

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION:

ITW STA'-PUT® S155/ S156 is a high performance, high solids, fast drying contact bond adhesive designed for versatility. **S155/ S156** bonds a wide variety of materials, including, but not limited to, decorative laminates, metals (not copper), plywood, particleboard, foamed polystyrene (using dry spray technique), polyurethane foam and rigid plastics. **S155/ S156** meets the need for a spray contact bond adhesive that provides extremely easy and uniform coverage in all types and sizes of spray operations.

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 Heat Resistance

TYPICAL PROPERTIES:

| Property | Typical Value |
|--|--|
| Base: | Compounded Polychloroprene |
| Solvent: | Organic Solvent* |
| Shelf Life: | 1 year from Date of Manufacture** |
| Color: | Clear/ Red |
| Flash Point: | -34.6°F (-37.0°C) |
| Weight / Gallon | 6.63 lbs./ gallon |
| VOC Content | 585.0 g/L (EPA Method 24) |
| Open Time | 60 minutes |
| Dry Time | 2 – 5 minutes |
| Solids | 17.3 ± 3.0% |
| Viscosity | 200 – 300 cps |
| Coverage | 250 ft ² /gallon @ 2.0 dry grams/ ft ² |
| Formaldehyde | No urea formaldehyde added during adhesive manufacturing |
| <p>* 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 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</p> | |

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 2.0 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:

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.

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