

ITW STA'-PUT

SURFACING ADHESIVE

ITW STA'-PUT® Surfacing Adhesive is a two-part Methacrylate adhesive designed for solid surface, engineered and natural stone seaming and assembly. **STA'-PUT® Surfacing Adhesive** is UV stable and non-yellowing. It offers excellent adhesion to a variety of surface sheet materials including cast acrylic, cast/densified polyester, engineered and natural stone. It exhibits high resistance to water, impact, wear, scuffing, boiling water, high temperature and UV light. Combined with **STA'-PUT® Surfacing Activator** at a 10:1 ratio, it has a working time of approximately 8-14 minutes at ambient temperature and achieves handling strength in approximately 18-25 minutes. The **Surfacing Adhesive** is available in a variety of colors and matched to most manufacturer sheet goods.

FEATURES

- ◆ UV Stable
- ◆ Minimal Surface Preparation
- ◆ Working Time: 8-14 minutes¹
- ◆ Fixture time: 18-25 minutes
- ◆ Excellent Wear Resistance
- ◆ High Strength
- ◆ Room Temperature Cure
- ◆ Industry Standard Packaging
- ◆ 100% Reactive
- ◆ GreenGuard Children & Schools Certified



Contributes to **LEED®** and other green building rating system credits:

- o **LEED Core & Shell EQ Credit 4**

PHYSICAL PROPERTIES (Uncured) – Room Temperature

| | Adhesive | Activator |
|-------------------------|-----------------|------------------|
| Viscosity, cp | 19,000 | 25,000 |
| Color | Various | Off-White |
| Density, lbs/gal (g/cc) | 8.90 (1.07) | 8.86 (1.08) |
| Mix Ratio by Volume | 10.1 | 1.0 |

Optimal Gap Size: Between 0.01 to 0.125 in (0.254 to 3.2 mm)

Recommended Mix Nozzle: MFX08-18 (250ml), MDX 5.4-16 (50ml)

SHELF LIFE: 18 months from Date of Manufacture²

MECHANICAL PROPERTIES (Cured) – Room Temperature

Butt Joint Tensile

Strength, psi 3,000 – 3,500

Flexural Strength (ASTM D790)

Strength, psi 5,200 – 5,600

Tensile Strength (ASTM D638)

Strength, psi 4,000 – 4,400

Hardness – Barcol (ASTM D2583)

Hardness 30 - 35

1 Working Time: The time elapsed between the moment Parts A and B of the adhesive system are combined and thoroughly mixed and the time when the adhesive is no longer useable. Times presented were tested at 75°F.

2. The shelf life of Surfacing adhesive and activator (Parts A and B) is 18 months from day of shipment from ITW TACC. Shelf life is based on continuous storage between 55°F and 75°F. Long-term exposure above 75°F will reduce the shelf life of these materials. Prolonged exposure of activators, including cartridges, which contain activators, above 100°F quickly diminishes the product's reactivity and should be avoided. Shelf life can be extended by refrigeration (45°F - 55°F). These products should never be frozen.

DIRECTIONS FOR USE

ITW STA'-PUT® Surfacing Adhesive (Parts A and B) is flammable. Contents include Methacrylate Ester. Keep containers closed after use. Wear gloves and safety glasses to avoid skin and eye contact. For best results, adhesive and materials to be bonded should be between 65°F and 80°F during application. Allow substrates to acclimate to room temperature for 48 hours before bonding. **STA'-PUT® Surfacing Adhesive** may be applied manually. To assure maximum bond strength, surfaces must be mated within the specified working time. Use sufficient material to ensure the joint is completely filled when parts are mated and clamped. All adhesive application, part positioning, and fixturing should occur before the working time of the mix has expired. After indicated working time, parts must remain undisturbed until the fixture time is reached. If the adhesive is already cured, careful scraping, or abrasion followed by a solvent wipe may be the most effective method of clean up.

Note: Because of the rapid curing features of this product, large amounts of heat are generated when large masses of material are mixed at one time. The heat generated by the exotherm resulting from the mixing of large masses of adhesive can result in the release of entrapped air, steam, and volatile gases. To prevent this, use only enough material as needed for use within the working time for the product and confine gap thickness to no more than .125 inch (3.2mm). Questions on handling and applications this should be directed to ITW TACC at 1-800-503-6991.

EFFECT OF TEMPERATURE

Application of adhesive at temperatures between 65°F and 80°F will ensure proper cure. Temperatures below 65°F will slow cure speed; above 80°F will increase cure speed. The viscosities of Parts A and B of this adhesive are affected by temperature.

**KEEP OUT OF REACH OF CHILDREN
FOR PROFESSIONAL OR INDUSTRIAL USE ONLY
USE ONLY WITH APPROVED EQUIPMENT**

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