

Code	Description	Size	Colour
19325	Holdfast 1117 Spray Adhesive	20 Litres	Clear
19326	Holdfast 1117 Spray Adhesive	20 Litres	Red

1. Description

Holdfast® 1117 is a contact spray grade solvent based neoprene adhesive.

2. Characteristics

- Fast drying
- Water resistant bond
- Withstand high temperatures
- Quick Initial Tack with rapid development of bond strength

3. Technical Data

Coverage:	5-6 sq. metres per litre (depending on the absorbency of the surface and method of application)
Specific Gravity:	0.86-0,87
Viscosity:	Approx. 523 cps
Solids:	Approx. 18%
Flash Point:	-22°C highly flammable
Tack Time (*):	5 min
Maximum Open Time (*):	30 min
Heat Resistance:	Greater than 140°C (when tested to AS2131-1987)

*These values may vary depending on environmental factors such as temperature, moisture, and type of substrates.

4. Applications

- Designed as a versatile laminating adhesive where heat resistance is required.
- Bonds Formica and similar materials to wood and wood-board commonly used for cabinet and bench manufacture.
- Used for foam and fabric lamination.

5. Packaging

20 Litres

6. Shelf Life

24 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C.

7. Application Instructions

Method: Spray
Application Temperature: +5°C until +30°C
Clean: Gorilla H2 Stick-It Solvent

Surfaces

Type: All usual building substrates
State: Surfaces must be clean, dry and sound.

Application

- Stir well before use
- Spray apply a thin coating of adhesive to both surfaces.
- Allow the solvent content to evaporate before bonding the materials.
- For normal working conditions bonds can be formed within five minutes after application of adhesive.
- The sprayed surfaces are contacted and pressed firmly together.

Equipment: Suggested spray equipment is a DeVilbiss JGA 502 gun with a 797 air cap. Line air pressure from 60 psi upwards.

Soudal recommends preliminary compatibility tests

8. Storage

- Store in well-sealed containers away from heat and any source of combustion or sparks.
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- Freezing is to be avoided.
- This product will remain suitable for its intended purpose for up to two years when stored in the original sealed container. Viscosity changes may occur during this time.

8. Health and Safety Recommendation

- This material is highly flammable. Flash point of less than 0o C. Class 3a flammable liquid.
- Do not smoke, have open flames, fire or electrical equipment near this product while in use. Vapours are extremely flammable.
- Use only in a well-ventilated area. Avoid breathing the vapours and contact of the adhesive with the skin.
- Harmful or fatal if swallowed. Keep out of the reach of children. Do not induce vomiting if swallowed. Call a doctor immediately.
- Keep container firmly closed when not in use. Stir adhesive well before use.
- In case of fire foam, BCF or carbon dioxide extinguishers are preferred. If liquid product is present water jet may spread the flames.
- Take the usual labour hygiene into account. Consult the packaging label for more information.

Remark

*The directives and data contained in this documentation is provided in good faith and accurately reflect Soudal's knowledge when its products are properly stored, handled and applied under normal conditions in accordance with Soudal's recommendations. In practice, the diversity of the materials, substrates, environments, site conditions, product storage, handling and application are such that no warranty can be given in respect to the merchantability or fit for purpose, of any product. All users must determine the product suitability for their purposes through testing. This technical data sheet and product properties may change without notice so users, suppliers and retailers of Soudal products should always check that the data sheets they have are the latest. To the maximum extent permitted by law, Soudal disclaims all warranties in relation to either the manufacture, storage and end use of the product. All orders are accepted subject to our current terms of trade. **If any clarification is required, please contact Soudal Technical Services or email info@soudal.co.nz.***

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