

PRODUCT DATA



One-Component Urethane Adhesives

DESCRIPTION

Specifically designed for lamination and construction, **OnePart™** is a premium one-component urethane adhesive. **OnePart** has been evaluated for structural use in the manufactured housing industry according to California CA 25-4 Standards and ASTM E72-80. **OnePart** has also passed all tests as specified on PEI Report #2000-1768 and 2001-1215 at the -20 minute working time profile. For further details and handling precautions, consult the Safety Data Sheet.

PROCESS APPLICATION

Designed for applications needing adhesion.

TYPICAL PHYSICAL PROPERTIES

Typical properties, individual results may vary. Properties below are typical when processed through a FSI dispensing unit. Properties are subject to change depending on specific operating parameters.

Type	Urethane
Color	Brown
Solids	100%
Net Weight	9.3 lb./gallon
Viscosity (cps @ 77°F)	4,300 – 4,900
Substrate Temperature*	60° – 105°F
Storage Temperature**	50° – 90°F
Typical Reactivity***	77°F @ 50% Relative Humidity
Open Time	30 sec. – 47 min.
Set-Up Time	1 min. – 95 min.

(Combustability: Polyurethane foams are organic material and are combustible under certain fire conditions.)

* Cure time will change with temperature and humidity.

** Viscosity increases with lower temperatures.

*** “Fastened” walls can be handled at any time.

NOMINAL APPLICATION SPECIFICATIONS

Adhesive	Application Method	Adhesive Applied	Water Applied	Ambient Temp	Ambient RH
OnePart-2	Bead or Roll Coat	12 g/ft ²	2 g/ft ²	73.4°F	50%
OnePart-20	Bead or Roll Coat	12 g/ft ²	2 g/ft ²	73.4°F	50%
OnePart-35	Bead or Roll Coat	12 g/ft ²	2 g/ft ²	73.4°F	50%
OnePart-47	Bead or Roll Coat	12 g/ft ²	2 g/ft ²	73.4°F	50%

NOMINAL CURING SPECIFICATIONS

Adhesive	Relative Humidity	Chemical Temp.	Open Time ¹	Closed Time ²	Press Time ³	Press Pressure
OnePart-2	50%	75°F	0.5 min	1.0 min	6 min	3 psi
OnePart-20	50%	75°F	1.25 min	11.25 min	67 min	3 psi
OnePart-35	50%	75°F	2.25 min	27.75 min	130 min	3 psi
OnePart-47	50%	75°F	3 min	30 min	180 min	3 psi

¹ **Open Time** is defined as the maximum amount of time elapsed from adhesive application until the adhesive is covered with another substrate.

² **Closed Time** is the maximum cumulative amount of time elapsed from the adhesive application, when it is covered with another substrate, until the assembly is under pressure.

³ **Press Time** is the minimum amount of time the assembly is maintained under pressure.



SAFETY:

When working with any chemicals it is necessary to wear eye protection and gloves. It is necessary to understand hazards involved in handling all components, establish and follow safe work procedures, and comply with all OSHA, DOT, and EPA Regulations. Refer to SDS for specific details. All persons who work with components must know and follow proper safe handling procedures.

SHELF LIFE:

Six (6) months from date of manufacture when stored in original, unopened, containers at temperatures between 65–80°F. Consult with FSI before disposal or return if components exceed shelf life.

HANDLING:

As with all chemicals, care should be exercised when handling. Avoid contact with eyes, skin, and clothing. Eye protection and gloves are considered a minimum requirement and should be worn at all times while working with components. Refer to SDS for specific details regarding handling requirements.

STORAGE:

Do not store in direct sunlight. Containers should be stored under cover and protected from contact with rain or snow. Water should not be able to accumulate where it can be drawn into the containers. Ideal storage temperatures are 50°F (10°C) to 75°F (24°C). Keep containers sealed until use. Refer to SDS for further information or contact FSI for assistance.

STEWARDSHIP:

FSI and its subsidiaries are committed to stewardship and have a concern for the health and safety of all individuals who come in contact with its products, as well as the environment. This philosophy is a foundation on which we assess information to appropriately protect individuals and preserve our environment. Success of stewardship rests with each and every individual involved in the cradle to grave life cycle of our products.

CUSTOMER RECOMMENDATIONS:

FSI strongly encourages customers to review their manufacturing, health, safety, and environmental processes and applications while evaluating its products.

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