

## CANISTER SPRAYING GUIDE



### STEP 1

Prepare the surface to be bonded, ensuring both faces are clean, free of dust, dirt, and grease. If necessary wipe clean with a solvent-based cleaner. **DO NOT USE CITRUS-BASED CLEANERS.**



### STEP 2

Hold spray gun at a constant distance of between 100-250mm from the surface, spray the surface with approx. 50-70% overlap to successive passes for thin laminates to reduce risk of telegraphing (note: correct coverage must be achieved).



### STEP 3

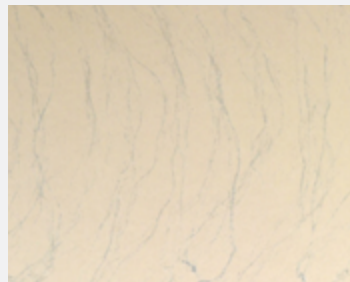
Maintain a constant speed of application during spraying, do not allow the adhesive to puddle or heavily 'wet' the surface. Maximum bond strength is achieved with coverage of 80-100%.

### STEP 4

Maximum adhesion will be obtained by spraying mating faces at 90° to each other, i.e. one face vertically, the other face horizontally. Double coating perimeter of face and edges is recommended.

## CANISTER BONDING TECHNIQUES

- Do not angle the spray gun or move in an arc while spraying. Hold the gun at 90° to surface. Release trigger at end of each pass to optimize coverage.
- Many boards such as plywood, flexi-ply and MDF are very absorbent and will need a primer coat. Allow to dry, then apply a regular coat over top of the primer coat.
- Some substrates can be difficult to bond, or have memory, and may require 2-3 coats. Best results are obtained by multiple coats rather than one heavy coat.
- Test for dryness using back of hand only; the surface should be tacky but adhesive should not transfer to skin. Position substrates correctly and press together working from centre outwards. Apply adequate pressure using nip or hand roller as a minimum.



COVERAGE TOO LIGHT



COVERAGE TOO HEAVY



CORRECT APPLICATION  
= 20 dry gms/sqm



75 mm HAND ROLLER

## CANISTER OPEN TIMES GUIDE



PRODUCT NAME

MAXIMUM OPEN TIME



**G50**

**60 mins**

The open time/s indicated above are only intended as a guide. Please take into account the factors listed below:

### SUBSTRATES

Porous substrates will reduce the required open time.  
Metals/Plastics will increase the required open time.

### TEMPERATURE

High temperatures will reduce the required open time.  
Low temperatures will increase the required open time.  
increase the required open time.