



LION GRIP

Adhesive / Adhésif

R 661

FEATURES AND BENEFITS:

LIONGRIP R 661 is a high temperature, contact adhesive packaged in a convenient and easy to use canister. It is designed for bonding a wide variety of materials, including but not limited to: decorative laminates, metals (except copper), plywood, particleboard, foamed polystyrene (using dry spray technique), polyurethane foam and rigid plastics.

R 661 provides easy and uniform coverage in all types and sizes of operations. The canister offers simplicity and portability. It's high tack plus excellent contactability and green strength provides uniform high strength bonds under a wide variety of laminating conditions.

CHARACTERISTICS:

R 661 is a high temperature spray adhesive. It has excellent adhesion to a variety of substrates including, but not limited to laminates, particle board, plywood, hardwood, leather, rubber and metal. It has excellent green strength and high heat resistance with excellent room temperature contactability in a portable system.

PHYSICAL PROPERTIES:

Pattern:	Web
Color:	Clear
Flash Point:	-13°F
Dry Time:	Approximately 3-5 Minutes
Open Time:	30 Minutes
VOC:	393 grams/liter (EPA Method 24)
Shelf Life:	1 year in unopened container
Coverage Rate:	3.0 dry grams/sq. ft. minimum
Clean Up:	Lion Grip RS02020L, R009 or RCCAR

PACKAGING & COLOR:

R 661 30 C	Clear	30 lbs / 13.61 kg
R 661 30 R	Red	30 lbs / 13.61 kg
R 661 140 C	Clear	140 lbs / 63.50 kg
R 661 140 R	Red	140 lbs / 63.50 kg
R 661 300 C	Clear	300 lbs / 136.08 kg
R 661 300 R	Red	300 lbs / 136.08 kg

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 warranty 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 R661

High Temperature Adhesive Spray

APPLICATION:

1. Prepare the surface to be bonded. Ensure both faces are clean and free of dust, dirt and grease. If necessary, wipe clean with LIONGRIP RS02020L or Citrus Cleaner.
 2. Hold spray gun at a constant distance of between 6-10 inches (150-250mm) from the surface, allowing adhesive to cobweb across the surface with minimal overlap for thick laminates. For thin laminates allow for approximately 50% overlap of successive passes to prevent telegraphing.
 3. Maintain a constant hand speed during spraying. Apply a consistent and thorough coating without allowing the adhesive to puddle or heavily wet the surface. Maximum bond strength is achieved with substrate coverage between 80-100% with a recommended coat weight minimum of 3.0 dry grams per square foot.
 4. Maximum adhesion will be obtained by spraying opposing mating faces with an adhesive pattern at 90° angles to each other. (Example: Face one substrate vertically while spraying. Face the other substrate horizontally. Extra coverage is recommended at substrate edges.
 5. Hold spray gun at 90° angle to substrate surface while spraying. Release trigger at end of each pass to optimize coverage.
 6. 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.
 7. Make sure to coat all exposed edges and corners with two coats of adhesives.
 8. Allow adhesive to dry completely before attempting assembly. (Dry time may vary due to humidity and temperature variations.) Test for dryness using back of hand only – surface should be tacky, but adhesive should not transfer to the skin.
 9. Position substrates carefully and apply pressure. Work from the center of the substrate, out to prevent bubbles and wrinkles. Apply adequate pressure (40 PLI) using nip roller. Proper use of a 3" J-roller will also provide proper pressure.
 10. The bonded assembly is immediately able to be trimmed or routed. Full bond strength is achieved after 24-48 hours depending on temperature and humidity.
-

SPRAY INFORMATION:

Adjustable Spray Gun w/ 6501 tip and hose

HANDLING AND APPLICATION PRECAUTIONS:

Attach and securely tighten a hose, in your length of choice to the matching fitting provided on the gun. Attach the other end of the hose to the matching fitting on the canister. It is recommended that plumbers tape be used on the fittings to assure an air tight seal. Check the fittings again for tightness. Slowly open the valve on the top of the canister and check for leaks. Half way is recommended at first. When hose is connected, keep canister valve open and hose pressurized at all times. Do not disconnect the hose until ready connect to new canister. Release pressure in hose before disconnecting from canister. For optimum performance, store at 70°F (21°C) during use. Canister must be above 50°F (10°C). Do not use in applications with copper or aluminum components. This adhesive is not recommended for use with plasticized vinyl, flexible plastics, expanded/extruded polystyrene, polyethylene, or polypropylene. Use only in well ventilated areas. Do not use near ignition sources.

Do not pull containers around by the hose even if on a dolly as this can cause the hose to break or disconnect to the tank and cause injury to the operator.

ATTENTION: Empty container remains hazardous until all flammable vapors, which may explode upon ignition, are gone from residue and container. Observe all labeled hazard precautions. Do not cut, puncture, or weld while hazard exists. Do not reuse empty container. Recycle, or dispose of, according to all federal, state, and local regulations.

STORAGE:

Store between 55°F and 85°F for best performance. Do not expose to direct sunlight. Product should be stored indoors and not be stored in direct sunlight. **DO NOT FREEZE** – If frozen, return to room temperature. In cold weather, store in heated area off of floor.