

M30

CO-REZ, LOW VOC, RTM/ INFUSION ADHESIVE

DATA SHEET

TensorGrip



As part of our **MARINE** range, **M30 CO-REZ™** is a mist spray adhesive that is low in V.O.C. It is suitable for foam and thin fabric bonding applications as well as fibreglass infusion.

PRODUCT DESCRIPTION

TensorGrip® M30 CO-REZ™, designed for the Marine infusion mould market, is a high performance, solvent-based polymer adhesive in a pressurised canister delivery system. **TensorGrip® M30 CO-REZ™** is specifically designed to hold reinforcing fibres in place during the infusion process of the resin without affecting the surface finish or structural integrity. Most importantly, **M30 CO-REZ™** does not interfere with the curing process of vinyl esters, polyesters or styrene resins and ultimately becomes part of the polymer matrix. This product is a unique system to be used in the moulding process, and is designed specifically to overcome the problems normally associated with using other types of adhesive: such as bonding failure, resin blockage, surface defects in the finished product etc. It can also be used as a general purpose adhesive for a wide range of applications.

ADVANTAGES

- Used for Infusion/Vacuum Forming composites
- Safely fuses laminating materials to structural core surfaces
- Provides superior holding during forming process
- Allows resin to obtain maximum tensile shear strength
- Fine mist adhesive with green tracer for accuracy
- Fast tack
- Low VOC
- Does not interfere with cure process

DIRECTIONS FOR USE

- This product is designed to be applied to one or two sides of the surfaces to be bonded together. Make sure that surfaces are clean, dry and free from dirt, dust, oil, loose paint, wax or grease, etc. For best results, the temperature of the adhesive and the surfaces being bonded should be between 60 degrees F - 80 degrees F (16degrees C - 27 degrees C).
- Use with adequate ventilation. When possible we recommend shaking the canister well before using. Attach and secure hose tightly onto the spray gun with required tip. Attach the other end of the hose onto the canister. Make sure the hose-valve connections are securely tight. Open the valve on the canister slowly and fully, check for leaks during this process. Unlock the trigger on the spray gun to start spraying.
- Prior to use, Check compatibility by spraying a small test patch of the adhesive on the substrate. This product may degrade some substrates. Spray about 10-20 cm (4" – 8") away at a 90 degree angle to the surface, applying a uniform, even coat of adhesive to obtain 80% to 100% coverage of the surface. If necessary, spray another coat of adhesive in areas that appear to need more adhesive. If using a two way stick, spray both surfaces to be bonded, one surface vertically and the other surface horizontally. Allow the adhesive to tack off until no adhesive transfers to the knuckle when touched.
- Adhere surfaces and press together with adequate pressure.
- If the spray tip clogs, unscrew the spray tip from the gun and clean with solvent such as lacquer thinner or acetone. Do not use a pin on the spray tip orifice.

CANISTER STORAGE/CHANGE OVER

- Turn valve on canister into the off position, spray out remaining adhesive left in the hose, disconnect the spray hose and gun from the canister. Reconnect the spray hose to a canister of cleaning solvent (sold separately) and spray out until liquid is clear which indicates that the hose and gun is clean. If you choose to leave the hose and spray gun on the canister, leave the valve on the canister open. Do not disconnect the hose/gun from the canister. Close and lock the spray gun.

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SPECIAL PRECAUTIONS

For optimum results store canister above 18°C during use, but must always be above 10°C. Allow substrates to acclimatise to normal room temperature (18°C) for 48 hours before bonding. Do not exceed open time of the adhesive. Keep canister off cold concrete floors during use. If adhesive is expelled wet or as a jet, canister is too cold – move to warm environment and allow to thoroughly acclimatise before reusing.

CAUTION

- Use only in well ventilated areas.
- DO NOT thin or reactivate with solvents.
- DO NOT incinerate.
- DO NOT expose to extreme heat over 50°C.
- Keep away from sources of ignition.
- Release pressure before disconnecting hose.
- Test for suitability before use.

MSDS and Technical Data Sheets **MUST** be read and understood before use. Information contained in this technical literature is believed to be accurate and offered in good faith for the benefit of the consumer. The company however cannot assume any liability or risk involved in the use of its chemical products since the conditions of use are beyond our control. Statements concerning the possible use of our products are not intended as recommendations to infringe on any patent.

CHEMICAL TECHNICAL DATA

TYPICAL PROPERTIES

- | | |
|-------------------------------|--|
| • Total Solids: | 28-30% |
| • System flammability: | Adhesive in flammable solvent & propellant |
| • Shear: | Not determined |
| • Tensile: | Not determined |
| • Shear adhesion failure temp | Not determined |
| • (SAFT): | Not determined |
| • Heat Resistance: | Not determined |
| • Dry Time: | 3-5 mins dependant on temperature and humidity |
| • Open Time: | 30 mins |
| • SHELF LIFE: | 18 months from date of manufacture |

PACKAGING

- | | |
|--------|--|
| • 6kg | Mini X canister suitable for industrial use only |
| • 11kg | Large canister suitable for industrial use only |

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STORAGE

HANDLING & STORAGE

- Consult Material Safety Data Sheet prior to use.
- Do Not store at temperatures over 50°C.
- Avoid exposure to direct sunlight.
- Do Not store directly on concrete floor.
- For optimum performance, store at 18°C during use, but must always be above 10°C.
- When connected, keep valve open and hose pressurised at all times.
- Do Not close valve until ready to connect to new cylinder.
- Release pressure in hose before disconnection.
- Always test product to determine suitability for your particular application prior to use in production.

DISCLAIMER OF WARRANTY: The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired. Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product. Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions. The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.

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