

STA'-PUT®

SURFACING ADHESIVE

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION:

ITW STA'-PUT® Surfacing Adhesive is a two-part Methacrylate adhesive designed solid surface, engineered and natural stone seaming and assembly. STA'-PUT® Surfacing Adhesive is UV stable and non-yellowing. It offers excellent adhesion to a variety of surface sheet materials including cast acrylic, cast/densified polyester, engineered and natural stone. It exhibits high resistance to water, impact, wear, scuffing, boiling water, high temperature and UV light. Combined with STA'-PUT® Surfacing Activator at a 10:1 ratio, it has a working time of approximately 8-14 minutes at ambient temperature and achieves handling strength in approximately 18-25 minutes. The Surfacing Adhesive is available in a variety of colors and matched to most manufacturer sheet goods.

ADVANTAGE:

- Bonds in Wet Environments
- UV Stable
- High Strength
- Room Temperature Cure
- 100% Reactive
- Excellent Wear Resistance
- Industry Standard Packaging

SUSTAINABLE GUIDE:

- GREENGUARD® Children & Schools Certified
- GREENGUARD® Indoor Air Quality Certified
- Contributes to LEED® and other green building rating system credits:
 - LEED Core & Shell EQ Credit 4

DIRECTIONS FOR USE:

- ITW STA'-PUT® Surfacing Adhesive (Parts A and B) is flammable. Contents include Methacrylate Ester.
- Keep container closed after use. Wear gloves and safety glasses to avoid skin and eye contact.
- For best results, adhesive and material to be bonded should be at 65°F (18.3°C) to 80°F (26.7°C).
- Allow substrates to acclimate to room temperature for 48 hours before bonding.
- ITW STA'-PUT® Surfacing Adhesive may be applied manually.
- To assure maximum bond strength, surfaces must be mated within the specified working time.
- Use sufficient material to ensure the joint is completely filled when parts are mated and clamped.

- All adhesive application, part positioning, and fixturing should occur before the working time of the mix has expired.
- After indicated working time, parts must remain undisturbed until the fixture time is reached.
- If the adhesive is already cured, careful scraping, or abrasion followed by a solvent wipe may be the most effective method of clean up.

TYPICAL PROPERTIES:

Property	Typical Value
Base:	Methyl Methacrylate
Shelf Life:	18 months from Date of Manufacture**
Colors:	Various
Weight/ Gallon	8.9 lbs/ gal (adhesive)/ 8.86 lbs/gal (activator)
Mix Ratio	10:1 by volume
Viscosity	19,000 (adhesive)/ 25,000 (activator)
Working Time*	8 - 14 minutes
Fixture Time	18 - 25 minutes
Optimal Gap Size	0.01 – 0.125 in (0.254 – 3.2 mm)
Butt Joint Tensile Strength	3,000 – 3,500 psi
Flexural Strength (ASTM D790)	5,200 – 5,600 psi
Tensile Strength (ASTM D638)	4,000 – 4,400 psi
Hardness – Barcol (ASTM D2583)	30 - 35
Formaldehyde	No urea formaldehyde added during adhesive manufacturing
<p>* Working Time: The time elapsed between the moment Parts A and B of the adhesive system are combined and thoroughly mixed and the time when the adhesive is no longer useable. Times presented were tested at 75°F (35°C). ** The shelf life for an unopened container of this adhesive stored at temperatures between 55°F (15.6°C) and 75°F (35°C) is 18 months from date of manufacture. Long-term exposure above 75°F (35°C) will reduce the shelf life of these materials. Prolonged exposure above 100°F (37.8°C) quickly diminishes the products reactivity and should be avoided. Shelf life can be extended by refrigeration (45°F (7.2°C) – 55°F (12.8°C)). These products should never be frozen.</p>	

ATTENTION:

- Because of the rapid curing features of this product, large amounts of heat are generated when large masses of material are mixed at one time. The heat generated by the exotherm resulting from the mixing of large masses of adhesive can result in the release of entrapped air, steam, and volatile gases.
- To prevent this, use only enough material as needed for use within the working time for the product and confine gap thickness to no more than .125 inch.
- Recommended Mix Nozzle: MFX08-18 (250MI)

EFFECT OF TEMPERATURE

- Application of adhesive at temperatures below 65°F (18.3°C) will slow cure speed: above 80°F (26.7°C) will increase cure speed. The viscosities of Parts A and B of this adhesive are affected by temperature.

**KEEP OUT OF REACH OF CHILDREN
FOR PROFESSIONAL OR INDUSTRIAL USE ONLY
USE ONLY WITH APPROVED EQUIPMENT**

NOTICE TO PURCHASER:

NO WARRANTIES, EXPRESS OR IMPLIED, ARE MADE INCLUDING MERCHANTABILITY AND/OR FITNESS FOR A PARTICULAR PURPOSE. EXCEPT FOR PERSONAL INJURY RESULTING FROM USE OF THE PRODUCT AS DIRECTED, ITW POLYMERS SEALANTS NORTH AMERICA, INC. SHALL NOT BE LIABLE IN TORT OR CONTRACT FOR ANY LOSS OR DAMAGE. UNDER NO CIRCUMSTANCES SHALL ITW POLYMERS SEALANTS NORTH AMERICA, INC., A DIVISION OF ILLINOIS TOOL WORKS INC., OR ITS AFFILIATES ("ITW POLYMERS SEALANTS NORTH AMERICA, INC.") BE LIABLE FOR ANY LOSS OR DAMAGE ARISING FROM THE PURCHASE, USE, OR INABILITY TO USE THIS PRODUCT, OR FOR ANY SPECIAL, INDIRECT, INCIDENTAL, OR CONSEQUENTIAL DAMAGES. THE USER MAY SEND A SAMPLE OF PRODUCT TO ITW POLYMERS SEALANTS NORTH AMERICA, INC. FOR TESTING. IF SUCH TESTING PROVES A PRODUCT DEFECTIVE, THE USER'S SOLE AND EXCLUSIVE REMEDY IS EITHER REIMBURSEMENT OF THE PURCHASE PRICE OF THE PRODUCT OR REPLACEMENT OF THE CONTAINER OF PRODUCT. NO FABRICATOR, INSTALLER, DEALER, AGENT OR EMPLOYEE OF ITW POLYMERS SEALANTS NORTH AMERICA, INC. HAS THE AUTHORITY TO MODIFY THE OBLIGATIONS OR LIMITATIONS OF THIS.

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Complete technical information is available from
ITW Polymers Sealants North America, Inc.