SPRAYING MANUAL

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QUIN GLOBAL
Tensor

Tensorgrip
Adhesives That Outperform

CONTENTS

- Spray Patterns
- Preparation
- Application
- Bonding Techniques
- Changing to a New Canister
- Disposing of an Empty Canister

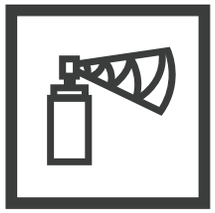
SPRAY PATTERNS

IDENTIFYING SPRAY PATTERNS

IMPORTANT ALWAYS CHECK WHAT TYPE OF SPRAY PATTERN YOUR ADHESIVE HAS BEFORE SPRAYING.

It is imperative that you ensure what type of spray pattern the adhesive will be released from the container in; failure to identify this can lead to improper applications and undesired results. To confirm the product's spray pattern, simply check the label and a property icon (like the one pictured left and listed below) will indicate this.

TYPES OF SPRAY PATTERN



WEB SPRAY

Description:
The easiest visual comparison that can be made to a Web spray is that of a spider's web, hence the name!

MIST SPRAY

Description:
Mist spray adhesives are released from the container as a fine mist, which creates a light and consistent droplet pattern on the surface it is sprayed upon.

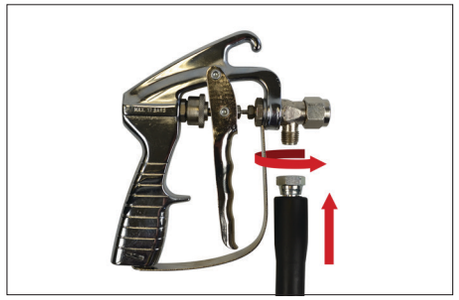
PEBBLE SPRAY

Description:
Pebble sprays are similar to Mist sprays however the pattern is made up of larger droplets, but still giving a smooth and consistent pattern on the surface.

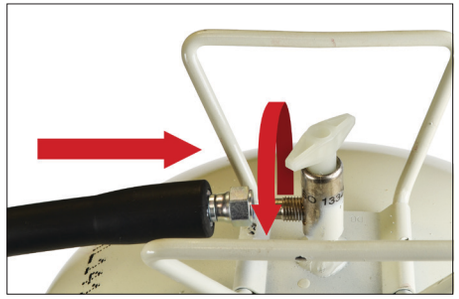
SNOWFLAKE SPRAY

Description:
Snowflake spray adhesives have a High build, large flake spray pattern which resemble snowflakes across the surface for single-sided bonds.

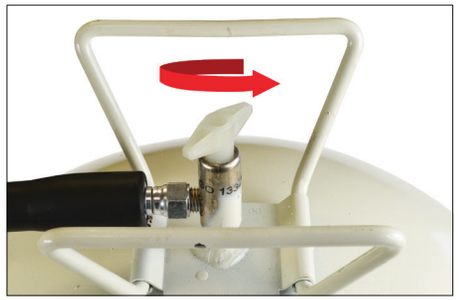
PREPARATION



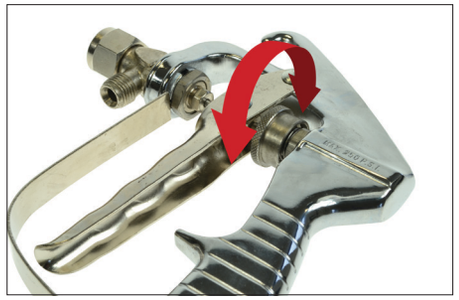
1. Screw the larger hose nut to the gun thread (clockwise) and fully tighten with a spanner. Check hose is securely attached.



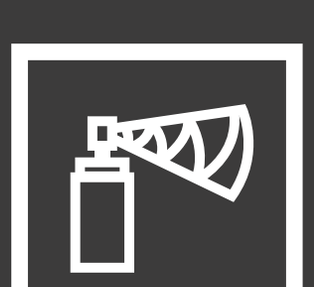
2. Screw the smaller hose nut to the canister (clockwise) and fully tighten with a spanner. Check the hose is securely attached.



3. Turn on the valve on the canister anti-clockwise until fully open. Check connections for any leaks and if any occur tighten connections. DO NOT TURN THE CANISTER VALVE OFF UNTIL THE CANISTER IS EMPTY (this is to prevent the adhesive curing in the hose and gun).



4. On initial use, or if the product has been standing for more than 12 hours, the hose and gun may require a purge. Do this by pulling the trigger and adjusting the flow by turning the adjustment screw at the back of the gun (anticlockwise to open and clockwise to close). Dispense and discard adhesive until a consistent spray pattern is achieved.



WEB SPRAY

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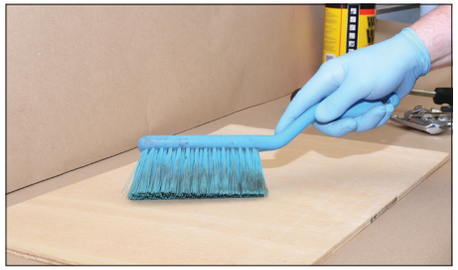
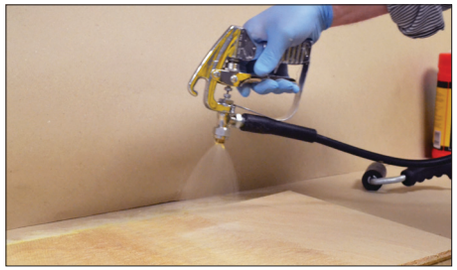
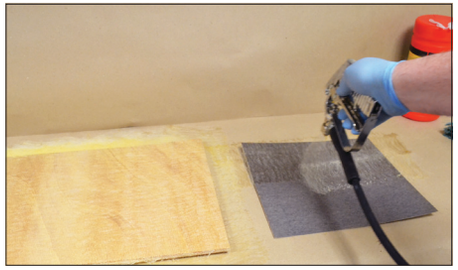


1. Prepare the surface to be bonded; ensuring both faces are clean, free of dust, dirt and grease. If necessary wipe clean with proprietary solvent-based cleaner. DO NOT USE WHITE SPIRIT, METHYLATED SPIRITS OR CITRUS-BASED CLEANERS.

2. Hold spray gun at a constant distance of between 100-250mm (4”- 10”) from the surface, allowing the adhesive to web across the surface with approximately 50-70% overlap to successive passes for thin laminates to reduce risk of telegraphing (note — correct coat weight must be achieved).



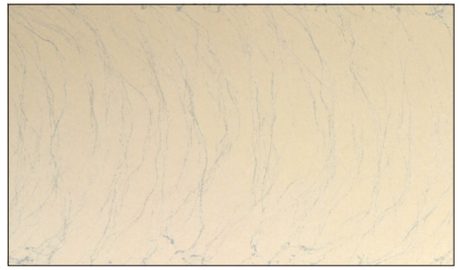
3. Maintain a constant speed of application during spraying, applying a consistent and thorough coating without allowing the adhesive to puddle or heavily ‘wet’ the surface. Maximum bond strength is achieved with coverage of between 80-100%, and a recommended minimum coat weight of 20 dry grams per m^2.



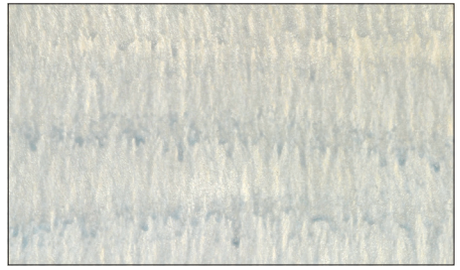
4. Maximum adhesion will be obtained by spraying mating faces at 90° to each other, i.e. one face vertically, the other face horizontally. Double coating perimeter of face and edges is recommended, including areas around subsequent cutting positions.

BONDING TECHNIQUES

- Do not angle spray gun or move in an arc while spraying. Hold gun at 90° to surface while spraying. Release trigger at end of each pass to optimize coverage.
- Many man-made boards such as plywood and especially flexi-ply and MDF are very absorbent and will need a primer coat (shown in ‘COVERAGE TOO LIGHT’ picture). Allow to dry, then apply the normal ‘CORRECT APPLICATION’, as shown, over top of primer coat.
- Many substrates should be regarded as difficult to bond, e.g. metal faced HPL, Colorcore etc. or products with memory (also soft and thick materials may require 2nd or 3rd coat). Best results are obtained by multiple coats rather than one heavy coat which may result in heavy wetting of surface and extended drying times. Always test before using in production – see disclaimer.
- Allow adhesive to dry (see product data sheets for appropriate drying times). Test for dryness using back of hand only; surface should be tacky but adhesive should not transfer to skin. Position substrates correctly and press together working from centre outwards. Apply adequate pressure using nip roller or 75mm hand roller and body weight as a minimum in order to achieve at least 35psi at glue line. Note; repositioning is not possible after contact has been made.
- Immediate trimming/routing is possible. Full strength is achieved after 24-48 hours depending on temperature and humidity.

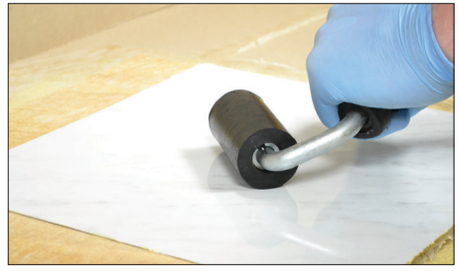


COVERAGE TOO LIGHT

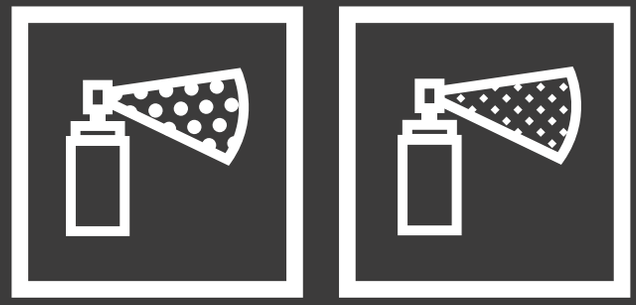


COVERAGE TOO HEAVY

CORRECT APPLICATION = 20 dry gms/sqm

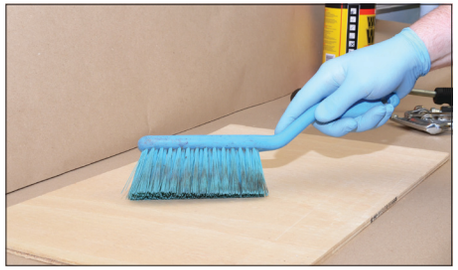


75mm HAND ROLLER



PEBBLE/MIST
SPRAY

PEBBLE/MIST SPRAY



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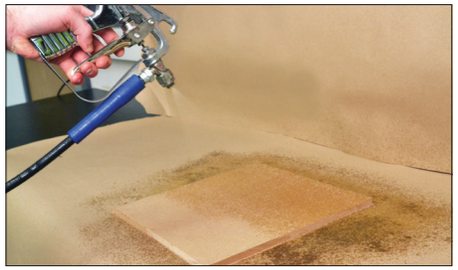

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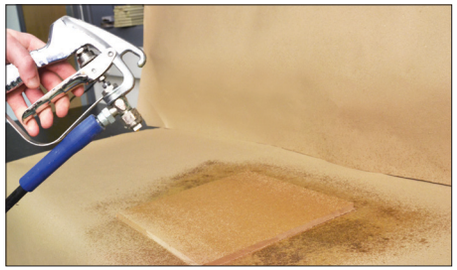

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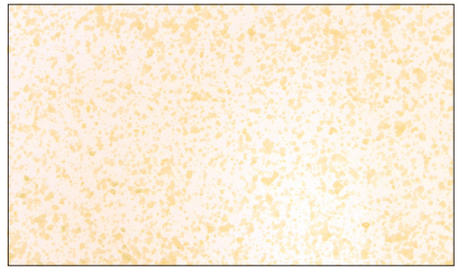

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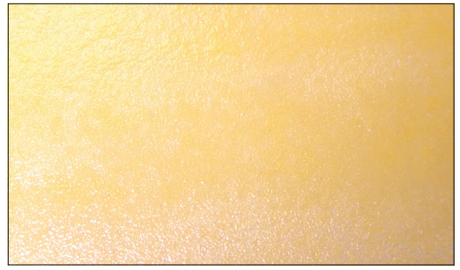

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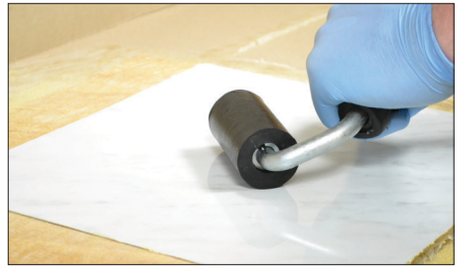
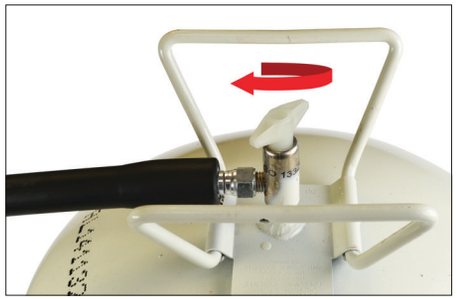


75mm HAND ROLLER

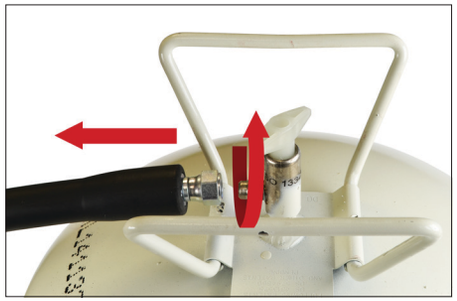
CHANGING TO A NEW CANISTER



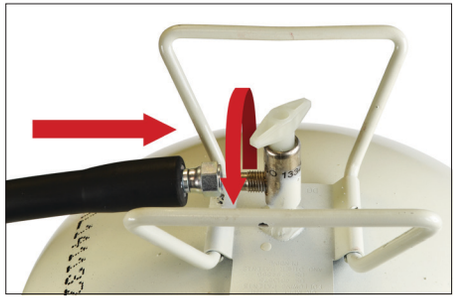
IMPORTANT: SAFETY GLASSES AND GLOVES MUST BE PUT ON BEFORE STARTING THE DISPOSAL PROCESS

1. Turn off the valve on the canister anti-clockwise until fully closed.

2. Pull the trigger on the gun and hold for 10 seconds to expel residual pressure.



3. Unscrew the hose nut and disconnect the hose from the empty canister (move to next page for canister disposal).



4. Connect the hose and gun to the new canister (go to Step 2 of **PREPARATION** and follow the process through to Step 4).

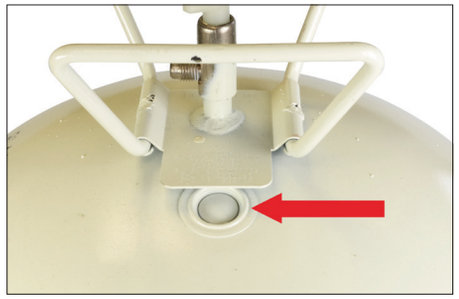
IMPORTANT NOTE: THIS PROCESS SHOULD BE FOLLOWED THROUGH IMMEDIATELY AND ADHESIVE SHOULD BE DISPENSED FROM THE NEW CAN OR THE GUN AND HOSE WILL BLOCK AND BECOME UNUSABLE.

If you are not transferring the hose and gun to a new canister you will need to clean it to ensure it can be used again on future jobs.

DISPOSING OF AN EMPTY CANISTER

1. Lay the empty canister on its side with the valve pointing AWAY from the operator, and well away from sources of ignition.

2. Open the canister valve (anti-clockwise) and release any residual pressure.



3. Stand canister upright. Use a hammer and brass punch or other non-sparking instrument to puncture the friable disc.

4. As long as the user is able to accept responsibility for de-pressurising the canister, it can be disposed of as per your normal scrap metal disposal (subject to local waste restrictions).

TRANSPORT INFORMATION

- During transport, the recommended PPE (Refer to MSDS), First Aid Kit and suitable Fire Extinguisher should be readily accessible in the vehicle.
- Keep vehicle well ventilated at all times whilst it contains TensorGrip® Spray Contact Adhesive.
- Secure canister during transportation.

GUARANTEE

Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product. Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions. The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.

CONTACT

If you are having trouble with one of our products or if you require any further information, please don't hesitate to get in touch.

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