



BSA-352 Flammable Adhesive, Nitrile Contact

Directions for Use:

- Prior to use, read the SDS for health and safety details.
- Surfaces being bonded are to be clean and dry, void of any dust, dirt, oil, rust, wax, loose paint or other contaminants.
- Ambient temperature, where adhesive is being used, should be between 60° F and 95° F. Adhesive and substrates being bonded should be the same. If not, allow them to condition to this environment prior to bonding.
- Thoroughly stir the adhesive prior to using. Do not thin the adhesive.
- If brush or roller application is used, use a brush or medium nap roller that is solvent resistant.
- Uniformly apply the adhesive to both surfaces being bonded. A minimum of 80% coverage is needed, and 100% coverage is recommended along the edges of the bond area. Two coats may be needed on porous materials. For recommended spray equipment, see refer to the list provided.
- The applied adhesive must be allowed to dry to the touch (tacky), prior to making the bond. This time will vary depending on the substrate condition, amount of adhesive applied and room temperature, humidity and air movement.
- Bonds should be made immediately after the adhesive has dried to the touch. If the surfaces don't adequately bond, the adhesive may have dried too long.
- The bond created will make it difficult to reposition the substrates. Take precaution in properly positioning the substrates prior to mating them together. When this is done, working from the center to the edges, immediately apply adequate pressure over the entire bonded surface.
- Allow the bonds to cure for 72 hours prior to exposing them to outdoor elements. Prior to this, intense sunlight or exposure to over 150° F can be a detriment to the bonds created.
- Keep the lid on the container tightly closed when not extracting adhesive. The loss of solvent will cause the adhesive to thicken and become unusable.

Equipment Recommendations:

- Manual Spray Gun: Binks 95 or 2100 or Devilbiss JGA-510
- Fluid Tip: Binks 63ASS or Devilbiss FX
- Fluid Needle: Binks 663A or 563A or Devilbiss FX
- Air Cap: Binks 66SD-3 or Devilbiss 24
- Recommended Fluid Pressure: 25 to 40 psi
- Recommended Air Atomization Pressure: 30 to 50 psi