

## EC-1099 Plastic Adhesive



Most recommended adhesive to use with any of the AcoustiGuard™ sheet or roll goods. Will not damage or react with the Barymat barrier or Conasorb acoustic foam products.

- Provides excellent adhesion to bare metal, painted metal, primed wood, glass and many types of plastic, rubber and vinyl.
- 1099 is a fast drying, high strength adhesive offering excellent resistance to weathering, water, oil, fuel and migrating plastisizers used in vinyl goods.
- Single surface application, 1099 applied to surface that acoustic material is being fastened to, i.e. enclosure panel. Apply with disposable brushes, cardboard / plastic spreaders.
- Coverage is approx. 1 litre per sheet (27 sq. ft.).

Available in: 1, 3.75 and 18.5 litre cans. Standard precautions must be taken when using any solvent / spray adhesive. Use only in well ventilated areas away from open flame or sparks. Wilrep Ltd. Provides manufacturers' M.S.D.S. Sheets with all adhesive purchases and conforms to required shipping practices.

### Suggested Installation Instructions

**Surface Preparation:** Remove all dust, dirt, oil, grease, wax, loose paint, etc. Wiping with 3M Scotch-Grip Solvent No.3, methyl ethyl ketone (MEK) or 3M Citrus Base Industrial Cleaner will aid in preparing the surface for bonding.

**Application Temperature:** For best results the temperature of the adhesives and surfaces should be at least 65° (18°C).

**Application:** Stir well before using.

**Porous Surface(s):** Brush, flow or spray a thin, even coat of adhesive to one or both surfaces. Coating both surfaces is preferred since it gives greater strength and permits longer open time before bonding. Very absorbent material may require more than one coat. Bond while adhesive is still wet or aggressively tacky. Join surfaces with firm pressure.

**Non-Porous(s):** Brush, flow or spray a thin, even coat of adhesive to both surfaces. Allow adhesive to dry until tacky. Join surfaces with firm pressure.

**Drying Time:** Drying time depends on temperature humidity, air movement, and porosity of the materials bonded. Greater immediate strength may be obtained by heater or solvent reactivation. See Reactivation below.

**Reactivation:** To solvent reactivate, coat both surfaces with adhesive. Allow to dry tack-free. Lightly wipe one surface with a solvent such as a Scotch-Grip Solvent No.3 or methyl ethyl (MEK). Complete bond within 30 seconds.

To heat reactivate, coat both surfaces with adhesive. Allow adhesive to dry completely. Reactivate by heating one or both surfaces to minimum of 180°F(82°). Assemble immediately (while hot), using firm pressure to ensure contact.

Curing: EC 1099 Plastic Adhesive, EC1099 may be heat cured to obtain superior properties. Cure assembled parts at time and temperature listed using 100 psi pressure on the bond line.

<u>Temperature of Bondline</u>	<u>Time for Minimum Cure</u>
200°F (93°C)	120 Minutes
240°F(116°C)	40 Minutes
280°F(138°C)	12 Minutes
320°C(160°C)	8 Minutes
360°C(182°C)	5 minutes
400°F(204°C)	2 Minutes

Cleanup: Excessive adhesive may be removed with Scotch-grip Solvent No.3 or methyl ethyl ketone or acetone preferably while adhesive is still wet.

\* Note: When using solvents, extinguish all ignition sources, read and follow the manufacturer's precautions and directions for use when handling such materials.

Storage : Store product at 60 - 80 F(16-27 C) for maximum life. Higher temperatures reduce normal storage life. Lower temperature cause increased viscosity of a temporary nature. Rotate on a "first in first out" basis.

Shelf Life: When stored in the original unopened container, under the conditions recommended, EC1099 has a shelf life of 15 months.