The Dependable and Durable Adhesive from the leader in PU solutions – Foam Supplies.

Entry and garage doors. Recreational vehicle components. Building and construction products like structural insulated panels (SIPs). For these commercial adhesive applications and many more, nothing meets the challenge like OnePart™ – the industrial strength adhesive from Foam Supplies, Inc.

OnePart™ is part of a family of FSI urethane adhesives designed with uncompromised quality. It’s been proven effective for many industrial and commercial applications, and is a more efficient and economical option to traditional tube and caulk applications.

OnePart™ is also environmentally benign. It’s VOC exempt, formaldehyde-free and does not contribute to global warming or ozone depletion. Plus, OnePart™ adhesive has third party certification for various testing requirements including, but not limited to, IM 022, CA 25-4 Standards and ASTM E72.
PHYSICAL PROPERTIES
• Type: Moisture-Cure Urethane Adhesive
• Color: Brownish
• 100% Solids
• Net Weight: 9.3 lbs/gal
• Viscosity (cps @ 77°F/25°C): 4,300 - 4,900
• Reactivity Range:
  – Open Time: 30 sec - 47 min
  – Set-Up Time: 1 min - 95 min
• Storage Temperature: 50 - 90°F
• Six-month shelf life

KEY BENEFITS
• Good Mechanical Properties
• No Fillers
• Third Party Certified
• Large Range of Reactivities
• Various Delivery Methods
• Worldwide Availability
• Environmentally Benign
  – Zero Global Warming
  – Non Smog Producing
  – Zero Ozone Depleting
  – Formaldehyde Free

CERTIFICATIONS
• CA 25-4 Standards
• ASTM E72-80
• ASTM C557
• ICC-ES AC0005-05
• IM 022/AC05
• IM 036/AC04

Specifications (from PEI Listing Report)
TABLE 1: NOMINAL APPLICATION SPECIFICATIONS
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>OnePart 2</td>
<td>Bead or Roll Coat</td>
<td>12 g/ft²</td>
<td>2 g/ft²</td>
<td>73.4°F</td>
<td>50%</td>
</tr>
<tr>
<td>OnePart 20</td>
<td>Bead or Roll Coat</td>
<td>12 g/ft²</td>
<td>2 g/ft²</td>
<td>73.4°F</td>
<td>50%</td>
</tr>
<tr>
<td>OnePart 35</td>
<td>Bead or Roll Coat</td>
<td>12 g/ft²</td>
<td>2 g/ft²</td>
<td>73.4°F</td>
<td>50%</td>
</tr>
<tr>
<td>OnePart 47</td>
<td>Bead or Roll Coat</td>
<td>12 g/ft²</td>
<td>2 g/ft²</td>
<td>73.4°F</td>
<td>50%</td>
</tr>
</tbody>
</table>

TABLE 2: NOMINAL CURING SPECIFICATIONS
<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Relative Humidity</th>
<th>Chemical Temp.</th>
<th>Open Time 1</th>
<th>Closed Time 2</th>
<th>Press Time 3</th>
<th>Press Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>OnePart 2</td>
<td>50%</td>
<td>75°F</td>
<td>0.5 min</td>
<td>1.0 min</td>
<td>6 min</td>
<td>3 psi</td>
</tr>
<tr>
<td>OnePart 20</td>
<td>50%</td>
<td>75°F</td>
<td>1.25 min</td>
<td>11.25 min</td>
<td>67 min</td>
<td>3 psi</td>
</tr>
<tr>
<td>OnePart 35</td>
<td>50%</td>
<td>75°F</td>
<td>2.25 min</td>
<td>27.75 min</td>
<td>130 min</td>
<td>3 psi</td>
</tr>
<tr>
<td>OnePart 47</td>
<td>50%</td>
<td>75°F</td>
<td>3 min</td>
<td>30 min</td>
<td>180 min</td>
<td>3 psi</td>
</tr>
</tbody>
</table>

1Open Time is defined as the maximum amount of time elapsed from adhesive application until the adhesive is covered with another substrate.
2Closed 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.
3Press Time is the minimum amount of time the assembly is maintained under pressure.

To obtain the most current PEI Listing Report, visit http://www.p-e-i.com/reports.html.