85-40

Product Data Sheet

PROPERTIES

COLOR:
Clear

APPLICATION CONSISTENCY:
Web spray, spray canister applied

AVERAGE WEIGHT / U.S. GALLON (ASTM D1475):
6.16 lbs./gal (0.74 kg/l) concentrate

AVERAGE NON-VOLATILE (ASTM D2369):
21.7% by weight

COVERAGE RANGE:
Subject to type of service and nature of material being bonded.
1,075 ft^2/canister (100 m^2/canister)

Dry coat weight: 0.5 lb/100 ft^2 (25 g/m^2)

BONDING TIME:
0 to 60 minutes

APPLICATION TEMPERATURE RANGE:
50°F to 100°F (10°C to 38°C)

60°F to 80°F (15°C to 27°C) for best results

SERVICE TEMPERATURE LIMITS:
Temperature at coated surface.
-20°F to 160°F (-4°C to 71°C)

WET FLAMMABILITY:
Flash point: -40°F (-40°C)

FOSTER® FOS-STIK™ ADHESIVE

FOSTER® FOS-STIK™ ADHESIVE is a flammable, rapid tacking, low soak-in, canister spray adhesive used to adhere a wide variety of insulation materials including polystyrene to metal or other construction surfaces where immediate adhesion and high initial adhesive strength are required. It can be used either as a one-way wet or a two-way contact cement.

FOS-STIK™ ADHESIVE is waterproof, flexible, transparent, and non-staining. It contains no chlorinated solvents or ozone depleters. It cleans up easily with mineral spirits.

FOS-STIK™ ADHESIVE is ideal for bonding kraft-backed and foil jacketing to urethane and phenolic foam insulation, as well as for adhering polystyrene to itself and to metal surfaces. It also provides strong adhesion for elastomeric foam insulation applied to metal. For non-porous substrates, it should be applied as a two-way contact adhesive to prevent moisture entrapment.

Hoses and spray guns available and sold separately.

FOS-STIK™ ADHESIVE meets the standard for web spray aerosol adhesive when the requirement is less than 75% VOC.

VOC Content: 376 g/L less exempt solvents (<71% by weight)

LIMITATIONS
Store between 60°F (15°C) and 95°F (35°C).

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APPLICATION GUIDE
FOR
FOSTER® FOS-STIK™ ADHESIVE
85-40

MATERIAL PREPARATION
Shake canister for 30 seconds prior to use. Apply only to clean, dry surfaces that are free from dust, dirt, and oil.

APPLICATION
Use in a well-ventilated area.

Connect spray applicator to hose and connect hose to adhesive canister. Once the hose and spray applicator have been attached, open the valve fully and check connection points for leaks.

FOS-STIK™ Sprayable Adhesive should be applied at ambient temperatures of 50°F (10°C) to 100°F (38°C). For optimum performance, use between 60°F (15°C) and 80°F (27°C). Do not place the canister on a cold concrete floor. Low temperature can result in irreparable separation of the adhesive. If the product sprays like a jet, the canister is too cold. Use a warming blanket or hot box when necessary to warm the adhesive.

On the first use, the canister may initially take a few seconds to spray correctly. Spray initially onto a scrap surface to ensure the spray pattern is correct for the application. Adjust the spray pattern/fan to the desired width by slowly adjusting the trigger lock; lock the trigger when not in use.

Hold the spray applicator 4-6 inches perpendicular to the substrate and apply a uniform coat of adhesive. Apply adhesive in overlapping bands of approximately 50%, with a double coat applied to the edges. Move at a steady pace that provides an even coat of adhesive without allowing the material to puddle. For most applications, 80-100% adhesive coverage is required for full bond strength. On porous materials, a second coat of adhesive may be necessary.

When applying non-porous insulation to metal or itself, allow the solvents to evaporate from the adhesive before bonding. The adhesive is ready to bond when it does not transfer to a gloved finger when touched. Bonding the substrates before the solvents have been allowed to evaporate can cause solvent entrapment resulting in bond failures.

Carefully position the two substrates. Once brought together an aggressive bond will form. Apply a uniform pressure over the work piece, starting in the middle and working outwards.

SAFETY
DANGER! EXTREMELY FLAMMABLE LIQUID AND VAPOR MAY CAUSE FLASH FIRE. Use with adequate ventilation. Consult canister label and safety data sheet for product hazards and precautions in use.

SPRAY APPLICATOR AND HOSE CLEANING INSTRUCTIONS
SHORT TERM STORAGE:
To clean up dried adhesive, use mineral spirits (flammable) or chlorinated solvents (non-flammable). To clean spray equipment, use an aerosol solvent-based cleaner.

Leave the valve on the adhesive canister open and lock applicator so trigger cannot be engaged. Make sure to clean spray tip in a well-ventilated area using appropriate PPE. Remove spray tip by removing retaining nut. Clean spray tip and retaining nut by soaking in mineral spirits. Spray tip may require manual cleaning with appropriately sized probe (small wire or pipe cleaner) to help remove build up. Clean applicator tip and threads with mineral spirits.

LONG TERM STORAGE:
Make sure to clean applicator/hose assembly in a well-ventilated area using appropriate PPE. Close valve on canister and engage trigger to completely relieve pressure on applicator/hose. Disconnect the hose from the canister outlet. Remove spray tip by removing retaining nut. Clean spray tip and retaining nut by soaking in mineral spirits following instructions detailed in “Short Term Storage”.

Connect hose to outlet of flush solution container; tighten with a wrench using caution not to cross-thread connection. Open canister valve full on flush cylinder and squeeze handle of spray applicator to allow flow of flush solvent through hose. Flush an adequate amount of solvent through the hose into an appropriate collection container. Once flushed, close the flush canister valve, and engage trigger to relieve pressure on applicator/hose. Make sure to collect all flush solution into an appropriate container. Disconnect the hose from the canister outlet and drain any residual flush solvent into an appropriate collection container. Clean applicator tip and threads with mineral spirits.

CUSTOMER SERVICE: 833-849-3700

IMPORTANT: HB 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 MERCHANTIBILITY 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.