



Data Sheet

Brushable Contact Adhesive #145 20° + Flashpoint Brushable Grade

Recommended Use

FORMICA® brand brushable contact adhesive #145 is a high quality contact adhesive formulated in a 20° + flashpoint flammable solvent system. It meets the requirements of the Consumer Product Safety Commission (C.P.S.C.) for a contact adhesive in a flammable solvent system that can be sold to non-professional users through retail outlets.

The consistency of FORMICA #145 is designed for bonding high pressure laminate to conventional substrates. It is non-pigmented and can be used with COLORCORE® brand surfacing material.

Advantages

Conforms to C.P.S.C. ruling: Flashpoint above 20° fahrenheit.

High bonding strength. Has excellent resistance to delamination and edge lift.

Ample bonding range: Up to one hour after drying.

Resistant to water, humidity and heat.

Unharmed by freezing: Allow to return to room temperature before using.

Stable: May be stored for 12 months in unopened container at temperatures under 90°F.

Easy to apply with notched spreader, brush or roller. Good flow characteristics to help provide an even coating.

Excellent coverage: From 100 to 200 square feet per gallon, single surface.

How To Use

PRECAUTIONS: VAPORS MAY IGNITE EXPLOSIVELY.

KEEP AWAY FROM HEAT, SPARKS AND OPEN FLAME. Vapors are heavier than air.

Prevent build up of vapors—open all windows and doors—use only with cross ventilation.

Extinguish all flames and pilot lights. Turn off stoves, heaters, electric motors and eliminate all other sources of ignition (including static sparks) during use and until all vapors are gone. Keep container closed when not in use.

HAZARDOUS INGREDIENTS: PETROLEUM DISTILLATE, MEK, TOLUENE. USE ONLY WITH ADEQUATE VENTILATION. Ventilation must be sufficient to limit exposure below MSDS limits.

Eye irritation and dizziness are indications of overexposure.

AVOID PROLONGED OR REPEATED BREATHING OF VAPOR. It is important to use adequate ventilation as high vapor concentrations may cause unconsciousness or even asphyxiation.

DO NOT TAKE INTERNALLY. Swallowing may cause injury, illness or death.

AVOID PROLONGED OR REPEATED CONTACT WITH SKIN. Contact may cause skin irritation and dermatitis.

DO NOT GET IN EYES. Will cause discomfort and irritation.

*CONTACT Adhesive
For Tiles
3214-90-5000
(K99)
UN 1133*

Flammable

TACC International Corporation • Air Station Industrial Park • Rockland, MA 02370
Phone 781-878-7015 • FAX 781-871-6727



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CFR



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*CONTACT ADHESIVE
FOR TILES
3214-90-5600
(KFS)
UN 1133*

TACC International Corporation • Air Station Industrial Park • Rockland, MA 02370
Telephone 781-878-7015 • FAX 781-871-6727



DO NOT EAT, DRINK OR SMOKE IN WORK AREAS.

NOTICE: Reports have associated repeated and prolonged occupational overexposure to solvents with permanent brain and nervous system damage and liver abnormalities. Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal.

FIRST AID

INHALATION OVEREXPOSURE—Remove patient to fresh air. If breathing stops, give artificial respiration. Call a physician. **SWALLOWING**—Seek medical attention immediately. Do not induce vomiting. **EYE CONTACT**—Flush eyes thoroughly with large amounts of water. If irritation persists, see a physician. **SKIN CONTACT**—Remove contaminated clothing and shoes. Wash skin with warm water and soap. Wash clothes and air out shoes. **CONSULT MATERIAL SAFETY DATA SHEET FOR ADDITIONAL INFORMATION. KEEP OUT OF THE REACH OF CHILDREN.**

Material Preparation

Make sure that surfaces to be bonded are clean, dry and free from dirt, grease or other contaminants. Fill significant holes or voids in corestock and sand smooth. Remove all sanding dust and particles. Lightly stir the adhesive to assure complete uniformity from top to bottom of the container. Maintain the temperature of the gluing area, adhesive and materials to be bonded above 65° and at a relative humidity of 35 to 80%.

Application

FORMICA #145 can be applied with a brush or roller. If using a brush, select a firm 3-4 inch wide brush of animal hair or other solvent resistant material. Avoid brushes which tend to spread the adhesive too thin or unevenly. If using a roller, select a short nap, mohair type with a phenolic core... the type used with enamel or oil based paints. Apply an even coat of adhesive to both surfaces to be bonded. A sufficient coverage will generally be indicated by a uniform glossy film. The presence of dull spots indicates insufficient adhesive and will require the application of a second coat once the first coat has dried.

Drying

Allow the coated adhesive to air dry. This will normally take 20 to 30 minutes, depending upon the temperature and humidity. When dry, the adhesives will not transfer to the finger when lightly touched. Once dry, FORMICA #145 has an effective bonding range of up to 1 hour under normal conditions. If the effective bonding range has been exceeded, apply another light coat of the adhesive to both surfaces and allow to dry.

Assembly

When the coated surfaces are ready to bond, align or index them in the exact position desired, make contact and then apply pressure to effect the bond. It is important to apply maximum pressure with a pinch roller or a 3 inch wide hand roller over the entire area.

Edge Banding

FORMICA #145 may be used effectively for edge banding. Coat both the laminate edge strip and core edge with adhesive and allow to dry. Once the first coat has dried, apply a second coat to the more porous core edge. When the second coat is dry, make sure the adhesive film has a uniform glossy appearance. If the adhesive film is not glossy, re-coat and allow to dry. Once an adequate glue line is obtained, align the edge band strip with the core edge by making initial contact at one end and then proceeding along the entire edge. Apply firm pressure on the entire edge with a 3 inch hand roller.

Clean Up

FORMICA #145 adhesive may be cleaned from laminate surfaces and application tools with FORMICA® brand non-flammable contact adhesive solvent. Carefully read and follow all precautions printed on the label when using this product.

Important Notice

This information and statements herein are believed to be reliable but are not to be construed as a warranty or representation for which we assume legal responsibility. Users should undertake sufficient verification and testing to determine the suitability for their own particular purpose of any information or products referred to herein. **NO WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE IS MADE.** Nothing herein is to be taken as permission, inducement or recommendation to practice any patented invention without a license.

NOTE: Copper and its alloys should not be used to transfer or contain any contact bond adhesive. Do not laminate copper with this adhesive.

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