DASA DS-408 Canister

Contents

Supplier

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Features

- Methylene Chloride free
- Uniform spray
- Fast easy application
- Fast drying
- High solids
- High temperature resistance
- Low odour
- Long Open Time
- Bonds a wide variety of substrates

Product Description

DASA DS-408 will bond a wide variety of substrates, including wood, metals, rubber, fabric, most plastics, cardboard, polythene and concrete, as well as decorative laminates. It is ideal for permanent bonds that require good initial bond strength. It provides good temperature resistance and if protected from contamination has an open time of several hours. Always test a small sample of the materials first to ensure the suitability of the product for the application. For instance, some vinyls contain large amounts of plasticiser which, over time, can migrate and soften the bond. When in doubt, test first.

Do not use on flexible PVC or expanded polystyrene.

Technical Specifications

Property	DASA DS-408	Property	DASA DS-408
Solvent	Hydrocarbon	Colour	Clear
Propellant	Hydrocarbon	Coverage	~100m^2 (dry coat weight of 25gm^{-2})
Solids content (approx.)	30%	VOC	548g /l
Spray pattern	Web	Heat Resistance	90^oC

Directions for Use

USE IN A WELL VENTILATED AREA

1. Surfaces should be clean, dry and free from grease, oil and dust. Excessive dust will impair performance.
2. Attach a suitable spray nozzle, such as a Unijet 9501, to the spray gun.
3. Connect the hose to the canister and the spray gun to the hose and tighten the connections.
4. Open the valve on the canister. The valve should remain open until the canister is used up. Use the locking nut on the gun after use. Turning off the valve will result in the adhesive drying in the hose and gun causing blockages.
5. Hold the spray gun at 90° to the surface and apply a uniform coat of adhesive, to both substrates, ensuring 90-100% coverage. Spray one surface vertically the other horizontally. Pay particular attention to the edges.
6. When the adhesive is dry to the touch it is ready for the bond to be made.
7. Porous substrates may require two applications
8. Drying takes approximately 1 to 2 minutes depending on substrates, ambient temperature and humidity. Over spraying and pooling of the adhesive will increase the drying time and may cause the adhesive to show through the laminate.
9. After spraying, remove the spray gun tip and rinse with Solvent Cleaner before it has cured.
10. It is important to remember that **DASA DS-408** is a contact adhesive and forms a bond by sticking to itself, so there must be sufficient adhesive ***on both surfaces*** for this to happen.
11. Allow the adhesive to tack up and protect from contamination whilst this happens. The adhesive is ready to bond when it feels dry to the touch and does not transfer.
12. Once the two surfaces have been brought together, and aggressive bond will be made. Spacers can be used to ensure the surfaces do not come into contact prematurely.
13. Once the two surfaces are brought together, apply a uniform pressure over the work piece, starting in the middle and working outwards. Use blocks or a 7,5cm roller and ensure the whole piece has been worked to ensure adequate contact of the adhesive.
14. Pay particular attention to the edges. Please note that testing at this point by lifting the edge will weaken the bond. A nip roller will give the best results.
15. Once assembled, the piece can be machined or trimmed as required.
16. Full cure will take 24 hours.

Limitations

DS-408 dries in two minutes under normal conditions, but this will vary under different temperatures and humidities. High humidity and low temperatures will slow the drying time and if the temperature gets very low, can produce bloom. Bloom is moisture which forms on the glue line caused by solvent evaporation lowering the air temperature above it.

Storage

Protect from extremes of temperature in a controlled environment between 15 and 35°C, and away from direct sunlight. **Do not stand on a cold concrete floor**. Low temperatures can result in irreparable separation of the adhesive. Stored under the correct conditions, in original, unopened containers, the product will have a shelf life of 12 months.

DO NOT ALLOW THE PRODUCT TO FREEZE

Disclaimer

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