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**WEB SPRAY  
APPLICATION**



## STEP 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.**



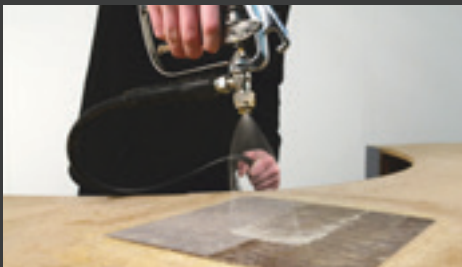
## STEP 2.

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).



## STEP 3.

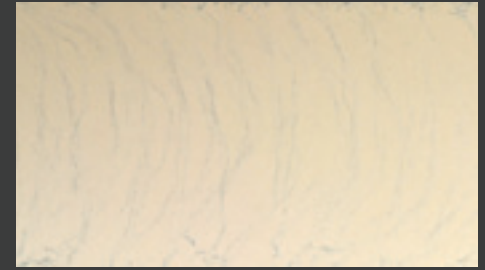
Maintain a constant speed of application during spraying, applying a consistent and thorough coating without allowing the adhesive to puddle or heavily 'wet' the surface. Maximum bond strength is achieved with coverage of between 80-100%, and a recommended minimum coat weight of 20 dry grams per m<sup>2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



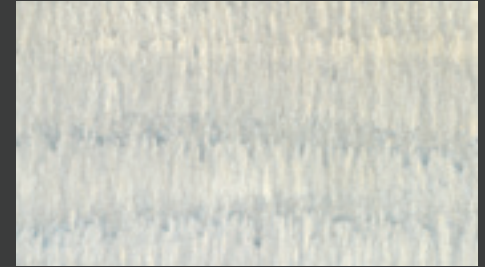
## STEP 4.

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.

- 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/m<sup>2</sup>



75mm HAND ROLLER