



LION GRIP

Adhesive / Adhésif

R 250

FEATURES AND BENEFITS:

LIONGRIP R250 is a unique Low VOC, High Solids contact adhesive used for bonding High Pressure Laminate and other demanding applications. It's Low VOC's permit its use in all OTC (Ozone Transport Commission) states, which require contact adhesives have Low VOC content. The high solids allow for almost 50% more coverage than conventional contact cements.

CHARACTERISTICS:

LIONGRIP R 250 is the best Low VOC Contact Cement on the market. The Low VOC's allows it to be compliant for use in OTC states. The high solids allow for increased mileage over all conventional solvent contact cements. The low open time and high heat resistance provide for the highest performance in the industry and allows contact cement users to easily convert over from high VOC cements to a low VOC contact. Low odor.

The product can be spray, brush or roller applied. It sprays with a better pattern than conventional contact cements. It dries fast with high initial tack and bond strength. It works well when bonding many difference surfaces to include plastic laminate, insulation, metals (not copper), wood, foam and fabrics and many headliner materials.

When converting from a high VOC contact to R250, see technical bulletin (to be supplied) for transition steps.

PHYSICAL PROPERTIES:

Base:	Synthetic Rubber
Solvent:	Blend of Hydrocarbons and Ketones
Solid Content (approx.):	36% +/- 1%
Viscosity:	120 cps
Color:	Natural/Red
Flash Point:	-20°F
Dry Time:	4 – 6 Minutes
Open Time:	60 Minutes
VOC:	239 grams/liter (EPA Method 24)
Shelf Life:	1 year in unopened container
Recommended Coverage:	275 sq. ft./ gallon bonded surfaces
Clean Up:	Lion Grip Cleaner/Thinner RS02020L, R009 or RCCAR

PACKAGING & COLOR:

R 250 20 11	Natural	5 gal / 19 liters
R 250 20 80	Red	5 gal / 19 liters
R 250 54 11	Natural	54 gal / 205 liters
R 250 54 80	Red	54 gal / 205 liters

DISCLAIMER OF WARRANTY:

Manufacturer and distributor of this product make no warranty, express or implied, including, but not limited to any implied warranty of fitness for a particular purpose. No warrantee is made as to the use or effects incidental to such use, handling or possession of the materials herein described. User is responsible for determining whether this product is fit for a particular purpose and method of application and assumes all risk and liability associated herewith. Manufacturer liability is limited to replacement of product or reimbursement of purchase cost, at its sole discretion. No representative of ours has authority to change this provision which relates to all sales.

See Material Safety Data Sheet for Proper Handling and Safety Information

REV 5/14

LIONGRIP R250

High Solids, Low-VOC Adhesive Spray

APPLICATION:

1. Substrates should be clean and free of moisture, dirt, oil and other contaminants.
 2. For best results, adhesive and substrates should be allowed to acclimate to room temperature (approximately 60°F or above) before adhesive application.
 3. Apply a minimum of 3.0 dry grams/sq. ft. For best results, apply two coats of adhesive to any porous surface; one base coat and a secondary top coat. This ensures adequate layup particularly on CARB 2 PARTICLEBOARD and other similar surfaces. Allow the second coat to completely dry before assembly. The adhesive should cover 80% of the surface of the substrate. The coated substrate surface should exhibit a uniform glossy sheen when the adhesive is completely dry. Dull areas indicate insufficient coverage. Adhesive should be re-applied to these areas.
 4. Make sure to coat all exposed edges and corners with two coats of adhesives. When bonding very porous substrates, it is advisable to apply two coats of adhesive. The first coat will act as a sealer and prevent excessive absorption of adhesive into the substrate. After the first coat has dried, apply a second coat. Allow the second adhesive coating to dry completely before assembly.
 5. Allowing the contact adhesive to dry completely before assembly is essential to obtaining a secure, permanent bond. To check for adhesive dryness, press the back of your fingers onto the adhesive surface. If adhesive transfers to fingers, additional dry time is necessary. If there is no adhesive transfer, the substrates are ready for bonding.
 6. If areas exist with excessive adhesive deposition, allow additional dry time to ensure complete evaporation of the solvent before bonding.
 7. Dry times can be improved through the use of air movement, drying ovens, lamps, etc.
 8. Substrates may be indexed together and bonded once the adhesive is dry. Bonds must be made within the open time of the adhesive. (Open times vary by adhesive. See page 1).
 9. Uniform pressure on the bonded laminates is necessary to create strong, lasting bonds. 40 pounds per linear inch is recommended to ensure complete fusion between the two layers of adhesive. A pinch roller is the ideal method for applying uniform pressure. When used properly, a J-roller can also provide sufficient pressure for bonding.
 10. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed and machined.
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SPRAY INFORMATION:

	Manual	Systems	Automatic	Systems
	Binks	DeVilbiss	Binks	DeVilbiss
Spray Gun	95, 2001,	JGA510, MSA510	21,95A	AGX550
Fluid Tip	63ASS	FX	63ASS	FX
Fluid Needle	663A, 563A	FX	263A,763A	FX
Air Cap	66SD-3	24	66SD-3	24

APPLICATION PRECAUTIONS:

Do not use in applications with copper or aluminum components.

Do not use on polystyrene foams or plasticized vinyls.

Do not mix with other adhesives. Thinning the adhesive is not recommended.

STORAGE:

Rotate stock, use oldest first. Keep covered to prevent solvent loss and contamination.

Store product between 60 – 80°F. Do not store in direct sunlight.

Do not freeze. If frozen, return to room temperature prior to use.

If frozen, some agitation of the product might be necessary once the product returns to room temperature.