

### TECHNICAL DATA SHEET

#### PRODUCT DESCRIPTION:

ITW STA'-PUT® Z100 is a solvent-free post-formable contact adhesive with high strength that combines high performance with regulatory compliance. Exceptional heat resistance and aggressive strength make **Z100** ideal for postforming operations. **Z100** has been specially formulated for those operations looking to reduce the cost and time of drying current, conventional water-borne adhesives. **Z100** combines zero flammability, zero VOC, zero Methylene Chloride and zero HAP's with high bond strength and post-formable heat resistance.

#### ADVANTAGE:

- No Solvents
- Quick Drying
- High Heat Resistance
- Non-Flammable
- High Yield
- Long Open Time
- Excellent Adhesion
- Post-formable

#### REGULATORY COMPLIANCE

- SCAQMD, Rule 1168
- California Air District Regulations
- Ozone Transport Commission (OTC) Rule for Adhesives and Sealants

#### TYPICAL PROPERTIES:

Property	Typical Value
Base:	Polychloroprene
Solvent:	Latex Emulsion
Shelf Life:	1 year from Date of Manufacture*
Colors:	Clear/ Green
Flash Point:	N/A
Solids	54.5% ± 2.0%
Weight / Gallon	9.13 lbs/ gallon
VOC Content	0 g/L (EPA Method 24)
Viscosity	200 – 1,000cps
Open Time	> 60 minutes
Dry Time	5 - 30 minutes
Coverage	900 ft <sup>2</sup> / gallon @ 2.5 dry grams/ ft <sup>2</sup>
Freeze/ Thaw	DO NOT FREEZE
Formaldehyde	No urea formaldehyde added during adhesive manufacturing

\* The shelf life for an unopened container of this adhesive stored at temperatures between 60°F (15.6°C) and 95°F (35°C) is 1 year from date of manufacture. Store out of direct sunlight in a cool, well-ventilated area. Avoid storing container directly on the floor or against an outside wall

#### APPROVED EQUIPMENT:

	Automatic	Manual
	<b>BINKS</b>	<b>BINKS</b>
Spray gun	Mach 1A HVLP	Mach 1 HVLP
Fluid Tip	94	94
Fluid Needle	47 – 478	54-3941
Air Cap	94P	94P
Fluid Pressure	10 – 30 psi	
Atomization Pressure	10 – 30 psi	
	Manual	
	<b>US LEGENDS System 500</b>	<b>US LEGENDS System 5000</b>
Spray gun	95 Tornado	95 Tornado
System	500 – 5-gallon pressure pot	5000 – 55 gallon drum pressure system
Fluid Pressure	5 – 15 psi	2 – 8 psi
Atomization Pressure	20 – 40 psi	20 – 40 psi
	<b>C.A. TECHNOLOGIES</b>	
Spray gun	Panther P100G 1.8 x 1590	
System	Pressure pot & hoses with non-corrosive fluid paths	
Fluid Pressure	5 – 15 psi	
Atomization Pressure	20 – 40 psi	

#### DIRECTIONS FOR USE:

- Use only after careful consideration of the warnings, directions, and first aid instructions given. Do not thin.
- Surfaces to be bonded should be clean, dry and free of any dust, loose paint, wax, moisture, dirt, grease, oil, rust, or other contaminants.
- Stir thoroughly before using.
- For best results, adhesive and materials to be bonded should be 60°F (15.6°C) to 95°F (35°C) during application.
- Allow substrates to acclimate to room temperature for 48 hours before bonding.
- DO NOT FREEZE.
- Apply adhesive uniformly to both surfaces and cover each surface a minimum of 80%. Some porous surfaces may require two coats. 100% coverage is recommended for the edges. Apply adhesive using a brush, paint roller, or stainless steel spray equipment.
- Spray equipment must have stainless steel fittings, passages, fluid nozzles and needles. Hoses must be nylon lined or plastic.
- Adhesive should be wet when applied and not immediately dry to the touch.
- Apply 2.0 to 2.5 dry grams of adhesive per square foot on both surfaces to be bonded. Be sure to have complete coverage of the surfaces.

- If brush or paint roller applied, or substrates are porous, apply two coats of adhesive to avoid soaking in.
- Allow the first coat of adhesive to dry completely before applying the second coat. Do not apply in direct sunlight.
- Both surfaces must be allowed to dry before bonding. This will usually take from 5 to 30 minutes at room temperature under normal conditions. Heat and humidity, or cold weather can effect drying times. Preheating substrates and the use of ovens, fans or lamps will result in shorter drying times. Surfaces are dry if adhesive is tacky, but no adhesive transfers to the hand when touched.
- Daily pretesting is recommended prior to use.
- The adhesive is dry when a translucent, glossy coat is obtained. Cloudy or opaque areas indicate incomplete drying. Dull areas indicate insufficient adhesive.
- Complete the bond within 1 hour (under normal conditions) after the adhesive is dry. If the two surfaces don't grab immediately when brought into contact, they have dried too long.
- Position coated surfaces carefully before putting them together since no shifting is possible once contact is made.
- Bring surfaces together and immediately apply firm pressure over entire surface working from the center to the edges. Apply uniform pressure over 100% of the area being bonded. A pinch roller or rotary press is ideal, using as much pressure as possible without crushing the substrates. The minimum recommended pressure would be a 3-inch rubber "J" at 95°F.
- Let bonded parts cure for at least 72 hours before exposing to direct sunlight of temperatures over 150° F (65.6°C).
- Replace the lid after each use and secure tightly for storage.
- Do not use on some vinyls or polystyrene foam. Some vinyls contain plasticizers, which can, over time, soften and dissolve the bond, or bleed through/dicolor. When in doubt, or if product is to be used on vinyls, or other light colored materials, conduct compatibility testing on the product to be bonded before use.
- CLEAN UP: Use warm, soapy water to clean wet adhesive from spray equipment, brushes or rollers. Use an ITW Polymers Sealants brand biodegradable citrus solvent to remove dried adhesive.

**ATTENTION:**

- Empty container remains hazardous until all flammable vapors, which may explode upon ignition, are gone from residue and container. Observe all labeled hazard precautions. Do not cut, puncture, or weld while hazard exists.
- Do not reuse empty container. Recycle, or dispose of, according to all federal, state, and local regulations. Follow solvent manufacture's recommendations and instructions for safe handling.

**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.

**WARRANTY:**

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