LION GRIP
Adhesive / Adhésif
R 517NF

LIONGRIP R517NF

Non-Flammable High Performance Spray Adhesive

FEATURES AND BENEFITS:

LIONGRIP R 517NF is a high performance and fast drying contact adhesive. It makes a great choice for most permanent adhesive applications wood, plastic laminates, gypsum, metals (except copper) and many other products.

R 517NF bonds well to a wide variety of substrates. Use for decorative laminates, edgebanding wood, veneers, foam, headliners, fiberglass and plastic.

CHARACTERISTICS:

R 517NF has exceptional tack and shear strength, high heat and UV stability; fast drying, precise application control, and long open time. Adhesive and surfaces should be at least 60°F or higher for best results.

Qualifies for LEED®-NC & CI EQ Credit 4.4: laminating adhesives shall contain no added urea formaldehyde resins

PHYSICAL PROPERTIES:

Base:	Neoprene
Solvent:	Organic solvents
Solid Content (approx.):	11% +/- 1%
Viscosity:	225 cps
Color:	Natural
Flash Point:	None
Dry Time:	2 – 4 Minutes
Open Time:	30 Minutes
VOC:	239 grams/liter (EPA Method 24)
Shelf Life:	1 year in unopened container
Recommended Coverage:	100-125 sq. ft./ gallon bonded surfaces
Clean Up:	Lion Grip Cleaner/Thinner RS02020L, or RCCAR

PACKAGING & COLOR:

R 517NF 20 11L	Natural	5 gal / 19 liters
R 517NF 54 11L	Natural	54 gal / 205 liters

See Material Safety Data Sheet for Proper Handling and Safety Information

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APPLICATION:

1. Substrates should be clean and free of moisture, dirt, oil and other contaminates.
2. For best results, adhesive and substrates should be allowed to acclimate to room temperature (approximately 60°F or above) before adhesive application.
3. The adhesive should be applied at approximately 2.0- 2.5 grams/square foot. The adhesive should cover 80% of the substrate surface. The substrate surface should exhibit a uniform glossy sheen when the adhesive is completely dry. Dull areas indicate insufficient coverage. Adhesive should be reapplied 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 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, twist the fingers while pressing them onto the adhesive layer. This will break any skin that may have formed as the adhesive dries from the top surface down. If a skin has formed, 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.).
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.

SPRAY INFORMATION:

Product Specifications		
Typical Fluid Pressure	Atomization Pressure	Spray Pattern
10-20 psi	30-50 psi	Pebble

Spray Equipment				
Binks				
Manual	*Auto*	*Fluid Tip*	*Needle*	*Air Cap*
95, 2100	21, 95	63ASS	663A, 563A	66SD-3
Devilbiss				
Manual	*Auto*	*Fluid Tip & Needle*		*Air Cap*
JGA-510, MBC-510	AGX	FX, FF		24, 797
CA Technologies				
Gun			*Set Up*	
Panther Tomcat			1.5 x 2266-3T 1.5 x 2266-3	

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.
Do not freeze. Store product between 60 – 80°F
If frozen, return to room temperature prior to use.
If frozen, slight agitation may be required after returning to room temperature.