



## PROPERTIES

**COLOR:**

Gray

**APPLICATION CONSISTENCY:**

Air atomized spray, brush, roller, or duct liner machine

**AVERAGE WEIGHT/U.S. GALLON (ASTM D 1875):**

8.8 lbs. (1.05 kg/l)

**AVERAGE NON-VOLATILE (ASTM D 1644):**

51% by volume (52% by weight)

**COVERAGE (FSTM 72):**

(Subject to type of surface and material being bonded)

**Spray:** Approx. 300-500 sq. ft./gal. (7.4 - 12.3 m<sup>2</sup>/l)

**Brush/Roller:** 150-300 sq. ft./gal. (3.7 - 7.4 m<sup>2</sup>/l)

**BONDING TIME RANGE (FSTM 66):**

0 to 10 minutes (depending on temperature and humidity)

**SERVICE TEMPERATURE LIMITS (FSTM 70):**

(Temperature at coated surface)

Minus 20°F to 200°F (-29°C to 93°C)

**WET FLAMMABILITY (ASTM D 3728):**

Flash Point: No flash to boiling, over 200°F (93°C)

**SURFACE BURNING CHARACTERISTICS  
(ASTM E 84):**

Flame Spread: 0

Smoke Developed: 0

Tested at coverage rate of 300 sq. ft. per gal. (7.4 m<sup>2</sup>/l)

Applied to 1/4 inch (6.4 mm) inorganic reinforced cement board. The flame spread may vary at different product thickness.

<sup>™</sup> Trademark of H.B. Fuller Construction Products Inc.

## FOSTER<sup>®</sup> STIC-FAS<sup>™</sup> ADHESIVE

**Foster<sup>®</sup> Stic-Fas<sup>™</sup> Adhesive** is a low odor rapid setting resin/polymer emulsion adhesive for adhering low density fibrous glass insulation, duct wrap and acoustical linings (up to 3 lbs/c.f.) in air handling systems. It has good wet grab, and can be applied to painted or unpainted steel, galvanized steel or aluminum surfaces.

**Stic-Fas Adhesive** is formulated for use in duct liner machines, both air atomized spray and roll coater types. It has excellent hot peel strength and high humidity resistance. Once dry and cured, it has outstanding water resistance.

**Stic-Fas Adhesive** is water based and non-flammable in the wet state. It meets the requirements of ASTM C916-85, Type II (ASC-A-7001, Type II)

**Stic-Fas Adhesive** meets NFPA-90A & 90B 25/50 requirements.

**Stic-Fas Adhesive** meets requirements for LEED IEQ 4.1 Low-Emitting Materials, Adhesives and Sealants. VOC: 2 g/l, less water and exempt solvents.

**Stic-Fas Adhesive** contains no asbestos, lead, mercury, or mercury compounds.

**LIMITATIONS**

Store and apply between 40°F (4°C) and 100°F (38°C), protect from freezing until dry.

Always test plastic foam insulation for warpage when using a water base adhesive.

Not suggested for sealing vapor barrier jackets.

Overhead applications may require mechanical fasteners.

Visit us on the web at [www.fosterproducts.com](http://www.fosterproducts.com)

**H.B. Fuller Construction Products Inc.**

1105 South Frontenac Street • Aurora, IL 60504 • 800-832-9002 • fax 800-952-2368

# APPLICATION GUIDE FOR FOSTER® STIC-FAS™ ADHESIVE 85-65™

## MATERIAL PREPARATION

Stir well. DO NOT THIN. Apply only to clean, dry, oil-free surfaces. Keep container closed when not in use.

## APPLICATION

### SPRAY - AIR ATOMIZED

Apply the Stic-Fas Adhesive to the metal surface uniformly at 300-500 sq. ft./gal. (7.4 - 12.3 m<sup>2</sup>/l). While still wet, press the insulation into place, making sure that complete contact is made with applied adhesive.

Average viscosity range 1000-2000 cps. Before using for the first time, existing spray systems must be completely cleaned and free of the old adhesive and solvents. Corrosion resistant pumps and fittings are suggested.

The following equipment combinations are suggested:

	MODEL SPRAYGUN	FLUID NOZZLE	AIR CAP	FLUID PRESSURE	ATOMIZATION PRESSURE
Binks	2001 SS	68	68PB	25-30 psi	60-70 psi
DeVilbiss	JGA-510	E	777	25 psi	60-70 psi

Not recommended for airless spray application.

### BRUSH/ROLLER

Use clean equipment suitable for water base paints.

### CLEAN-UP

To clean up, use warm soapy water if still wet. When dry, use xylene (flammable) or chlorinated solvent (non-flammable).

## DATA REPRODUCED FROM ASTM E-84 FIRE TEST (TUNNEL TEST)

### STICK-FAS™ ADHESIVE H.B. Fuller Company

	Surface Burning Characteristics 1/4 inch (6.4 mm) Inorganic Reinforced Cement Board
Surface Flame Spread	0
Smoke Developed	0
Number of Coats	1
Rate Per Coat (sq. ft. per gal.)	300

## CUSTOMER SERVICE: 800-231-9541

IMPORTANT: H.B. Fuller Construction Products Inc., warrants that each of its products will be manufactured in accordance with the specifications in effect on the date of manufacture. WE MAKE NO OTHER WARRANTIES AND EXPRESSLY DISCLAIM ANY WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. If a product fails to meet this limited warranty, purchaser's sole and exclusive remedy is replacement of the product or, at our option, refund of the purchase price. OUR ACCEPTANCE OF ANY ORDERS FOR THE PRODUCT IS EXPRESSLY CONDITIONAL UPON PURCHASER'S ASSENT TO THE TERMS ON THE APPLICABLE INVOICE.

ADEQUATE TESTS: The information contained herein we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be performed by you to determine if this product meets all of your requirements. The warranted shelf life of our products is six months from date of shipment to the original purchaser.

**For professional use only. Keep out of reach of children.  
Consult Material Safety Data Sheet and container label for further information.**