

### TECHNICAL DATA SHEET

#### PRODUCT DESCRIPTION:

ITW STA'-PUT® S140 is a high-solids, brush grade contact bond adhesive designed for industrial applications. S140 is used to bond a wide variety of materials, including, but not limited to, decorative laminates, metals (not copper), plywood, particleboard, polyurethane foam and rigid plastics. S140 provides easy and uniform coverage in all types and sizes of industrial operations.

#### ADVANTAGE:

- High Green Strength
- Aggressive Grab Tack
- High Strength Bonds
- Quick Dry Time
- Brush or Roller Applied
- Long Open Time
- Excellent Adhesion to many Substrates
- Excellent Heat Resistance

#### TYPICAL PROPERTIES:

Property	Typical Value
Base:	Compounded Polychloroprene
Solvent:	Organic Solvent*
Shelf Life:	1 year from Date of Manufacture**
Color:	Clear
Flash Point:	-34.6°F (-37.0°C)
Weight / Gallon	6.77 lbs./ gallon
VOC Content	606.9 g/L (EPA Method 24)
Open Time	60 minutes
Dry Time	2 – 5 minutes
Solids	21.0 ± 2.0%
Viscosity	700 - 900 cps
Coverage	250 ft <sup>2</sup> /gallon @ 2.5 dry grams/ ft <sup>2</sup>
Formaldehyde	No urea formaldehyde added during adhesive manufacturing

\* Reports have associated repeated and prolonged occupational exposure to solvents with permanent brain and nervous system damage

\*\* The shelf life for an unopened container of this adhesive stored at temperatures between 60°F (15.6°C) and 95°F (35°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

#### DIRECTIONS FOR USE:

- Use only after careful consideration of the warnings, directions, and first aid instructions given.
- Stir thoroughly before using. Do not thin.
- Surfaces to be bonded should be clean, dry and free of any dust, loose paint, wax, moisture, dirt, grease, oil, rust, or other contaminants.
- Adhesive should be at 60°F (15.6°C) to 95°F (35°C). For best results, adhesive and materials to be bonded should be 60°F (15.6°C) to 95°F (35°C) during application. Allow substrates to acclimate to room temperature for 48 hours before bonding.
- 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 coat 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 cause longer 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 (30 psi) over entire surface working from the center to the edges.
- 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 vinyls or polystyrene foam. Some vinyls contain plasticizers, which can, over time, soften and dissolve the bond, or bleed through/ discolor. 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.

**ATTENTION:**

- Empty container remains hazardous until all flammable vapors, which may explode upon ignition, 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. Recycle, or dispose of, according to all federal, state, and local regulations. Follow solvent manufacture's recommendations and instructions for safe handling.

**KEEP OUT OF REACH OF CHILDREN  
FOR PROFESSIONAL OR INDUSTRIAL USE ONLY  
USE ONLY WITH APPROVED EQUIPMENT**

**NOTICE TO PURCHASER:**

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**WARRANTY:**

THIS WARRANTY GIVES YOU SPECIFIC LEGAL RIGHTS, AND YOU MAY ALSO HAVE OTHER RIGHTS, WHICH VARY FROM STATE TO STATE; THEREFORE, SOME OF THE LIMITATIONS STATED ABOVE MAY NOT APPLY TO YOU. IT IS TO YOUR BENEFIT TO SAVE YOUR DOCUMENTATION UPON PURCHASE OF A PRODUCT. THE INFORMATION AND SUGGESTIONS FOR USE CONTAINED HEREIN ARE BELIEVED TO BE ACCURATE, BUT ARE NOT TO BE CONSTRUED AS WARRANTIES. USER SHALL DETERMINE THE SUITABILITY OF THE PRODUCT FOR HIS OR HER INTENDED USE AND SHALL ASSUME ALL RISK ASSOCIATED THEREWITH.

Complete technical information is available from  
ITW Polymers Sealants North America, Inc.