

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

All NORDOT® one-part adhesives have basically the same high grab, outstanding water resistance and long-term durability in all climates after cure. When installing, our Newtonian syrup-type liquids level and flow, and our Thixotropic mayonnaise-types hold trowel ridges, even on vertical surfaces. Some can be applied by airless spray or a glue box, while a trowel, squeegee or roller can be used with all. Plus, they are usable year-round, under widely variable weather conditions and with no temperature limits.

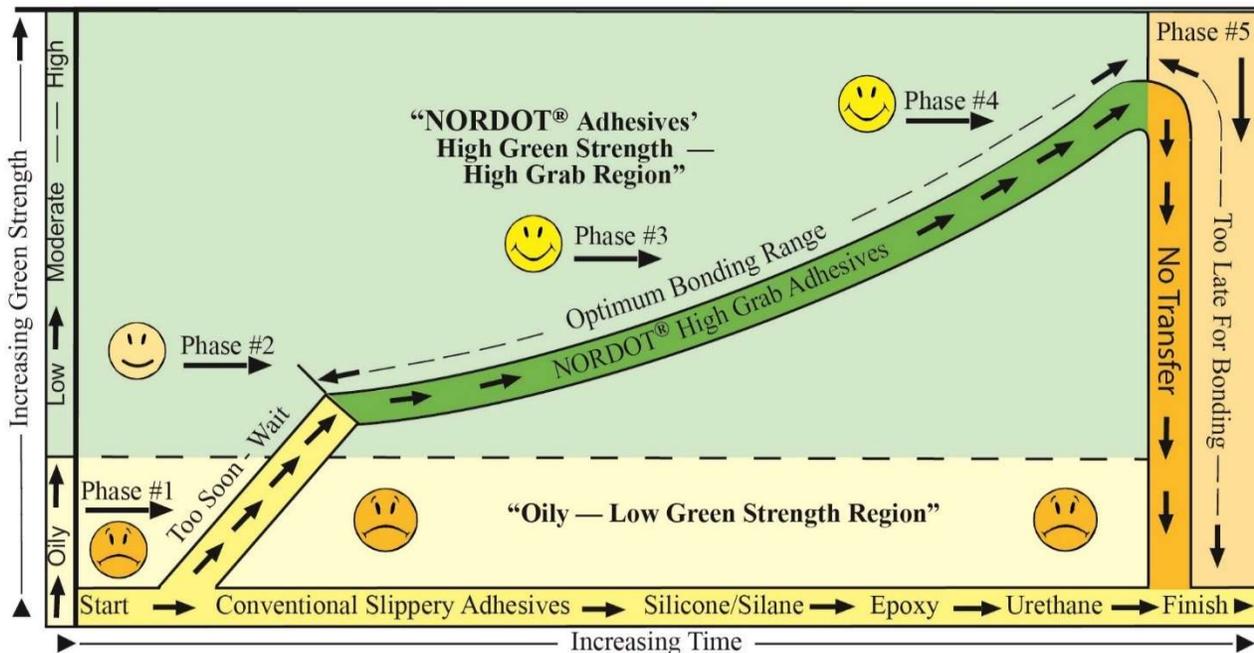
The key to faster, higher quality and more profitable installations using NORDOT® Adhesives is the unique and important property known as high “green strength” (high grab while still wet).

The graph and description below show how to best use NORDOT® Adhesives to take advantage of their high green strength. Although they are very easy to handle, NORDOT® Adhesives are different than other adhesives, so please read below before starting an installation.

Helpful hint to prolong the adhesive’s pot life:
 1) Prepare your work. 2) Remove the pail lid or screw cap. 3) Dispense the adhesive amount needed. 4) Tightly re-seal the lid or screw cap immediately. 5) Spread the dispensed adhesive. 6) Repeat this process during the installation.

Handling Barometer: There is no specific bonding time to use as a 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® Adhesive phases described below.

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| Phase #1 (Negligible grab) | – | Adhesive film is wet and in the early stages of solvent evaporation. |
| Phase #2 (Mild grab) | – | Tack developing, 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 is dry with no adhesive transfer when pressed and/or heated. Too late. |



As shown on this graph, NORDOT® high green strength adhesives pass through five “phases” of grab after application: **Phase #1** – “Too Soon - Wait”; **Phase #2** – Rapid increase in green strength (grab) as the solvent evaporates; **Phases #3 and #4** – The high green strength “Optimum Bonding Range”; **Phase #5** – “Too Late for Bonding” (no adhesive transfer).

