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Hauthaway XS-4115

DESCRIPTION: XS-4115 is a solvent based contact for bonding various automotive and furniture trim.

SUGGESTED USES: XS-4115 can be used to bond fabrics and many vinyl coated fabrics (fabric backing only) to wood, metal, fiberglass, most rubbers, and plastics. This adhesive can also be used to bond carpeting, textiles, cork, felts, and leather. It is not recommended for bonding to vinyl, vinyl films, or plastisols.

CHARACTERISTICS:

- ▶ Polychloroprene-based
- ▶ Available colors - yellow, black, or neutral
- ▶ Vapors and liquid are extremely flammable

APPLICATION: Surfaces to be bonded should be cleaned of dust, oils, or other contaminants. Light sanding or abrading the surfaces is suggested, especially for plastics. Ambient application temperature should not be below 45 °F. Apply a thin coat of adhesive by brush or tube onto one of the surfaces to be bonded. Join the surfaces together to transfer adhesive to the second substrate. Pull the substrates apart and let dry until the adhesive is tacky to the touch but does not transfer to the finger. Put the substrate together again and apply pressure to make complete contact. Continue pressure for one to three minutes or until the bond no longer moves. Coating weight, drying conditions, and the substrates bonded can affect bonding time and adhesion. XS-4115 may be thinned with toluene, if necessary.

PHYSICAL PROPERTIES: (typical)

SOLIDS:	27 - 28%
VISCOSITY:	3500 - 3800 cps
Wt/gal:	7.2 - 7.4.
Solvent type:	Heptane/MEK/Toluene