

**CANTAC HIGH-TAC** is a premium high strength, high heat resistant contact adhesive formulated for bonding High Pressure Laminates (HPL) to MDF, particleboard and plywood.

**HIGH-TAC** is also suitable for a wide variety of substrates and applications including furniture and upholstery work, automotive headliners and marine applications. Superior bond strength properties and exceptional heat resistance make HIGH-TAC an excellent choice for permanent bonding of HPL and a variety of substrates.

**HIGH-TAC** will effectively bond High Pressure Laminates (HPL), MDF, particleboard and plywood, urethane foam, FRP, carpet, felt, fabrics, paper products, duct insulation, steel, aluminium, concrete, moulded fiberglass, most plastics and many other materials.



## USES

- Bonds High Pressure Laminates (HPL)
- Radius Edge Banding
- Bonds Foam to Foam
- Furniture & Upholstery
- Automotive & Marine Headliners
- Wall & Floor Coverings

## FEATURES

- |                       |                                 |
|-----------------------|---------------------------------|
| ✓ High Heat Resistant | ✓ No Ozone Depleting Substances |
| ✓ High Strength       | ✓ Low Odour                     |
| ✓ Fast Tacking        | ✓ High Coverage                 |
| ✓ Non-Flammable       | ✓ High Solids                   |
| ✓ Waterproof          |                                 |

## THE CANISTER ADVANTAGE

- CANTAC's self contained, environmentally friendly, portable canister system was designed for ease of use.
- The canister, equipped with a reusable gun and hose, eliminates the need for air assisted adhesive application systems.
- No power or compressor is required!
- This approach significantly reduces set up and clean-up time. The canister system is almost maintenance free. No solvent is needed to flush out guns and messy pressure pots.
- The spray pattern is consistent, delivering perfect results every time which eliminates human error caused by inconsistent spray patterns. Its portability enables you to apply adhesive in your facility or on site.
- Once you have emptied the eco friendly canister, simply attach your gun and hose to a new one. The empty canister is made from recyclable steel and can be easily recycled making it more environmentally friendly than traditional plastic containers.

## PHYSICAL & CHEMICAL PROPERTIES

<b>Chemical Description</b>	Solvent Based Contact Adhesive	<b>Minimum Open Time</b>	1 - 3 minutes
<b>Odour</b>	Minimal Solvent Odour	<b>Maximum Open Time</b>	2 hours (best results within 1hr)
<b>Appearance</b>	Clear Liquid	<b>Heat Resistance</b>	-40 – +120°C
<b>Solids Content</b>	32 - 36%	<b>Cleaner</b>	Citrus Cleaner or Acetone
<b>Viscosity</b>	Sprayable Grade	<b>Flash Point</b>	Non detected
<b>Coverage</b>	15m <sup>2</sup> per kg Single Sided <small>(Guide only. Coverage depends on absorbency of surface and coating weight).</small>	<b>Specific Density</b>	1.20kg per ltr +/- 5%
		<b>Size</b>	17kg Recyclable Canister; 575mL Aerosol

## DIRECTIONS FOR USE

1. For best results all surfaces to be bonded must be clean, dry and free from dirt, dust, oil, loose paint, wax and grease. The temperature of the adhesive and the surfaces being bonded should ideally be between 15°C - 27°C.
2. Attach the larger end of the hose to the spray gun and tighten securely, attach the smaller end of the hose to the canister valve securely.
3. Slowly open the canister valve and inspect the connections for any leaks. Tighten if needed. Fully open the valve.
4. Unscrew the trigger stop nut on the gun and spray a test pattern. Adjust nut to vary adhesive output.

### ADHESIVE APPLICATION

Hold the applicator 150-250mm away from the surface and apply an even coat of adhesive to one or both surfaces covering approximately 80-100% of the surface. Allow adhesive to dry until tacky (1-3mins).

*Note: Test for tackiness by gently touching the adhesive with your knuckle. If the adhesive transfers to your skin it is too wet. If the adhesive is tacky and does not transfer to your skin, it is ready to bond. If the adhesive is dry or has very little tack, it is too dry and another coat of adhesive should be applied. Porous substrates may require additional coats. High strength of critical bonds may require two coats per surface.*

Apply even pressure over the entire surface to ensure intimate contact. Pressure may be applied by mechanical presses, nip rollers or hand rollers. Insufficient pressure will result in poor bonds.

### CLEAN UP

Clean tip after use with CANTAC Citrus Cleaner. Excess adhesive and overspray may be removed with CANTAC Citrus Cleaner, Acetone, WOODLOK GLAZE-AWAY & DSOLV-AWAY, GLUE GURU 05CR or most Industrial Solvents.

### EQUIPMENT SHUT DOWN / STORAGE

Screw the trigger stop adjustment nut all the way to the trigger lock position.

DO NOT disconnect the hose until the canister is completely empty and ready to attach to another canister.

The canister system can be stored for up to 2 months without being used. If the canister is going to be left for longer than 2 months it is recommended to turn off the canister, bleed the pressure from the gun and hose. Remove the gun and hose and attach to a canister of Gun & Hose Cleaner and flush out the line for approximately 3 minutes. The gun and hose can then be removed and stored.

Alternatively remove the tip and soak in solvent, spray a small amount of adhesive through the gun and hose every 1-2 months to ensure there is no thickened adhesive in the hose.

## TROUBLESHOOTING

### COLD WEATHER PROBLEMS

#### *EFFECTS OF COLD WEATHER AND CANISTERS*

The adhesive in the canister will thicken as temperatures get colder. The propellants used will decrease in pressure and therefore effectiveness. The propellants may condense and reduce the effective amount of available pressure in the canister. This will adversely affect the spray pattern and consequently, the performance of the adhesive.

#### *HOW TO ELIMINATE COLD WEATHER PROBLEMS*

1. Store the canisters in a controlled environment with temperatures between 15°C and 27°C.
2. Keep canisters off cold concrete floors and away from outside walls.
3. Allow additional time for solvents and propellants to flash off when temperatures are below 15°C.
4. If the canisters are too cold for use, they can be brought up to room temperature by submerging them up to the valve in warm water or by attaching a heater belt. Once the canisters equilibrate to at least 15°C, the products will perform as normal.

### APPLICATOR – HOSE BLOCK CHECK LIST

#### *IF THE SYSTEM SPRAYS POORLY, OR NOT AT ALL:*

The sequence below runs through to a complete clog in the canister valve. If at any time during the sequence the problem is resolved, stop, clean the needed parts, put the system back together, and you are finished.

1. Make sure the canister is not empty.
2. Make sure the canister valve is open.
3. Close the spray gun trigger stop adjusting nut and clean the nozzle tip. (Does it spray now?)
4. Take off the nozzle and try spraying (Does it spray now?). Clean the nozzle.
5. Shut off the canister valve. Carefully and slowly, loosen the spray gun/hose connection and look for adhesive to squirt out. If adhesive starts to leak out, allow it to slowly continue to do so until it stops. (This will be messy but you will need to bleed off the pressurised adhesive to clean the spray gun). The spray gun has a clog at the valve, stem or inlet area and needs to be cleaned.
6. If nothing leaks out after fully loosening the spray gun, carefully remove the spray gun, realising that the hose may be clogged but could be full of adhesive and pressure depending on where the clog is. (Secure the open end of the hose into a bucket in case the clog releases and the system flushes).
7. Carefully and slowly loosen the hose connection at the canister valve. Look for adhesive to squirt out. If adhesive starts to leak out, allow it to slowly continue to do so until it stops. (This will be messy but you will need to bleed off the pressurised adhesive in the hose.) Clean or replace the hose.
8. With everything now isolated from the canister, place a bucket in front of the canister valve and slowly open to see if any adhesive comes out. If it does, put the cleaned system parts back together. If it does not, there is something wrong with the canister valve and it should be returned.

#### *SOLVENTS THAT CAN BE USED FOR CLEANING THE NOZZLE, SPRAY GUN:*

CANTAC Citrus Cleaner, Acetone, Toluene, WOODLOK GLAZE-AWAY & DSOLV-AWAY, GLUE GURU 05CR or most Industrial Solvents.

#### *FOR CLEANING THE HOSE:*

Attach gun and hose to a canister of CANTAC Gun & Hose Cleaner and flush out for approximately 3 minutes.

## HEALTH & SAFETY

Refer to the Material Safety Data Sheet for health and safety information before using this product.

## HANDLING & STORAGE

Product should be stored between 5°C and 25°C on a wooden pallet and kept from freezing. Keep out of direct sunlight and away from sources of heat. If the product has been left for prolonged periods between uses, agitating is recommended.

## DISPOSAL

Canister disposal: Use extreme caution. Empty canister completely. Puncture the friable disc on the canister using a non-spark producing tool. Dispose of the scrap metal in accordance with local regulations.

## SHELF LIFE

Best used within 24 months from date of manufacture when stored under the above conditions in the original unopened containers.

## LIMITATIONS

HIGH-TAC is not recommended for use on Polystyrene.  
HIGH-TAC is not recommended for Vinyl Flooring.

## TESTING

Always test the suitability of the product for your application before use.

## OTHER CANTAC PRODUCTS

### HSE-TAC

*Premium high strength contact with low odour.  
Extra long open time for high volume applications.*

### POLY-TAC

*Industrial strength, polystyrene safe contact adhesive for bonding polystyrene to itself and many other materials.*

### HIGH-TAC

*High strength, high heat resistant contact adhesive for high pressure laminates, upholstery & most wall & floor coverings.*

### ULTRA-TAC

*Pressure sensitive adhesive with exceptional tack for insulation materials.*

### GUN & HOSE CLEANER

*Solvent canister for flushing out guns and hoses.*

### CITRUS CLEANER

*Cleans gun tips and removes a variety of adhesives and tape residue.*



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