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## DESCRIPTION

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STABOND U 290 is a moisture curing, 100% solids polyurethane adhesive system. This product has been successfully used for binding various surfaces such as: fiberglass, wood, EPS board, aluminum and steel.

## PROPERTIES

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TYPE:	URETHANE	HANDLING TIME:	5 MIN. AFTER WATER SPRAY
APPEARANCE:	CLEAR AMBER LIQUID	CURE TIME:	5 MIN. FOR HANDLING 1 HOURS FOR FULL STRENGTH
SOLIDS:	100%	OPEN TIME:	1 MIN. OVER ENTIRE TEMP. RANGE WITH CORRECT WATER APPLICATION
SHELF LIFE:	1 YEAR	CLEANER:	STABOND U CLEANER FOR WET ADHESIVE
WT/GAL:	9.1 LBS		
VISCOSITY:	7000 CPS @ 75° F		
APPLICATION TEMP.:	70° F TO 100° F		
BOND TEMP.:	-20° F to 250° F		

## APPLICATION

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STABOND U 290 urethane adhesive system is designed for extrusion application. Surfaces to be bonded must be free of dirt, oil, and grease. Apply a uniform wet film to the less porous surface only. The wet film thickness should be determined for each specific application; however, normally this will be between 3 and 10 mils. **ADHESIVE MUST BE SPRAYED WITH WATER MIST IN ORDER TO ACHIEVE A RAPID CURE RATE.** After spraying water mist onto adhesive, combine substrates before water can evaporate. Apply bonding pressure within 1 min. after water spray. Cure time for handling will be 5 minutes. Water mist levels required to obtain this speed of cure will vary from 1.1 gr/ft<sup>2</sup> at 70° F to 0.5 gr/ft<sup>2</sup> at 90° F.

## STORAGE

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Store at 70° F to 80° F. The air inside the containers should be purged with nitrogen and then tightly sealed. **DO NOT FREEZE.** If freezing occurs, heat to 120° F to ensure complete melting.

## CAUTION

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This compound is nonflammable. Vapors are harmful if inhaled. It may cause eye and skin irritation and allergic respiratory reaction. Avoid contact with eyes, skin, and clothing. Protect from moisture contamination. Moisture contamination can result in dangerous pressure building up in the container. **THOROUGHLY READ THE SDS FOR THIS PRODUCT PRIOR TO USING IT.**

## IMPORTANT

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Suggestions for the use of this product are based on tests believed to be reliable; however, the user should determine suitability for the intended use by his own evaluation. Because the use of the material is beyond our control, neither the seller nor the manufacturer shall be liable for any injury, loss, or damage, direct or consequential, arising out of the use or inability to use this product. Seller and manufacturer's sole obligation shall be replacement of material proved to be defective.