



LION GRIP

Adhesive / Adhésif

555

FEATURES AND BENEFITS:

LIONGRIP R 555 offers a number of unique benefits. The high solids allow for higher line speeds and increased productivity. The adhesive on an applied basis cost less than most conventional solvent contact adhesives. It is postformable and provides for higher line speeds due to the high solids content. The adhesive will be very aggressive in its initial bond strength and will cure to a high heat resistant bond very quickly.

Ideal for bonding decorative laminates, plywood, rigid plastics, rigid urethane, particleboard, metal, wood, leather and most other materials.

CHARACTERISTICS:

R 555 has been specifically formulated for mass production bonding to a wide variety of materials. The high solids content of R 555 insures adequate coating weights at high line speeds, giving excellent long-term bond performance. The high solids content and fast drying solvent blend on R 555 enables high line speeds that increase productivity

PHYSICAL PROPERTIES:

Base:	Neoprene
Solid Content (approx.):	24% +/- 1%
Viscosity:	135 cps
Color:	Natural / Red
Flash Point:	-4°F
Dry Time:	3 – 5 Minutes
Open Time:	30 Minutes
VOC:	546 grams/liter (EPA Method 24)
Shelf Life:	1 year in unopened container
Recommended Coverage:	185 sq. ft./ gallon bonded surfaces
Clean Up:	Lion Grip Cleaner/Thinner RS02020L, R009 or RCCAR

PACKAGING & COLOR:

R 555 20 11L	Natural	5 gal / 19 liters
R 555 20 80L	Red	5 gal / 19 liters
R 555 54 11L	Natural	54 gal / 205 liters
R 555 54 80L	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 Safety Data Sheet for Proper Handling and Safety Information

REV 10/16

LIONGRIP R555

Postform High-Solids 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 application of adhesive.
 3. The adhesive should be applied at approximately 2.0-2.5 dry grams per square foot. 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. When bonding porous substrates, it is advisable to apply two coats of adhesive. The first coat will act as a sealer and prevent excessive absorption of the adhesive into the substrate. After the first coat has dried, apply a second coat. Allow the second coat to completely dry before assembly.
 5. Allowing contact adhesive to dry completely before assembly is essential to obtaining a secure, permanent bond. To check for adhesive dryness, press a piece of Kraft paper onto the adhesive surface. If there is transfer of adhesive to the paper, more time is required to let the adhesive dry. If there is no transfer, substrates are ready for bonding. A second method to check for dryness is to place the back of your hand into the adhesive and turn. If adhesive transfers to your hand, allow for more dry time.
 6. If areas exist with excessive adhesive deposition, allow more time for evaporation to ensure complete removal of 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 may vary by adhesive – see specification on page 1).
 9. Uniform pressure on the bonded laminates is necessary to create strong, lasting bonds. 40 pounds per linear inch is recommended to insure complete fusion between the two layers of adhesive to be bonded. A pinch roller is ideal for applying uniform pressure. When used properly, a J-roller can also provide adequate 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, 2001,2100	JGA510, MSA510	21,95A	AGX550
Fluid Tip	63B-SS	FX	63C-SS	FX
Fluid Needle	663A, 563A	FX	263A,663A	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.
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STORAGE:

- Rotate stock, use oldest first.
- Keep covered to prevent solvent loss and contamination.
- Store product between 60 – 80°F.
- Do not freeze. If frozen, return to room temperature prior to use.
- If frozen, slight agitation may be required after returning to room temperature.