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TECHNICAL SALES BULLETIN

Hydra FAST-EN DC12929

DESCRIPTION

Hydra FAST-EN DC-12929 is a water-based adhesive for use in general fabrication. Various substrates can be used including polyurethane foams, fabrics, plastics, leather, HPL (high pressure laminates such as Formica) and wood-based products (particle board, plywood, etc.).

When used as a 1-part DC-12929 has good bond strength development. It can be sprayed, rolled or brushed and needs to be fully dried before mating. Depending upon ambient conditions and laydown requirements, dried conditions can be achieved in as little as 4-6 minutes.

DC-12929 can also be used as a 2-part system (with DC-12239 part B) when immediate mating with high strength is desired. Substrates that transmit water (including wood based products) allow water in the bondline to migrate out while maintaining a good tight bond. Full adhesive strength is developed in 3 to 12 hours depending on substrate type and ambient conditions.

PRODUCT FEATURES

- **Water-based** -- No VOC's, easy clean up.
- **Quick Bonding** -- Immediate for 2-part application; As soon as 4-6 minutes for 1-part applications (depending upon ambient conditions and laydown).
- **Delayed mating** -- If desired, parts can be mated as long as 20 minutes after spraying.
- **Color tinted** -- Aids in noting coverage and uniformity: Standard color is light green.
- **Environmentally Friendly** -- Neither wet nor dry adhesive is considered a RCRA hazardous waste
- **Equipment friendly** -- 2 parts are mixed external to the spray gun (when used as a 2-part).
- **High shear stability**-- Not affected by high shear forces from mechanical pumps or mixers.
- **Temperature range** -- The dried adhesive has a use range of -50 to 190 °F.
- **Shelf life** -- Six months when stored between 40°F and 80°F in unopened containers.

TYPICAL PROPERTIES

(specification values available upon request)

DC12929:

Base	Polychloroprene rubber
Color	Black
Solids	50.25%
Viscosity	6500 cps (#2 @ 10 rom)
Weight/Gallon	9.01 lbs
Specific Gravity	1.079
Ph	11.0
VOC	None

DC-12239 Part B (when used as 2 -part)

Base	Zinc Sulfate
Color	Clear
Solvent	Water
Solids	15.0%
Viscosity	Water thin
Weight/Gallon	9.3 lbs.
Specific Gravity	1.12
pH	2.0-4.0

COVERAGE

Hydra FAST-EN DC-12929 is color tinted to aid the operator in the correct amount to be applied. Custom colors are available upon request. The color tint also aids the operator in determining if uniform coverage is being achieved. Recommended laydown is 4-6 grams wet l ft².

DC-12929 when used as a 1-part requires a full dry condition before mating. Application can be by spray, roll coating, or brush. Ambient conditions and adhesive laydowns will dictate required times to achieve a full dry condition.

For low laydowns with good ambient drying conditions 4 to 6 minutes are usually acceptable. Assisted drying can reduce this time. Ample pressure is then applied to assure uniform contact. Mated parts can be handled immediately.

DC-12929 when used in a 2-part scenario requires the use of DC-12239 as an activator (Part B). A 2-part spray gun is required. Part B flow rate should be adjusted to guarantee full conversion of part A to a solid adhesive film. The following are recommended approximate mix ratios:

By Volume or Weight

DC-12929 Part A	100
DC-12239 Part B	10 - 20

These parameters are adjusted by air pressure settings to the required levels to achieve the effect desired. The air supply used must be consistent (no wide fluctuation in line pressures) and be oil free to achieve the best results. Atomizing air pressures can be adjusted over a wide range to meet specific requirements.

Sprayed parts in a 2-part scenario can be mated immediately. Ample mating pressure is applied to assure uniform and firm contact. Mated parts can be handled immediately. Full bond strength develops within hours.

EQUIPMENT CONSIDERATIONS

Hydra FAST-ENTM DC-12929 is compatible with most of the currently available one part spray gun systems and two part external mix spray gun systems. The two part systems are designed to deliver Part A and B materials to the spray head via air pressure. Each part has its own pressure setting. Part B is delivered to the spray head and introduced to Part A external to the spray head, which minimizes spray head clogging problems. It is recommended that product be gently stirred (5-10 minutes) before each use.

EASY CLEAN-UP

Clean up is easily accomplished using a commercially available liquid detergent (Pinesol) in a 5 -10% water solution. Tap water alone is not recommended for clean up.

PRECAUTIONARY DATA

- For professional or industrial use only
- Use with adequate ventilation
- Read the container label and the Material Safety Data
- Sheet carefully before use
- Keep away from children
- Keep container closed when not in use.
- Protect from freezing

DISPOSAL INFORMATION

Do not reuse container or remove label. Safely dispose of container and contents in accordance with applicable Federal, State and Local regulations.