



General Plastics Manufacturing Company

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Manufacturers and Molders of
LAST-A-FOAM® High Density
Rigid and Flexible
Polyurethane Foams
and
Fabricators of Plastic Sheets
for
Aircraft, Industrial,
Construction, Marine, Nuclear,
Shipping and Modeling
Industries



- Cures to similar hardness and density as LAST-A-FOAM®
- Easy-to-apply polyurethane formulation
- Waterproof and weatherproof
- Expands slightly to fill bond-line gaps
- Economical to use – a little goes a long way
- High-strength, tough – but easy to cut through and sand

GENERAL PLASTICS MANUFACTURING COMPANY

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LAST-A-FOAM® BONDER

and

LAST-A-FOAM® QUICK-SET BONDER



Polyurethane Foam
Bonding Adhesive
suitable for use with
LAST-A-FOAM®
densities to 20 lbs. pcf

LAST-A-FOAM® BONDER

DIRECTIONS FOR USE:

1. **Wear gloves when using this adhesive** – cured glue cannot be removed from skin.
2. Compressed-air blow or vacuum any dust or cutting debris from bonding surface. Bonding surfaces should be clean, dry, and free of any contaminants.
3. Apply liquid adhesive to **one side** of intended bond line. For best results, spread adhesive to form a **very thin coating** on foam surface. A paint brush with bristles cut short works to accomplish this very easily.
4. **Spread material as far as it will go.** Avoid creating any puddles or thick build-up of adhesive. A thin coating will cause a barely-noticeable color change in the surface of the foam.
5. **Adhesive cures with moisture.** A (very) light misting of water over surface of the adhesive can be applied to slightly accelerate adhesive cure.
6. Set or clamp second piece of foam together with the first piece (the piece with the adhesive on it).
7. **Clamp together for at least 4 hours.** Apply sufficient clamp pressure to fixture parts and **fully engage bonding surfaces.** A small amount of squeeze-out usually indicates adequate adhesive coverage. **This adhesive expands on curing** – large amounts of squeeze-out indicates too much adhesive.
8. Adhesive cures fully in 24 hours.
9. Squeeze-out can be removed with a sharp chisel, coarse sandpaper, or scraper.

WARNING! KEEP OUT OF REACH OF CHILDREN. ADHESIVE CONTAINS METHYLENE DIISOCYANATE. DO NOT GET ADHESIVE ON SKIN OR IN EYES.

CAUTION: Do not get on skin – cured adhesive *cannot* be removed. It is advisable to wear gloves when using this product. This adhesive can and will ruin clothing if spilled on it.

CLEAN UP: Liquid adhesive can be removed with mineral spirits and a rag – please be sure to follow the solvent manufacturer's instructions for use. Cured excess adhesive can be removed with a chisel, knife or sandpaper.

BONDER CURE TIME: Adhesive reaches handling-strength in 2-3 hours, and is fully cured in 24 hours at 75 degrees F temperature and 50% relative humidity.

QUICK-SET CURE TIME: Adhesive reaches handling-strength in 30-45 minutes, and is fully cured in 2 hours at 75 degrees F temperature and 50% relative humidity.

FOR BEST RESULTS: Apply clamp pressure to hold pieces in position while adhesive cures. Adhesive expands while curing to fill gaps. Clamp pressure will maintain proper bond line gaps and prevent movement.

STORAGE: Store in a cool, dry place. **DO NOT REFRIGERATE.** Keep tightly capped when not in use. After opening, to maintain good adhesive-cure performance, fill container-space above adhesive level with dry nitrogen or dried air before re-sealing.

SHELF LIFE: Minimum 6 months in un-opened container.

FIRST AID:

- Eye Contact – Flush with copious amounts of water for at least 15 minutes.
SEEK IMMEDIATE MEDICAL ATTENTION.
- Skin Contact – Wash affected areas with soap and water.
- If inhalation causes physical discomfort, remove person to fresh air.
- If discomfort persists, or if any breathing difficulty occurs, or material is swallowed,
SEEK IMMEDIATE MEDICAL ATTENTION

LAST-A-FOAM® QUICK-SET BONDER

DIRECTIONS FOR USE:

1. **Wear gloves when using this adhesive** – cured glue cannot be removed from skin.
2. Compressed-air blow or vacuum any dust or cutting debris from bonding surface. Bonding surfaces should be clean, dry, and free of any contaminants.
3. Apply liquid adhesive to **one side** of intended bond line. For best results, spread adhesive to form a **very thin coating** on foam-surface. A paint brush with bristles cut short works to accomplish this very easily. (The stiff-bristles move adhesive with little effort.)
4. **Spread material as far as it will go.** Avoid creating any puddles or thick build-up of adhesive. A thin coating will cause a barely-noticeable color change in the surface of the foam – this is desirable.
5. **Adhesive cures with moisture.** A (very) light misting of water over surface of the adhesive *can* be applied to slightly accelerate adhesive cure – but a little goes a long way with this fast-reacting formula. Excess water-spray will cause excessive squeeze-out and reduces adhesive-bond strength.
6. Set or clamp second piece of foam together with the first piece (the piece with the adhesive on it).
7. **Clamp together for at least 30-45 minutes.** Apply sufficient clamp pressure to fixture parts and **fully engage bonding surfaces.** A small amount of squeeze-out usually indicates adequate adhesive coverage. **This adhesive expands on curing** – large amounts of squeeze-out indicate too much adhesive has been used.
8. **Adhesive starts foaming 2 minutes after spreading. Adhesive squeeze-out is tack-free in 25 minutes. Bond-lines will have good handling strength in 45 minutes, with LAST-A-FOAM® Quick-Set Bonder reaching full-strength in 2 hrs.**
9. Squeeze-out can be removed with a sharp chisel, coarse sandpaper, or scraper.