



Chemical Concepts

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410 Pike Road • Huntingdon Valley, PA 19006

Toll Free: 800 220 1966

Phone: 267 684 1038 • Fax: 215 357 2754

e-mail: sales@chemical-concepts.com • www.chemical-concepts.com

Chem-set™ AW 205 M — Technical Data Sheet

High Performance Contact Adhesive

Chem-set™ AW 205 is a high performance contact bond adhesive in a non-flammable solvent. *Chem-set™ AW 205* is suitable for bonding decorative laminate, wood, particleboard, metal, rubber, hardboard, plywood, leather, canvas and many other materials. It is fast drying, oil and waterproof and requires no clamping. Its high tack plus excellent combinability and green strength provides uniform high strength bonds under a wide variety of laminating condition.

FEATURES

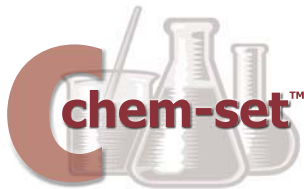
- ◆ Quick Dry Time
- ◆ Aggressive Grab Tack
- ◆ High Green Strength
- ◆ Excellent adhesion to many substrates
- ◆ High Strength Bonds
- ◆ Good Spray Pattern
- ◆ Postformable
- ◆ Long Open Time

DIRECTIONS FOR USE

Use only after careful consideration of the warnings, directions, and first aid instructions given. 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. Adhesive should be at 60°F to 80°F. For best results, adhesive and materials to be bonded should be 60°F (15.6°C) to 80°F (26.7°C) during application. Allow substrates to acclimate to room temperature for 48 hours before bonding. **SPRAY APPLICATIONS:** 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 coating weight of 2.5 - 3.5 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 effect drying times. Surfaces are dry if adhesive is tacky, but no adhesive transfers to the hand when touched. Complete the bond within 30 minutes (under normal conditions) after the adhesive is dry. **BRUSH APPLICATIONS:** Apply the adhesive with a brush or solvent-resistant medium nap roller. Apply adhesive uniformly to both surfaces and cover each surface 100%. Some porous surfaces may require two coats. Double coat all edges. For typical applications a coating weight of 3.0 dry grams per square foot is recommended. Both surfaces must be allowed to dry before bonding. This will usually take from 10 to 15 minutes at room temperature under normal conditions. Heat and humidity, or cold weather can effect 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 over entire surface working from the center to the edges. Apply a minimum of 30 psi uniform pressure over 100% of the area being bonded. 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 some vinyls or polystyrene foam. Some vinyls contain plasticizers, which can, over time, soften and dissolve the bond, or bleed through/dicolor. 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.

NOTE: The shelf life for an unopened container of this adhesive stored at temperatures between 60°F (15.6°C) and 80°F (26.7°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.



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ATTENTION: Empty container remains hazardous until all vapors 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. Dispose of according to all federal, state, and local regulations. Do NOT use on copper substrates or its alloys. Do NOT use copper spray systems or fluid components.

NOTICE: Reports have associated repeated and prolonged occupational exposure to solvents with permanent brain and nervous system damage.

WARNING: This product contains methylene chloride, a chemical known to the state of California to cause cancer

PHYSICAL PROPERTIES

BASE:	Compound Neoprene	WEIGHT/GALLON:	10.74 lbs/gallon
SOLVENT:	Methylene Chloride	VOC CONTENT:	71.4 g/l (EPA Method 24)
SHELF LIFE:	9 months, unopened	VISCOSITY:	325-425 cps
SOLIDS:	15.0 +/- 1.5%	OPEN TIME:	60 minutes
FLASHPOINT:	N/A	DRY TIME:	2-5 minutes
COLORS:	Clear/ Green	COVERAGE	365 ft ² /gallon @2.0 dry grams/ft
FORMALDEHYDE:	No urea formaldehyde added during adhesive manufacturing		

APPROVED SPRAY EQUIPMENT:

	AUTOMATIC		MANUAL	
	BINKS	DEVILBISS	BINKS	DEVILBISS
Spray Gun:	21,95A	AGX-550	95, 2100	JGA-510, MSA-510
Fluid Tip:	63ASS	FX	63ASS	FX
Fluid Needle:	263A, 763A	FX	663A, 563A	FX
Air Cap:	66SD-3	24	66SD-3	24
Air Atomization Pressure:	80-100 psi, Fluid Pressure: 10-15 psi			
Hot spray temperature:	100°F maximum			

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NOTICE TO PURCHASER: All statements, technical information, and recommendations set forth herein are based on tests which Chemical Concepts believes to be reliable. However Chemical Concepts does not guarantee their accuracy or completeness. The buyer should conduct its own tests of this product before use to determine proper preparation technique and suitability for purposed application.

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**KEEP OUT OF
REACH OF
CHILDREN.
IF SPRAYING,
USE ONLY
WITH
APPROVED
EQUIPMENT**

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