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**Product
Bulletin**

A-30

**MICROSORB
CONTACT ADHESIVES**

GENERAL DESCRIPTION

MICROSORB offers different types of contact adhesives for bonding foam absorbers to substrates.

MICROSORB 504 is a non-flammable chloroprene rubber based contact adhesive. It is formulated for spray applications.

MICROSORB 707 is a flammable chloroprene rubber based adhesive. It is formulated for spray applications.

MICROSORB 808 is a flammable chloroprene rubber based adhesive. It is formulated for roller or brush application.

SIZES

MICROSORB contact adhesives are available in one-gallon and five-gallon containers.

APPLICATION

Surface must be clean, dry and dust free. Metal surfaces should be roughened to aid in bonding. Wipe with a solvent to remove oil and dirt. For best results, temperature of adhesive and surfaces should be at least 65°F.

Stir well before using.

Spray or roll a thin even coat of adhesive to both surfaces, overlapping 40 – 50%.

Refer to second page for detailed instructions.

PROPERTIES

Physical Properties	MICOSORB 504	MICROSORB 707	MICROSORB 808
Total Solids by Weight	9 – 10 %	16 – 17%	19 – 20 %
Total Solids by Volume	10 – 11 %	10.75 – 11.75 %	12.5 – 13.5 %
Theoretical Coverage 1 mil dry, no loss	170 sq ft/gallon	180 sq ft/gallon	21 sq ft/gallon
Viscosity #1 @ 20 RPM @ 20°C	300 – 350 cps	225 – 250 cps	600 - 650
Weight/Gallon	11.1 – 11.5 lbs	6.8 – 7.2 lbs	6.8 – 7.2 lbs
EPA Method 24 V.O.C. (minus water & exempt)	9.17 lbs/gallon	5.65 lbs/gallon	5.45 lbs/gallon
V.O.C. "As Supplied"	3.74 lbs/gallon	4.74 lbs/gallon	4.50 lbs/gallon
Lbs V.O.C. per lb of Solids	3.58	4.06	3.28
Lbs V.O.C. per Gallon of Solids	37.13	42.11	34.02
Lbs of "HAP" Solvent per lb of Solids	9.74	2.74	2.28
Color	Amber	Amber	Amber

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 Rev 2 042407



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Application:

SURFACE PREPARATION: Surface must be clean, dry and dust free. Wiping with T-400 Solvent will aid in removing oil and dirt. Metal surfaces should be roughened to aid in bonding. For best results, temperature of adhesive and surfaces should be at least 65.F.

TO APPLY: Stir well before using.

Microsorb 504 is supplied ready to use. Spray a thin even coat of adhesive to both surfaces, overlapping 40 -50 %. Pressure pot is the preferred application method. The pressure for a pressure pot system should be set to 15 – 20 PSI at pot, and 50 – 70 PSI gun atomizing pressure.

Microsorb 707 is supplied ready to use. Spray a thin even coat of adhesive to both surfaces, overlapping 40 -50 %. Pressure pot is the preferred application method. The pressure for a pressure pot system should be set to 15 – 20 PSI at pot, and 50 – 70 PSI gun atomizing pressure.

Microsorb 808 is supplied ready to use. If cement in pail begins to thicken, you may add solvent. Brush or roll a thin even coat of cement to both surfaces. Coating of both surfaces gives greater strength and permits longer open time before bonding. The work may now be bonded. Place work carefully as it may be difficult to move once positioned. There are different methods being used, all work if done properly. Using a J roller apply even pressure over entire area. Always work from center to edges using an overlapping pattern to avoid any bubbles.

- **POROUS SURFACE (S):** Very absorbent material may require more than one coat. Allow first coat to become tacky then apply second coat. Bond while adhesive is still wet or aggressively tacky.
- **NON-POROUS SURFACE (S):** Allow adhesive to dry until it is tacky but will not transfer to knuckle when touched. Join surfaces with firm pressure.
- **DRYING TIME:** Drying time depends on temperature, humidity, air movement and porosity of the materials bonded. Let coated surfaces dry for 15-30 minutes then test with finger (rubber gloves are recommended) Dry contact cement will appear glossy.
- **CLEAN-UP:** Excess adhesive may be removed with Solvent.
- *We recommend testing substrates prior to use, to ensure proper bond is achieved.*

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