



## 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: F170**

**TYPE OF ADHESIVE: Contact Adhesive, High Solids, OTC Compliant**

### TYPICAL TECHNICAL DATA:

Viscosity:	350 cps	Dry Time:	2 – 5 Minutes
Solids:	25.5% Minimum	Open Time:	30 minutes
Color:	Green	Solvents:	Organic solvents
Density:	10.1 lbs/gallon	Flash Point:	deg F
Coverage:	225 sq ft/gallon bonded surfaces	VOC:	0 grams/liter (EPA Method 24)
Coverage Rate:	2.5 dry grams/sq ft minimum	Clean Up:	Choice Brads 1000
Shelf Life:	1 Year in unopened container	Class:	NON- FLAMMABLE
Availability:	Pails, drums and 300 gallon totes		

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

### PROPERTIES:

- High solids, non-flammable spray grade contact cement
- Excellent adhesion to a variety of substrates including, but not limited to laminates, particle board, plywood, hardwood, leather, rubber and metal
- Excellent room temperature contactability
- Non ozone depleting
- Excellent green strength and high heat resistance
- Excellent sprayability

### APPLICATION:

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 to room temperature (approximately 60° F or above) before adhesive application.
4. The adhesive should be applied at approximately 3.0 grams/square foot. The adhesive should cover 80% of the substrate surface. The substrate surface should exhibit a uniform glossy sheen when the adhesive is completely dry. Dull areas indicate insufficient coverage. Adhesive should be reapplied to these areas.
5. When bonding porous substrates, it is advisable to apply two coats of adhesive. The first coat will act as a sealer and prevent excessive absorption of adhesive into the substrate. After the first coat has dried, apply a second coat. Allow the second adhesive coating to dry completely before assembly.
6. Allowing the contact adhesive to dry completely before assembly is essential to obtaining a secure, permanent bond. To check for adhesive dryness, press the back of your fingers onto the adhesive surface. If adhesive transfers to fingers, additional dry time is necessary. If there is no adhesive transfer, the substrates are ready for bonding.

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7. If areas exist with excessive adhesive deposition, twist the fingers while pressing them onto the adhesive layer. This will break any skin that may have formed as the adhesive dries from the top surface down. If a skin has formed, allow additional dry time to ensure complete evaporation of the 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. (Open times vary by adhesive. See specification on Page 1.)
10. Uniform pressure on the bonded laminates is necessary to create strong, lasting bonds. 40 pounds per linear inch is recommended to ensure complete fusion between the two layers of adhesive. A pinch roller is the ideal method for applying uniform pressure. When used properly, a J-roller can also provide sufficient pressure for bonding.
11. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed and machined.

### SUGGESTED EQUIPMENT:

	Automatic Systems		Manual Systems	
	Binks	DeVilbiss	Binks	DeVilbiss
Spray Gun	21,61,610,95A	AGX	18, 62, 2001, 95	JGA510,MBC510
Fluid Tip	63C, 66	E,FF	63C, 66	E,FF
Fluid Needle	63A, 66	E,FF	63C	E,FF
Air Cap	66SD-3	24,765	66SD-3	24,765

### APPLICATION PRECAUTIONS:

- Do not use in applications with copper or aluminum components.
- Do not use on polystyrene foams or plasticized vinyls
- Do not mix with other adhesives. Thinning the adhesive is not recommended.

### STORAGE CONDITIONS:

- Rotate stock, use oldest first.
- 1 year shelf life if container is unopened
- Keep covered to prevent solvent loss and contamination.
- Do not freeze. Store product between 60 – 80 degrees.

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

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