



## FastStick Water-Based Contact Adhesive

**FastStick Water-Based Contact Adhesive** is a waterborne contact adhesive with aggressive tack, high heat resistance and excellent bond strength. This versatile adhesive can be brush, roller, or spray applied. It is suitable for post-forming and flat applications and can be used for EPS-cored insulated panels. FastStick Water-Based Contact Adhesive can be used for lamination of High Performance Laminate (HPL) and other decorative overlays to particleboard and/or MDF core materials in the fabrication of store fixtures, millwork, cabinets, work surfaces, decorative panels and similar products.



### PHYSICAL PROPERTIES

**Adhesive:** Polychloroprene

**Solids Content:** 48 - 52%

**Viscosity:** 1,800 - 2,200 cps

**Specific Gravity:** 1.08

**Weight/Gal:** 9.0 lb

**Coverage/Gal:** 340 ft<sup>2</sup> @ 3.0 dry grams/ft<sup>2</sup>

**Open Time:** 60 minutes

**Color:** White and Green

**VHAP:** 0lb/lb of solids

**VOC:** 0 lb/gal (0 g/L); less water and exempt solvents

### KEY PRODUCT FEATURES

- Solvent-free with zero VOCs
- High solids content for excellent coverage and fast dry times
- Long open time
- Immediate aggressive bond
- High heat resistance

### PERFORMANCE PROPERTIES

- OTC Rules for Adhesives & Sealants – Contact Bond Adhesive

### APPLICATION GUIDELINES

**Conditioning of Materials:** Allow the core and overlay materials to acclimate together at the same temperature and humidity for at least 48 hours before bonding. Optimum conditions are approximately 18°C/65°F and relative humidity of 45% - 55%. Provisions should be made for the circulation of air around the components.

**Stock preparation:** Substrates to be bonded must be clean, dry and free from dust, dirt, grease, oils, solvents or any other contaminants.

**Spread rate:** This adhesive can be brushed, rolled and sprayed. If brushing and rolling, apply 100% coverage (3.0 dry grams/ft<sup>2</sup> or higher). If spraying, a coating weight of 3.0 - 3.5 dry grams/ft<sup>2</sup> should be applied. The atomization pressure at the gun should be 5 - 20 psi and the fluid pressure should be 10 - 15 psi. Ensure that the spray system oil and water traps are functioning, drained regularly and are at least 25 ft from the air compressor.

When applying contact adhesives to porous materials such as plywood and edges, it is advisable to apply two coats. Apply the first coat and allow to dry. This will act as a sealer, prevent the second coat from soaking in, and ensure that there is the sufficient adhesive on the surface to achieve a strong, permanent bond. When dry, apply the second coat and allow it to dry completely before bonding. Waterborne contact adhesives will change appearance from milky to clear when dry.

To check for dryness, use the back of your fingers and press into the adhesive and lift up. Any adhesive transfer or legginess indicates that the adhesive requires more time to dry. If the adhesive feels tacky, but there is no transfer or legginess, the adhesive is ready for bonding. If there are heavy areas of adhesive present, press the back of your fingers in the adhesive and twist. If a skin has formed, this will tear it open and allow you to notice that the adhesive requires more dry time. Do Not use the palm of your hand to check for dryness.

**Assembly time:** Dry time is normally 20-30 minutes, however, will vary depending on temperature, humidity and coat weight. Drying time can be reduced using air movement, drying ovens, etc. Bonds can be made as soon as the adhesive is dry. Bonds made any time during the 60 minute open time will be as strong as those made immediately after drying. Position the pieces carefully, as a strong bond is made instantly upon contact.

**Pressure:** Apply good uniform pressure to ensure good film fusion. A pinch roller is the best method for applying pressure. Use the maximum possible pressure without damaging the substrates. Minimum recommended pressure is 30-40 psi. This is easily achieved with a 3" J-roller. Rubber mallets, blocks of wood, flooring rollers, etc. may not apply adequate pressure and should be avoided.

NOTE: A failed contact adhesive bond with a shiny appearance to the surface of the adhesive is an indication that the recommended open time was exceeded and/or that inadequate laminating pressure was applied during assembly. Do Not Exceed the Recommended Open Time! Apply Sufficient Laminating Pressure. Do Not use copper or its alloys to transfer or contain any contact adhesive. Thinning the adhesive is not recommended.

**Machining:** Completed panels can be processed immediately.

**Clean-up:** Wet adhesive can be cleaned using ammoniated cleaner before adhesive film cures. Dried adhesive can be cleaned using a solvent based cleaner.

## STORAGE AND HANDLING

**Shelf life:** Best if used within twelve months of date of manufacture. Product is not freeze-thaw stable.

**Storage:** Store between 10°C/50°F and 32°C/90°F. Keep container tightly closed and stored off of the floor when not in use. Avoid exposure of containers to direct sunlight. Do not apply or make bonds at temperatures below 18°C/65°F. Use at room temperature, 18°C/65°F, or warmer. For best results use above 22°C/72°F.

### IMPORTANT NOTICE TO CUSTOMER:

The recommendations and data contained in this Product Data Sheet for use of this product are based on information Franklin believes to be reliable. They are offered in good faith without guarantee, as conditions and methods for use of our product by Customer and are beyond Franklin's control. Customer must determine the suitability of the product for a particular application before adopting it on a commercial scale.

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