



## Product Data Sheet

FORMICA is a registered trademark of the Formica Corporation  
Manufactured by: Choice Brands Adhesives

666 Redna Terrace, Suite 500  
Cincinnati, OH 45215  
Customer Service: (800) 330-5566

**Product Number:** F-180

**Description:** Neoprene Water Base Contact Adhesive

### Typical Physical Properties:

<b>Solids:</b>	50.0% +/- 1%	<b>Shelf Life:</b>	12 months in unopened container
<b>Viscosity:</b>	600 cps	<b>Color:</b>	Natural/Clear(when dry)
<b>Density:</b>	9.1 lbs./gal	<b>Packaging:</b>	Drums, pails, gallons
<b>Coverage:</b>	375 bonded ft <sup>2</sup> @ 3.0 dry grams	<b>VOC:</b>	53 g/l (EPA Method 24)
<b>Open Time:</b>	60 minutes	<b>Clean Up:</b>	Warm, soapy water
<b>Shipping:</b>	Adhesives, Not Regulated	<b>Flash Point:</b>	N/A

Qualifies for LEED®-NC & CI EQ Credit 4.4: *laminating adhesives shall contain no urea formaldehyde resins*

### Properties:

- Excellent room temperature contactability
- Excellent mileage,
- Excellent bond adhesion to a variety of substrates including decorative, laminates, particleboard, plywood, metal, honeycomb and leather.
- Provides good uniform coverage in hand and automatic spray applications.
- Excellent green strength and high heat resistance for high speed postforming applications.
- Extremely low VOC content
- OTC and SCAQMD compliant

### Application:

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Temperature of adhesive and substrates during fabrication should be at least 65°F (18°C) for best results.
3. F-180 can be brushed, rolled and sprayed. If brushing and rolling, apply 100% coverage (3.0 dry grams/sq. ft. or higher). If spraying, coating weight of 2.5 to 3.5 dry grams should be applied. The atomization pressure at the gun should be 5 to 20 psi and the fluid pressure should be 10 to 15 psi.
4. When applying contact adhesives to porous materials such as plywood and edges, it is advisable to apply two coats. Apply the first coat and allow to dry. This will act as a sealer. When dry, apply the second coat

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and allow to dry properly before bonding. This helps to insure that the adhesive does not soak-in below board fiber and that you have the proper amount on the surface to achieve a strong, permanent bond.

5. Allow the adhesive to dry properly before bonding. Water borne contact adhesives will change color when dry. However, to check for dryness, use the back of your fingers and press into the adhesive and lift up. Any adhesive transfer indicates that the adhesive requires more time to dry. If the adhesive feels tacky, but there is no transfer to the fingers or opaque areas in the adhesive, the adhesive is ready for bonding. humidity and coating weight. Drying time can be reduced using air movement, drying ovens, lamps, etc.
6. Typical drying will occur in 30 minutes, however, dry time can vary depending on temperature. Bonds can be made as soon as the adhesive is dry. However, bonds made any time in the one hour open time will be as strong as those made immediately after dry.
7. Position the pieces carefully, since a strong bond is made instantly upon contact. Spacers such as dowels or strips of laminate should be used to prevent contact prior to proper positioning.
8. Use good uniform pressure. Use the maximum possible pressure without damaging the substrates. Minimum recommended pressure is applied with a J-roller.
9. The completed panel can be routed or trimmed, cut, filed and machined immediately.

### Recommended Equipment:

Automatic Manual, Binks DeVilbiss Binks DeVilbiss, Spray gun Mach 1A Spirit H2000 Mach 1 V3, Fluid tip 94 FF 94 FF, Fluid needle 47-478 FF 54-3941 FF, Air cap 94P 28, 33 94P 28, 33A, Spray equipment must have stainless steel fittings, passages, fluid tips and needles. Fluid lines can be nylon lined or PVC. This material should be pumped.

### Application Precautions:

- DO NOT use copper and its alloys to transfer or contain any contact adhesive.
- DO NOT laminate copper with this adhesive.
- DO NOT exceed the recommended "open time."
- Thinning the adhesive is not recommended. .
- DO NOT use on plasticized vinyls.

### Storage Conditions:

- Keep adhesive container closed tightly when not in use.
- Store closed, lined containers where temperature will be between 50°F and 80°F
- Product should not be stored in direct sunlight.

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- Product is not freeze/thaw stable. Protect from freezing.
- Product should not be used after being frozen.

**REFER TO THE MATERIAL SAFETY DATA SHEET PRIOR TO USE.**

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