



PROPERTIES

COLOR:

White
Black

APPLICATION CONSISTENCY:

Air atomized spray, brush, roll or drip coil line

AVERAGE WEIGHT / U.S. GALLON (ASTM D1475):

9.3 lbs. (1.1 kg/l)

AVERAGE NON-VOLATILE (ASTM D2369):

41% by weight

COVERAGE:

Subject to type of surface and material being bonded.

Spray: approx. 300 – 500 sq. ft./gal. (7.4 – 12.3 m²/l)

Brush/Roller: 150 – 300 sq. ft./gal. (3.7 – 7.4 m²/l)

BONDING TIME RANGE:

Dependent on temperature and humidity.
0 – 10 minutes

WET FLAMMABILITY:

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

SURFACE BURNING CHARACTERISTICS (ASTM E84):

Flame Spread: 0

Smoke Developed: 0

Tested at coverage rate of 400 sq. ft. per gal. (7.4 m²/l).
Applied to 1/4 inch (6.4 mm) inorganic reinforced cement board. The flame spread may vary at different product thicknesses and/or when applied over other surfaces.

DUCT LINER ADHESIVE

Foster® 85-10 Adhesive is a rapid-setting, synthetic polymer 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 adhesion and can be applied to painted or unpainted steel, galvanized steel or aluminum surfaces.

85-10 Adhesive is formulated for use on coil lines with drip or spray heads and roll coating machines. Also may be applied with conventional air assist spray guns or by brush or roller for HVAC duct fabrication uses. Once dry and cured, it is heat, water and humidity resistant.

85-10 Adhesive is water-based and non-flammable in the wet state. It meets the requirements of ASTM C916, Type II.

85-10 Adhesive meets NFPA 90A & 90B 25/50 requirements.

85-10 Adhesive meets the requirements of:

- MAS Certified Green®
- California Dept. of Public Health Standard Method v1.2
- VOC Emissions and Content requirements to contribute to **LEED v4** EQ Credit: Low Emitting Materials – Paints and Coatings
- Collaborative for High Performance Schools EQ 7.1

VOC Content: <80 g/l, less water and exempt solvents.



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-based adhesive.

Not suggested for sealing vapor barrier jackets.

Overhead applications may require mechanical fasteners.

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APPLICATION GUIDE FOR FOSTER® 85-10 ADHESIVE

MATERIAL PREPARATION

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

APPLICATION

Spray:

Apply the Foster® 85-10 adhesive to the metal surface uniformly at 300 – 500 sq. ft./gal. (7.4 – 12.3 m²/l). While still wet, press the insulation into place, making sure that complete contact is made with applied adhesive. Immediately embed weld pins. As a water based adhesive 85-10 will not flash due to weld pint installation even while wet.

Average viscosity: 5,000 cps. Before using for the first time, existing spray systems must be completely cleaned and free of the old adhesive and solvents. Flush system thoroughly with water before use. Keep spray heads clean and tips damp to prevent drying between use.

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

Brush/Roller:

Use clean equipment suitable for water-based 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)

ADHESIVES

H.B. Fuller Company SURFACE BURNING CHARACTERISTICS

Applied to 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.): 400

CUSTOMER SERVICE: 833-849-3700

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 twelve months from date of shipment to the original purchaser or as otherwise provided on the certificate of analysis.

For professional use only. Keep out of reach of children.

Consult Safety Data Sheet and container label for further information.