



HC7382 FOAM ADHESIVE GREEN

HC7382 FOAM ADHESIVE GREEN is a synthetic elastomer based, pressure sensitive adhesive specifically formulated to bond polyurethane foam to itself as well as a number of other porous and non-porous substrates. It is intended for use in the manufacture of foam fabrication, bedding and mattresses, decorative panels as well as a variety of other foam bonding end uses.

SUGGESTED APPLICATIONS

- Foam to foam bonding
- Foam to fabric bonding
- Foam to wood, metal & plastics

KEY PERFORMANCE FEATURES

- Aggressive grab tack
- Quick dry time
- Long open time (1 hour +)
- Excellent adhesion to a variety of substrates
- Water resistant
- Heat resistant
- Ready to spray for most systems
- High visibility green colour
- Soft bond line

PHYSICAL PROPERTIES

Colour	Green
Odour	Mild (organic solvent)
Base	Synthetic Elastomer
Relative Density	0.8300 ± 0.01 gms/cc
Viscosity	100 +/- 20 cps
VOC (EPA #24)	395 gms/l
Flash Point	Approx. -20°C T.C.C.
Total Solids	40.00% ± 1% (2 hours @ 135°C)

Freeze/Thaw Stability	Stable, if frozen, allow adhesive to return to room temperature & stir well before use
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ADDITIONAL CHARACTERISTICS

Reduction	None required
Clean-up	T5122 Toluene
Shelf-life	6 months – closed container
Typical Coverage	2.50 - 3.00 grams per square foot or 200 - 250 square feet per US Gallon
Dry Time	2 - 10 minutes
Packaging	18.9L pail

SURFACE PREPARATION – Surfaces to be bonded must be clean and dry. Remove all dirt, dust, oil, wax, grease or other contaminants.

APPLICATION – Adhesive should be applied at 60°F (15.6°C) to 95°F (35°C). Apply the adhesive to both surfaces at a minimum coverage rate of 80%. Some porous substrates may require 2 coats. 100% coverage is recommended for all edges.

Both surfaces must be allowed to dry before bonding. Drying time is usually 2 to 10 minutes at room temperature under normal conditions. Heat, humidity or cold weather can affect the dry times. Surfaces are dry if the adhesive is tacky, but no adhesive transfers to the hand when touched.

The bond should be completed within 60 minutes (under normal conditions) after the adhesive is dry. If the 2 surfaces do not grab immediately when brought together, they have dried too long.

Position coated surfaces carefully before putting them together since no shifting is possible once contact is made.

Bring the surfaces together and immediately apply firm pressure over the entire surface working from the center to the edges. Apply a minimum of 30 psi uniform pressure over 100% of the bonded area.

Let bonded parts cure for at least 72 hours before exposing them to direct sunlight or temperatures over 150°F (65°C)

CAUTION - Do not use on some vinyls. Certain vinyls contain plasticizers which can, over time, soften and dissolve the bond or bleed through / discolor the substrate. Conduct compatibility testing when in doubt.

HC7382 FOAM ADHESIVE GREEN (cont'd)

SAFETY – During application, always wear eye protection, gloves and appropriate work clothing to minimize contact. Use a respirator and safety glasses at all times.

Explosion proof ventilation is required with special consideration for enclosed or confined areas. Use caution when handling flammable liquids and eliminate sources of ignition and uncovered containers from the work place. Vapours formed from this product may travel or be moved by air currents and ignited by pilot lights, light switches, other flames, smoking, sparks, heaters, electrical equipment, static discharges or other ignition sources at locations distant from the product.

DISPOSAL - Disposal of chemicals and their solutions should be done according to local, provincial and federal regulations. Safety Data Sheets are available and should be consulted when handling products. These products are for industrial and professional use only; Application directions must be followed.

WARRANTY – Halton Chemical Inc. warrants that its products are free from defects in manufacture for a period of one (1) year from date of purchase, if used prior to expiration date, applied and used in accordance with Halton Chemical Inc's most current published specifications applicable to such products. Halton Chemical Inc. expressly disclaims all other warranties, express or implied, including the implied warranties of merchantability and fitness for purpose. Halton Chemical Inc. disclaims all liability for incidental, consequential or indirect damages of any nature whatsoever. This warranty cannot be changed or modified whether by course of dealing, custom or trade or otherwise, unless agreed to in writing by Halton Chemical Inc.



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Ver04/23 - Supersedes all previous versions
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