# 1075G-ZF

**Contact Adhesive**

## PRODUCT DATA SHEET

### DESCRIPTION

Permagrip 1075G-ZF is a bulk spray grade contact adhesive free from methylene chloride.

### BENEFITS

- High solids, non-flammable spray grade contact cement
- Excellent adhesion to a variety of substrates including but not limited to laminates, particle board, plywood, hardwood, leather, rubber and metal
- Excellent room temperature adhesion
- Non ozone-depleting
- Excellent green strength and high heat resistance
- Excellent spray-ability

### HANDLING & APPLICATION

- Avoid application equipment containing aluminum or copper.
- Do not use on polystyrene foams or plasticized vinyl.
- Do not mix with other adhesives.
- Do not use lacquer thinner for thinning.
- Do not thin the adhesive with other solvents or additives.

### STORAGE CONDITIONS

- Rotate stock; use oldest first (FIFO)
- Keep container closed tightly when not in use
- Shelf life expires 1 year from manufacture date
- Do not store in direct sunlight
- If frozen, return to room temperature. Some agitation may be required

**PLEASE REFER TO THE SAFETY DATA SHEET FOR FURTHER INFORMATION.**

**Qualifies for LEED®-NC & CI EQ Credit 4.4: laminating adhesives shall contain no added urea formaldehyde resins**

**AVOID APPLICATION EQUIPMENT CONTAINING ALUMINUM OR COPPER. AVOID COPPER OR COPPER ALLOY SUBSTRATES.**

| TYPICAL PHYSICAL PROPERTIES | |
|---|---|
| **Adhesive** | Non-Flam / Non-Flam Adhesive / Propellant |
| **Dry Time** | 2-5 minutes |
| **Open Time** | 30 minutes |
| **Color** | Natural, Red and Green |
| **Flash Point** | >93°C |
| **VOC** | 740 g/L |
| **Coverage Rate** | 205-250 sq.ft. per gallon double bonded |
| **Clean Up** | Choice Brands 1000 |
| **Shelf Life** | 1 year in unopened container |
| **VHAP** | 2.75 lbs/lbs of solids |
| **Pattern** | Web |

| SIZE AVAILABILITY | |
|---|---|
| PG-1075GZF-1 | 1 Gallon |
| PG-1075GZF-5 | 5 Gallon |
| PG-1075GZF-54 | 54 Gallon |

### APPLICATION

1. Substrates should be clean and free of moisture, dirt, oil and other contaminates.
2. For best results, adhesive and substrates should be allowed to acclimate to room temperature (approximately 60°F or above) before adhesive application.
3. The adhesive should be applied at approximately 2.5-3.0 grams/sq. ft. The adhesive should cover 80% of the substrate surface. The substrate surface should exhibit a uniform glossy sheen when the adhesive is completely dry. Dull areas indicate insufficient coverage. Adhesive should be reapplied to these areas.
4. When bonding porous substrates, it is advisable to apply two coats of adhesive. The first coat will act as a sealer and prevent excessive absorption of adhesive into the substrate. After the first coat has dried, apply a second coat. Allow the second adhesive coating to dry completely before assembly. (continued on page 2)



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5. Allowing the contact adhesive to dry completely before assembly is essential to obtaining a secure, permanent bond. To check for adhesive dryness, press the back of your fingers onto the adhesive surface. If adhesive transfers to fingers, additional dry time is necessary. If there is no adhesive transfer, substrates are ready for bonding.
6. If areas exist with excessive adhesive deposition, twist the fingers while pressing them onto the adhesive layer. This will break any skin that may have formed as the adhesive dries from the top surface down. If a skin has formed, allow additional dry time to ensure complete evaporation of the solvent before bonding.
7. Dry times can be improved through the use of air movement, drying ovens, lamps, etc.
8. Substrates may be indexed together and bonded once the adhesive is dry. Bonds must be made within the open time of the adhesive. (Open times vary depending on application and environmental conditions.)
9. Uniform pressure on the bonded laminates is necessary to create strong, lasting bonds. 40 pounds per linear inch is recommended to ensure complete fusion between the two layers of adhesive. A pinch roller is the ideal method for applying uniform pressure. When used properly, a J-roller can also provide sufficient pressure for bonding.
10. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed and machined

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