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Tensor®

TC49

INFUSION HI-TAC ADHESIVE FINE MIST

TensorGrip® TC49 is a long standing favourite Infusion / RTM spray adhesive. With an immediate tack to hold the reinforcing fibres, you will also achieve a great surface finish with carbon fibre applications thanks to its fine mist spray properties. **TensorGrip® TC49** is compatible with polyester, styrene and vinyl ester resins and has been successfully

ADVANTAGES

- Fine Mist Spray Pattern
- Epoxy Resin Compatability
- Excellent for carbon clear coat aesthetics
- High Tack

TECHNICAL DATA

SUITABLE FOR

- Fibreglass Infusion
- FRP/GRP
- Thick Fabric
- Thin Fabric
- Mist Spray

COVERAGE

	500ml	22ltr
Single-sided	8m²	440m²

*Depending on ambient temperature

APPLICATION

1 Sided

GUN TYPE

Spray Gun - Professional, Spray Gun

OPEN TIME**

Up to 10 mins

HOSE TYPE

Black Rubber

FLASH OFF TIME***

30 secs

VALVE

Lechler

COLOUR

Clear

SPRAY TYPE

Fine Mist

ADHESIVE TYPE

SBR

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CHEMICAL TECHNICAL DATA

Viscosity	2050 CPS
Solids	29%
System Flammability	Flammable Solvent / Flammable Propellant
Heat resistance	115°C
Application Temperature	10 - 25°C
Shelf Life	18 months from date of manufacture

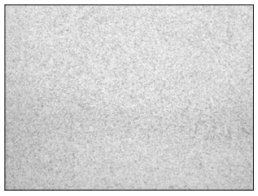
HANDLING & STORAGE

- For full handling and storage details consult Safety Data Sheet section 7.
- For optimum performance during use keep the aerosol/canister between 10°C and 25°C.
- Shake well before use.
- When connected, keep valve open and hose pressurised at all times.
- To avoid gun and hose blocking leave connected and under pressure even when canister is empty until ready to connect to new cylinder.
- Do not store below 10°C.
- Do not allow the product to freeze.
- Do not store directly on concrete floor.
- Do not incinerate and keep away from heat, hot surfaces, sparks, open flames and other ignition sources.
- Avoid exposure to direct sunlight and extreme temperatures.
- Do not use in confined spaces without adequate ventilation and/or respirator.
- For full PPE information, consult Safety Data Sheet section 8.
- Replace aerosol cap after use to protect actuator / valve.

COVERAGE

Coverage for this product is calculated on an average coatweight of approx 5 to 10 grams per m² based on a single sided bond. Lower coatweight may result in reduced bond strength and/or bond failure.

Coverage too light



Correct application
= 20 grams/m2

Coverage too heavy

SURFACE PREPARATION

Surface preparation is crucial for achieving effective adhesion, make sure that surfaces are clean, dry and free from dirt, dust, oil, loose paint, wax or grease, etc. Any contaminants may affect adhesion.

For best bonding results, the adhesive temperature range should be between 10°C - 25°C. Optimum temperature is 18°C.

PRE BONDING INFORMATION

- Prior to use, check compatibility by spraying a small test patch of the adhesive on the substrate. This product may degrade some substrates.
- Always test the adhesive to determine suitability for your particular application prior to use in production.
- Consult both MSDS and TDS documents.
- When working with absorbent materials a higher coat weight is recommended.
- ALWAYS READ THE LABEL.

CAUTION

ALWAYS USE WITH ADEQUATE VENTILATION. For Full PPE Information Consult SDS (Safety Data Sheet) Section 8. Whenever possible we recommend shaking the canister well before use.

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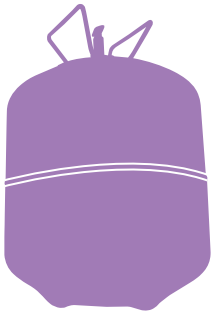
DIRECTION FOR USE



AEROSOL

1. SHAKE WELL BEFORE USE
2. Make sure that surfaces are clean, dry and free from dirt, dust, oil, loose paint, wax or grease, etc.

3. Spray 10 to 20cm away from the substrate at a 45 degree angle to the surface, applying a uniform, even coat of adhesive to obtain 80% to 100% coverage of the surface.
4. If necessary, another coat of adhesive may be applied in areas that appear to require more adhesive.

5. When working with absorbent materials testing is recommended to achieve correct coat weight for optimum bonding.

6. Please note that a higher coat weight will reduce overall coverage.
7. Allow the recommended flash off time for the adhesive to tack off, temperature may affect drying times so ensure adhesive is touch dry.

8. Bring surfaces together with adequate pressure to form the bond, a roller is recommended to apply a uniform pressure to achieve maximum bond strength.

9. Allow 24 hours for the adhesive to fully cure.
10. If the aerosol spray nozzle clogs, turn the can upside down and press the nozzle until a small amount of propellant is expelled to clear the blockage.

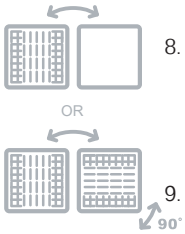
CANISTER

1. Make sure that surfaces are clean, dry and free from dirt, dust, oil, loose paint, wax or grease, etc.
2. Attach and secure hose tightly onto the spray gun with required tip as per the set up guide.

3. Spray 10 to 20cm away from the substrate at a 90 degree angle to the surface, applying a uniform, even coat of adhesive to obtain 80% to 100% coverage of the surface.
4. If necessary, another coat of adhesive may be applied in areas that appear to require more adhesive.

5. When working with absorbent materials, a higher coat weight and is recommended.
6. Please note that a higher coat weight will reduce overall coverage.

7. Allow the recommended flash off time for the adhesive to tack off, temperature may affect drying times, ensure adhesive is touch dry.



8. Bring surfaces together with adequate pressure to form the bond, a roller is recommended to apply a uniform pressure to achieve maximum bond strength.
9. Allow 24 hours for the adhesive to fully cure.
10. Clean the tip after use with a suitable solvent cleaner.

11. If the spray tip clogs, unscrew the spray tip from the gun and consult canister maintenance & storage after use.
12. Do not use a pin on the spray tip.

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CANISTER SETUP

STEP 1.
Screw the larger hose nut to the gun thread (clockwise) and fully tighten with a 22mm spanner. Check hose is securely attached.

STEP 2.
Insert the spray tip into the tip retaining nut and screw onto the end of gun using a 22mm spanner. Ensure spray tip is in vertical/upright position.

STEP 3.
Screw the smaller hose nut to the canister valve (clockwise) and fully tighten with a 15mm spanner. Check the hose is securely attached.

STEP 4.
Turn the canister valve anti-clockwise until fully open. Check connections for leaks - if any occur, tighten connections. DO NOT TURN THE CANISTER VALVE OFF UNTIL THE CANISTER IS EMPTY (this is to prevent adhesive curing in the hose and gun).

STEP 5.
On initial use, or if canister has been standing for over 12 hrs, the hose and gun may require a purge. Pull the trigger and adjust flow by turning adjustment screw at the back of the gun (anticlockwise to open and clockwise to close). Dispense and discard adhesive until a consistent spray pattern is achieved.

CANISTER CHANGEOVER

STEP 1.
Turn the canister valve (clockwise) until fully closed. Pull the trigger on the gun and hold until there is no more pressure in the line to expel residual pressure (may take up to 20 seconds).

STEP 2.
Unscrew the hose nut with a 15mm spanner and disconnect the hose from the empty canister (move to next page for canister disposal).

STEP 3.
Connect the hose and gun to the new canister (go to Step 3 of preparation and follow the process through to Step 5). If you are not transferring the hose and gun to a new canister you will need to clean it to ensure it can be used again on future jobs. Consult product TDS and MSDS, for correct cleaner.

IMPORTANT NOTE:
This process should be followed through immediately, to stop the gun and hose blocking and becoming unusable.

Safety glasses and gloves must be put on before starting the disposal process.

Tip should be wiped after every use with wire brush and appropriate cleaner.

AEROSOL REMOVAL OF ADHESIVE

To remove wet adhesive overspray, apply a solvent based cleaning product to the surface or to a rag and wipe away. Use warm soapy water to remove cleaner residue if required.

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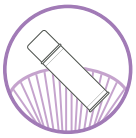
AEROSOL DISPOSAL

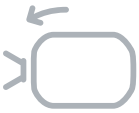


Dispose of the can as per your normal recycling process (subject to waste restrictions).

WARNING

Do not pierce or burn even after use.

CANISTER DISPOSAL



STEP 1.
Lay the empty canister on its side with the valve pointing AWAY from everyone, and well away from sources of ignition.

STEP 2.
Open the canister valve (anti-clockwise) and release any residual pressure.

STEP 3.
Stand canister upright. Use a hammer and brass punch or other non-sparking instrument to puncture the friable disc.

STEP 4.
As long as the user is able to accept responsibility for de-pressurising the canister, it can be disposed of as per your normal scrap metal disposal (subject to local waste restrictions).