



Garden Street, Ramsbottom

**Formulated**  
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## FP 1250 TWO PART SPRAYABLE CONTACT ADHESIVE

FP 1250 is a two-part water based contact adhesive designed to replace solvent based adhesives in spray applications. FP 1250 is used with FP 1166 activator at a ratio of approximately ten to one. Developed for fabrication of parts comprising polyurethane and latex foam, fabrics, paper and other porous substrates for the furniture, bedding, footwear and automotive industries.

### APPLICATION

Apply the adhesive to both substrate surfaces equally. Adequate compression is necessary for destructive final bonds. After application allow parts to dry fully (ideally overnight) to ensure maximum bond strength. Spray only in ventilated areas designed to control overspray. Unlike solvent based adhesive, water based adhesive over-spray will stay airborne longer and could foul nearby equipment, if not controlled.

The finest coating of adhesive that achieves the required bond strength should be applied. Heavy adhesive coatings will give a harder bond line. When bonding fibres to cushions care must be taken not to apply too much adhesive as this will cause a hardening of the fibres. Some users have designed the cushion overwrap of fibre so that there is no fibre bonding on the cushion edge.

### ADHESIVE TO ACTIVATOR RATIO

It is important that the ratio of FP 1250 adhesive to FP 1166 activator is kept as close to the ten parts adhesive to one part of activator. If the ratio of adhesive to activator is higher this will cause the mixture to be alkaline. If the ratio of activator is higher this will cause the mixture to be acidic. Both Alkalis and Acids can affect certain fabrics, especially those containing metallic threads that may be used to cover the bonded items.

It is important that ratios are be monitored on a regular basis and records of kept of the results.

### RATIO MEASUREMENT AND CONTROL

Ratios should be checked by flowing the adhesive and activator into two separate 100ml measuring cylinders. The air supply to the gun must be turned off and pressure released from the gun by triggering. Allow 50 ml of adhesive to flow into one tube. Now check the level of activator in the other tube. If it is below 5 then you will need to increase the activator flow rate by turning the knob on flow meter up and retest till correct. If more than 5 ml you will need to decrease flow by turning the flow meter down.



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#### **FP 1250 PROPERTIES**

Total Solids Content, %	50.0 - 54.0
Viscosity, cps	<100
pH	12.0 - 14.0

#### **FP 1166 PROPERTIES**

Total Solids Content, %	13.0 - 17.0
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#### **STORAGE AND HANDLING**

FP 1250 should be stored in sealed containers in order to prevent skinning and contamination. When in use a small amount of air ingress must be allowed to prevent a vacuum forming. Store between 5 and 30<sup>o</sup> C. Protect from frost. Do not store containers in direct sunlight.

**The above information is given in good faith but without liability**

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