

HANDLING GUIDELINES FOR ALL NORDOT® HIGH GREEN STRENGTH (GRAB) URETHANE ADHESIVES

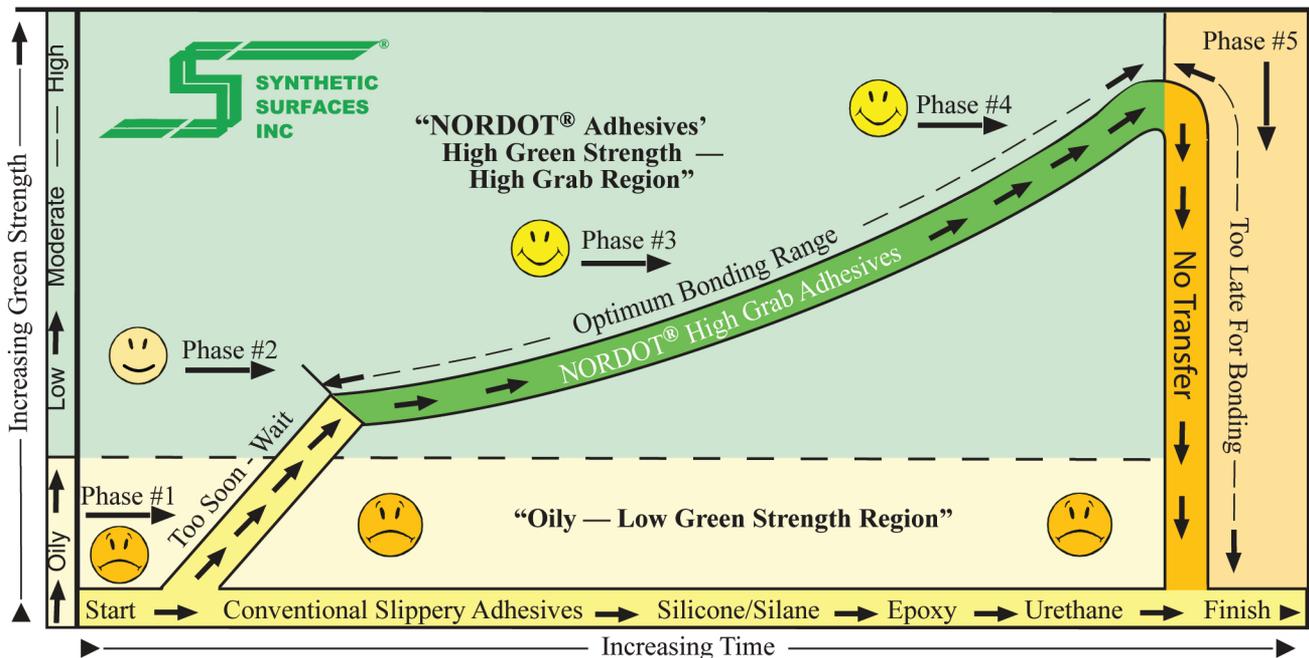
We offer several NORDOT® High Green Strength adhesives which, after cure, have basically the same outstanding water resistance, durability, and weathering characteristics. Their differences are in their physical properties and handling properties before and during installation.

The reason for the different adhesives is so that installers, contractors and others will have easier, faster, more profitable installations by being able to select the NORDOT® Adhesives that are best suited for their particular needs. Some are Newtonian type liquids that pour; some are Thixotropic with a mayonnaise type consistency; some can be sprayed; troweled; applied from a glue-box; or a squeegee; or a roller, plus all are usable under widely variable outdoor weather conditions. As a result, installations are faster and often less labor expenses are required.

The key to faster, high quality and more profitable installations is the adhesive property known as green strength. Below are both a description and a graph showing how to better use NORDOT® Adhesives and how to take advantage of their high green strength properties. NORDOT® Adhesives are very easy to handle but they are different than other adhesives, so please read before starting an installation.

Handling Barometer: Forget specific times as a bonding guide because temperature, humidity, wind, adhesive thickness, method of application and other factors prohibit it. Instead, regardless of weather conditions, observe and be guided by the five NORDOT® Adhesives phases listed and discussed below.

- Phase #1** (Negligible grab) - Film is wet and in the early stages of solvent evaporation.
- Phase #2** (Mild grab) - Tacky, long and weak adhesive “legs”. Low cohesive strength.
- Phase #3** (Moderate grab) - High tack, short and strong adhesive “legs”. Moderate cohesive strength.
- Phase #4** (High grab) - Film almost dry when touched lightly, but has high strength and stubby adhesive “legs” when firmly pressed. The adhesive has a high cohesive strength; grabs aggressively; and clings tenaciously.
- Phase #5** (No grab) - Film dry with no transfer when pressed and/or heated.



NORDOT® high green strength adhesives pass through five phases of grab after application as shown on the above graph: Phase #1 “Too Soon - Wait”; Phase #2 shows their rapid increase in grab as the solvent evaporates; Phases #3 and #4 show the high green strength “Optimum Bonding Range” and Phase #5 is “Too Late For Bonding” (no adhesive transfer).

SYNTHETIC SURFACES INC.