



CHOICE BRANDS
A D H E S I V E S
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PRODUCT DATA SHEET

CHOICE BRANDS ADHESIVES, 666 REDNA TERRACE #500, CINCINNATI, OH 45215 513-772-1234

PRODUCT: CBA-1093 SPRAY FOAM ADHESIVE

BENEFITS:

Excellent Bond Adhesion
Non-Ozone Depleting
Fast Drying
Good Open Tim (2 to 4 minutes)
High Solids Content
Good Heat Resistance

TYPICAL PHYSICAL PROPERTIES:

Base: Synthetic Rubber
Flammability: Non-Flammable
Solids: 27%
Viscosity: 275 cps
Packaging: 5 and 54 gl container
VOC's: 0 gms/ liter (EPA Method 24)
VHAPS: 0
Color: Clear Amber
Shelf Life: 1 year in an unopened container
Clean up: 1000

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

SUGGESTED USE:

A non-flammable based synthetic rubber adhesive formulated for bonding a variety of porous and non-porous substrates.
Foam to foam and fabrics; Fabric to wood, metal and plastics; Foam to wood, metal and plastics; Bonds a variety of other surfaces.
Intended for use in the manufacture of foam fabrication, bedding and mattress, insulation, decorative panels, carpeting underlayments marine and automotive applications for carpeting and headliner applications.

APPLICATION: Spray or Brush Apply

1. Agitate adhesive before use.
2. Substrates should be clean and free of moisture, dirt, oil, and other contaminants.
3. For best results, adhesive and substrates should be allowed to acclimate temperature (approximately 60°F or above) before application of adhesive.
4. Apply a minimum of 3.0 dry grams/sq. ft. For best results, apply two coats of adhesive to any porous surface; one base coat and a secondary top coat. This ensures adequate layup particularly on CARB 2 PARTICLEBOARD and other similar surfaces. Allow the second coat to completely dry before assembly. The adhesive should cover 80% of the surface of the substrate. The coated substrate surface should exhibit a uniform glossy sheen when the adhesive is completely dry. Dull areas indicate insufficient coverage. Adhesive should be re-applied to these areas.
5. Make sure to coat all exposed edges and corners with two coats of adhesives.
6. Allowing contact adhesive to dry completely before assembly is essential to obtaining a secure, permanent bond. To check for adhesive dryness, press a piece of Kraft paper onto the adhesive surface. If there is

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transfer of adhesive to the paper, more time is required to let the adhesive dry. If there is no transfer, substrates are ready for bonding.

7. If areas exist with excessive adhesive deposition, twist the (gloved) fingers while pressing them onto the adhesive layer. This will break any film that has formed as the adhesive dries from the top surface down. If a skin has been formed, allow more time for evaporation to ensure complete removal of solvent before bonding.
8. Dry times can be improved through the use of air movement, drying ovens, lamps, etc.
9. Substrates may be indexed together and bonded once the adhesive is dry. Bonds must be made within the open time of the adhesive.
10. Uniform pressure on the bonded laminates is necessary to create strong, lasting bonds. 40 pounds per linear inch is recommended to insure complete fusion between the two layers of adhesive to be bonded. A pinch roller is ideal for applying uniform pressure. When used properly, a J-roller can also provide adequate pressure for bonding.
11. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed, and machined.

SUGGESTED EQUIPMENT:

	Manual	Systems	Automatic	Systems
	Binks	DeVilbiss	Binks	DeVilbiss
Spray Gun	95, 2001, 2100	JGA510, MSA510	21,95A	AGX550
Fluid Tip	63B-SS	FX	63C-SS	FX
Fluid Needle	663A, 563A	FX	263A, 663A	FX
Air Cap	66SD-3	24	66SD-3	24

PRECAUTIONS:

Please refer to the Material Safety Data Sheet for further safety information.

This product is not to be sold or distributed in the state of California which has banned the use of Methylene Chloride.

STORAGE CONDITIONS:

Keep container closed when not in use. Caution: Store away from direct sunlight. Maintain temperature below 90°F.

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