



Hydra FAST-EN™ DC-13279 can be used to bond many

DC13279 1- Part Sprayable, Water-Based General Purpose PSA ISO 9001:2000

DESCRIPTION

Hydra FAST-EN™ DC-13279 is a general purpose one part sprayable pressure sensitive adhesive designed to bond a variety of porous and non-porous surfaces. Product is low-cost, stable, solventless, user-friendly and, upon drying, provides high tack mating surfaces for tight initial bonds. In some cases the adhesive can be used in a one surface application. Any applications where the use of solvent based, flammable and non-flammable systems are a concern for either health or environmental reasons may also be suitable candidates for the use of this product.

PRODUCT FEATURES

- **Water-based** -- Low toxicity, easy clean up
- **High solids** -- 54%
- **One-part** -- Easy to use, no activator required
- **High tack** -- Aggressive, tight grab in dried state
- **Color tint available** -- Aids in noting coverage and uniformity: standard color is white
- **Equipment friendly** -- Uses standard one-part spray guns
- **Shear stability** -- Adhesive is not affected by normal shear forces generated by mechanical pumps or mixers
- **Temperature range** -- The dried adhesive has a use range of -30 to 150 °F
- **Shelf life** -- 6 months when stored between 40°F and 80°F in unopened containers

TYPICAL PROPERTIES

(specification values available upon request)

Base	SBR
Color	White when wet (unless tinted)
Solvent	Water
Solids	54%
Viscosity	750 cps (#2 @ 10 rpm)
Weight/Gallon	8.39 lbs.
Specific Gravity	1.01
pH	9.0 – 10.0
VOC	None

BONDING CAPABILITIES

different substrates together including cardboard, Kraft paper products, various foams, soft woods, some plastics and insulation materials. Depending upon substrates **DC-13279** can be applied to both mating surfaces or as a one side application. For porous materials adhesive can be wet or dry mated. For non-porous materials adhesive needs to be fully dried before pressure mating. Dry times depend upon the substrates bonded and ambient conditions. Higher temperatures, low humidity and good air circulation will accelerate bond development. Forced and heated air can be used. Bonded assemblies can be handled immediately after mating. Maximum bond strength is developed over 24 hours. Initial tack is aggressive and is retained over time.

COVERAGE

Hydra FAST-EN™ DC-13279 can be color tinted to assist the operator of the correct amount to be applied. The color tint also aids the operator in determining if even coverage is being achieved. Custom colors are available at no extra charge. The coverage rate needed to achieve the desired level of adhesion will need to be established for each particular substrate and end product requirement. This rate will depend on the substrate's surface texture and bonding properties and must be determined empirically.

EQUIPMENT CONSIDERATIONS

Hydra FAST-EN™ DC-13279 is compatible with many conventional and HVLP one-part spray gun systems. Laydowns and spray patterns are adjusted by fluid nozzle and needle selections and air pressure settings to achieve the effect desired. The air supply used must be consistent (no wide fluctuation in line pressures) and be oil free to achieve the best results.

Contact your Royal Adhesives sales representative for spray gun and total system set up recommendations.

EASY CLEAN-UP

Clean up is easily accomplished using commercially available liquid detergent (e.g. Pine-Sol) in a water solution. Tap water alone is not recommended for clean up.

PRECAUTIONARY DATA

Royal Adhesives & Sealants, LLC • 2001 W. Washington Street, South Bend, IN 46628 • Phone: 800-999-GLUE • Fax: 574-246-5425

This product is warranted to the original purchaser to meet published specifications, if any, and, in the absence of published specifications, to be merchantable quality. Such warranty may not be assigned or otherwise transferred by purchaser. No other warranty, expressed or implied, of fitness for a particular purpose or any other thing is made. Purchaser's exclusive remedy for breach of this warranty shall be a refund of the price paid for the products by the purchaser. Except as stated above, Royal Adhesives & Sealants, LLC, shall not be liable for any defect in, or breach of obligation relating to the defects in these products, regardless of the theory that may be asserted, including, without limitation, negligence, contract, absolute liability in tort or misrepresentation. If the purchaser does not accept goods on these terms, they are to be returned at once, unopened.

- This product is nonflammable when wet
- For professional or industrial use only
- Use with adequate ventilation
- Read the container label and the Material Safety Data Sheet carefully before use
- Keep away from children
Keep container closed when not in use
- Keep from freezing

DISPOSAL INFORMATION

Do not reuse container or remove label. Safely dispose of container and contents in accordance with applicable Federal, State and Local regulations.

8/05

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