



H.B. Fuller



ROYAL
ADHESIVES & SEALANTS

Silaprene®

ISO 9001:2000 2/14/05

TECHNICAL SALES BULLETIN

SILAPRENE® DC12880

HAP's FREE, LOW VOC

FLAMMABLE CONTACT ADHESIVE

DC-12880 is a high quality, synthetic rubber general-purpose contact adhesive. It utilizes a Hazardous Air Pollutant-free solvent system. DC-12880 can be used for bonding foam, plastics, carpet, FRP, wood, various metals and many elastomers. Not recommended for highly plasticized materials.

- Low VOC (<400 grams/liter.)
- HAPs Free
- Long open tack time
- Repositionable
- Excellent temperature resistance
- Low-pressure sprayability
- High tack
- Can be sprayed, brush or rolled
- Light colored and non-staining for light colored fabrics
- Excellent general purpose adhesion
- Resistant to humidity and water

SURFACE PREPARATION

Clean, dry, dust-free surfaces are required for optimum bond strength. A solvent wipe is recommended for maximum adhesion. Surface temperatures should be maintained at temperatures above 40° F. Bonds to rigid surfaces are usually improved by a solvent wipe followed with light abrasion (180 grit), and another solvent wiping to remove abrasive residue. Dry surfaces thoroughly before applying adhesive.

APPLICATION METHODS

Suitable spray equipment is listed below. Others are available as well. The adhesive should be applied in smooth even coats to both surfaces at a rate of at least 2 dry grams per square foot of bonding area. Porous materials, such as fabric, foam or wood may require two coats of adhesive. Join the surfaces when the adhesive is tacky to the touch but does not transfer to the finger. Adequate pressure must be applied to assure complete contact.

Binks HVLP BBR Mach I with .055 -.070 fluid tip
Graco Delta with .055-.070 fluid tip
Devilbiss JGMV530 with .055 - .070 fluid tip.

CLEAN-UP

Acetone is recommended for cleaning equipment and over spray. Other solvents will provide varying degrees of cleaning capability.

PRECAUTIONARY DATA

This product is extremely flammable. Vapors may form an explosive mixture with air. Precautions should be taken to keep product away from fire, sparks, motors and other sources of heat or flame. Turn off or deactivate any electrical equipment or sources of ignition. Adequate ventilation is required to keep vapor concentration below the Threshold Limit Value.

- For professional or industrial use only.
- Read the container label and the Safety Data Sheet carefully before use.
- Keep away from children.
- Keep container closed when not in use.

DISPOSAL INFORMATION

Do not reuse container or remove label. Safely dispose of container and contents in accordance with applicable Federal, State and Local regulations.

ROYAL EMERGENCY NUMBER

Chemtrec 800-424-9300

TECHNICAL DATA

<i>Physical Properties</i>	<i>(Typical)</i>
Base:	Synthetic Rubber
Solids:	35%
Solvents:	Acetone, Heptane, Cyclohexane
Color:	Clear to light amber
Heat Resistance:	190-200°F
Viscosity:	200 - 400 cps (#2 @ 20rpm)
Approx. Weight:	7.1 lbs/gal
Open Tack Time:	10-15 Minutes
Cleaner:	Acetone
VOC Content:	< 400 g/l
HAPs Content:	0 lbs/gal.
1" X 6" 180° peel	18pli (cotton duck/AL)
1 square inch shear	250psi (cotton duck to itself)
SAFT	200°F
Storage:	Store in closed container under 80°F.
Shelf Life:	1 year when stored below 80°F in unopened containers.

Royal Adhesives & Sealants, LLC an H.B. Fuller Company • 2001 W. Washington Street, South Bend, IN 46628 • Phone: 800-999-GLUE • Fax: 574-246-5425

This product is warranted to the original purchaser to meet published specifications, it any, and, in the absence of published specifications, to be merchantable quality. Such warranty may not be assigned or otherwise transferred by purchaser. No other warranty, expressed or implied, of fitness for a particular purpose or any other thing is made. Purchaser's exclusive remedy for breach of this warranty shall be a refund of the price paid for the products by the purchaser. Except as stated above, Royal Adhesives & Sealants, LLC, shall not be liable for any defect in, or breach of obligation relating to the defects in these products, regardless of the theory that may be asserted, including, without limitation, negligence, contract, absolute liability in tort or misrepresentation. If the purchaser does not accept goods on these terms, they are to be returned at once, unopened.