

TUSKBOND

HGL100

High Gloss Laminate Adhesive

TECHNICAL DATA SHEET

- Mist Spray • Fast Easy Application • Fast Drying • High Solids • High Temperature Resistance • Low Odour
- Long Open Time • Bond A Wide Variety Of Substrates

DESCRIPTION:

Tuskbond HGL100 spray adhesive is designed to give 100% coating on both surfaces in one pass. It has a mist spray pattern distinctly different to the web. This makes it easy to apply, with more confidence that the required coat weight is being applied. The finish is a smooth, even layer suitable for bonding thin or high gloss laminates to various substrates including MDF, chipboard, plywood and other timber sheet materials. It will also bond to most common building materials such as plasterboard, aluminium, concrete, brickwork and steel. The canister, when equipped with a re-useable hose and gun, eliminates the need for air assisted application systems. 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 SPECIFICATION:

PROPERTY	TUSKBOND HGL100
Solvent	Hydrocarbon/ester
Propellant	Hydrocarbon/nitrogen
Solids Content (approx)	28%
Spray Pattern	Mist
Colour	Pale cream
Coverage (14.3kg Canister)	~ 150m ² (dry coat weight of 25gm-2)
VOC	587g/l
Heat Resistance	100°C
Available Sizes	14.3kg





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DIRECTIONS FOR USE:

- **USE IN A WELL VENTILATED AREA**
- Surfaces should be clean, dry and free from grease, oil and dust. Excessive dust will impair performance.
- Attach a suitable spray nozzle to the spray gun.
- Connect the hose to the canister and the spray gun to the hose and tighten the connections.
- 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.
- Hold the spray gun at 90° to the surface and apply a uniform coat of adhesive, to both substrates, ensuring 80-100% coverage. Spray one surface vertically the other horizontally. Pay particular attention to the edges. Porous substrates may require two applications.
- It is important to remember that Tuskbond HGL100 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.
- 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.
- Drying takes approximately 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.
- Once the two surfaces have been brought together, an aggressive bond will be made. Spacers can be used to ensure the surfaces do not come into contact prematurely.
- Apply a uniform pressure over the work piece, starting in the middle and working outwards. Use blocks or a 3 inch roller and ensure the whole piece has been worked to ensure adequate contact of the adhesive.
- Please note that testing at this point by lifting the edge will weaken the bond. A nip roller will give the best results.
- Once assembled, the piece can be machined or trimmed as required.
- Full cure will take 24 hours.
- After spraying, remove the spray gun tip and rinse with a suitable solvent cleaner before it has cured.

LIMITATIONS

Tuskbond HGL100 dries within 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 & SHELF LIFE:

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. If the adhesive sprays like a jet, the canister is too cold. warm to at least 10°C before using. **DO NOT ALLOW THE PRODUCT TO FREEZE.** Stored under the correct conditions, in original, unopened containers, the product will have a shelf life of 12 months.

DISCLAIMER:

All the information in the Data Sheet is based on practical experience and is published in good faith. However, because we have no control over the manner or conditions in which our products are used, or over work undertaken or end product manufactured by the purchaser, we cannot accept liability for results. Responsibility for ascertaining the suitability of products for his purposes rests with the purchaser. All conditions, representations, statements, warranties or guarantees whatsoever, whether express, implied or statutory, in respect of any goods manufactured, sold or supplied by us are hereby expressly excluded and we accept no liability in respect of any claim for damage or consequential loss caused to any property arising directly or indirectly out of the use of our products or goods.