 is a non-flammable solvent-based adhesive developed to bond various types of foam to wood, fiberfill, or to itself. The adhesive is for use in the upholstery furniture industry.

### ADVANTAGE:

- High Green Strength
- Aggressive Grab Tack
- High Strength Bonds
- Quick Dry Time
- Good Spray Pattern
- Long Open Time
- Excellent Adhesion to many Substrates
- Excellent for Foam Bonding Applications

### TYPICAL PROPERTIES:

Property	Typical Value
Base:	Synthetic Polymer
Solvent:	Methylene Chloride*
Shelf Life:	9 months from Date of Manufacture**
Color:	Clear/ Red
Flash Point:	N/A
Weight / Gallon	9.57 lbs./ gallon
VOC Content	110.4 g/L (EPA Method 24)
Open Time	6 - 8 minutes
Dry Time	N/A
Solids	33.4 ± 2.5%
Viscosity	225 - 275 cps
Coverage	575 ft <sup>2</sup> /gallon @ 2.5 dry grams/ ft <sup>2</sup>
Formaldehyde	No urea formaldehyde added during adhesive manufacturing

\* Reports have associated repeated and prolonged occupational exposure to solvents with permanent brain and nervous system damage

\*\* 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 9 months 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

### 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: 80 – 100 psi

Fluid Pressure: 10 – 15 psi

Hot spray Temperature: 120°F (93.3°C) maximum

### 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. Do not thin.
- Adhesive should be at 60°F (15.6°C) to 95°F (35°C). 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.
- 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. For typical applications a coat weight of 2.5 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 cause longer drying times. Surfaces are dry if adhesive is tacky, but no adhesive transfers to the hand when touched.
- Complete the bond within 60 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 (30 psi) over entire surface working from the center to the edges.
- Let bonded parts cure for at least 72 hours before exposing to direct sunlight of temperatures over 150°F (65.6°C).
- Replace lid after each use and secure tightly for storage.
- Do not use on vinyls or polystyrene foam. Some vinyls contain plasticizers, which can, over time, soften and dissolve the bond, or bleed through/ discolor. 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.
- DO NOT use on copper substrates or its alloys. DO NOT use copper spray systems or fluid components.

**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:**

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