



# LION GRIP

## Adhesive / Adhésif

# R 980NF

### FEATURES AND BENEFITS:

LIONGRIP R980NF is a non-flammable 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.

R980NF provides easy and uniform coverage in all types and sizes of operations. The canister offers simplicity and portability. Excellent heat resistance and bond strength provides uniform high strength bonds under a wide variety of laminating conditions.

### CHARACTERISTICS:

R980NF is a non-flammable spray adhesive. It has excellent heat resistance and bond strength to a variety of substrates including, but not limited to laminates, particle board, plywood, hardwood, leather, rubber and metal.

### PHYSICAL PROPERTIES:

Pattern:	Pebble
Color:	Clear / Red
Flash Point:	None
Dry Time:	Approximately 3-5 Minutes
Open Time:	60 Minutes
VOC:	0 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 980NF 28 C	Clear	28 lbs
R 980NF 28 R	Red	28 lbs
R 980NF 117 C	Clear	117 lbs
R 980NF 117 R	Red	117 lbs
R 980NF 235 C	Clear	235 lbs
R 980NF 235 R	Red	235 lbs

### 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 R980NF

Non-Flammable Adhesive Spray with compressed Air System

### CANISTER SET UP AND PRECAUTIONS:

1. 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. 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 to connect to new canister.
2. Release pressure in hose before disconnecting from canister.
3. Modify existing fluid line fitting to attach to the back of Devilbis or Binks Conventional spray gun. This fitting can be obtained by your spray equipment distribution. Attach atomizing air line with air regulator to your spray gun. Open fluid line at canister and adjust fluid and air pressure at gun to achieve spray fan patterns of 8 to 12 inches.
4. Typical atomization pressure of 50-65 psi.

### 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 R009
  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. 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.
  8. 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.
  9. 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.
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### HANDLING AND APPLICATION PRECAUTIONS:

Release pressure in hose before disconnecting from canister. 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 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.

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### 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.