

TensorGrip®



TC49

INFUSION MOULDING HI-TAC
ADHESIVE FINE MIST SPRAY

TensorGrip® TC49 is a spray adhesive designed for the infusion mould market. With an immediate tack to hold the reinforcing fibres, you will also achieve a great surface finish with carbon fibre applications thanks to its fine mist spray properties. TensorGrip® TC49 is compatible with polyester, styrene and vinyl ester resins and has been successfully tested with epoxy resins using less than 9 grams of adhesive per sqm. The short open time makes TensorGrip® TC49 ideal for small area applications.

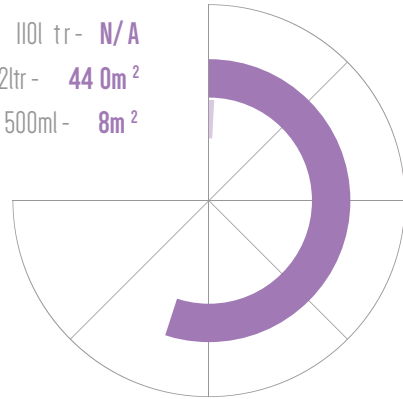
ADVANTAGES

- Extra Fine Mist Spray.
- Safely Fuses Laminating Materials To Structural Core Surfaces.
- Great Surface Finish Results.
- Superior Holding During Forming Process.

TECHDATA

SQUARE METRE COVERAGE (m²):

110l tr - N/A
22ltr - 44 0m²
500ml - 8m²



Fibreglass
Infusion



FRP/GRP



Thick Fabric



Thin Fabric

CHEMICAL TECHNICAL DATA

Viscosity	20.5 mm ² /s
Total Solids	29%
Colour	Clear or Green
System Flammability	Flammable adhesive in flammable propellant
Shear	> 320.89 p.s.i.
90° Peel (6.25 sq.cm)	> 29.3 p.s.i.
Shear adhesion failure temp. (SAFT) 100gram	> 80°C
Dry time	30 secs dependant on temp & humidity
Open time	5-10 mins
SHELF LIFE	18 months from date of manufacture

CANISTER STORAGE/CHANGE OVER

Turn valve on canister into the off position, spray out remaining adhesive left in the hose, disconnect the spray hose and gun from the canister. Reconnect the spray hose to a canister of cleaning solvent (sold separately) and spray out until liquid is clear which indicates that the hose and gun is clean. If you choose to leave the hose and spray gun on the canister, leave the valve on the canister open. Do not disconnect the hose/gun from the canister. Close and lock the spray gun.

HANDLING & STORAGE

- Consult Material Safety Data Sheet prior to use.
- DO NOT store at temperatures over 50°C.
- Avoid exposure to direct sunlight.
- DO NOT store directly on concrete floor.
- For optimum performance, store at 18°C during use, but must always be above 10°C.
- When connected, keep valve open and hose pressurised at all times.
- DO NOT close valve until ready to connect to new cylinder.
- Release pressure in hose before disconnection.
- Always test product to determine suitability for your particular application prior to use in production.

DIRECTIONS FOR USE

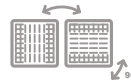
- This product is designed to be applied to one side of the surfaces to be bonded together, However, It can be used for double sided bonding where required. Make sure that surfaces are clean, dry and free from dirt, dust, oil, loose paint, wax or grease, etc. For best results, the temperature of the adhesive and the surfaces being bonded should be between 60 degrees F - 80 degrees F (16degrees C - 27 degrees C).
- Use with adequate ventilation. When possible we recommend shaking the canister well before using. Attach and secure hose tightly onto the spray gun with required tip. Attach the other end of the hose onto the canister. Make sure the hose-valve connections are securely tight. Open the valve on the canister slowly and fully, check for leaks during this process. Unlock the trigger on the spray gun to start spraying.
- Prior to use, check compatibility by spraying a small test patch of the adhesive on the substrate. This product may degrade some substrates.



1. Make sure that surfaces are clean, dry and free from dirt, dust, oil, loose paint, wax or grease, etc.



2. Spray about 10-20 cm (4" – 8") away at a 90 degree angle to the surface, applying a uniform, even coat of adhesive to obtain 80% to 100% coverage of the surface. If necessary, spray another coat of adhesive in areas that appear to need more adhesive.



3. Spray both surfaces to be bonded, one surface vertically and the other surface horizontally.



4. Allow 2 - 3 minutes for the adhesive to tack off until no adhesive transfers to the knuckle when touched.



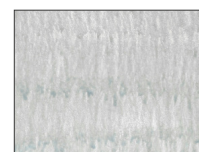
5. Adhere surfaces and press together with adequate pressure. A roller is recommended to apply a uniform pressure to achieve maximum strength. Allow 24 hours for the adhesive to fully cure.

6. If the spray tip clogs, unscrew the spray tip from the gun and clean with solvent such as lacquer thinner or acetone. Do not use a pin on the spray tip orifice.

COVERAGE



COVERAGE TOO LIGHT



COVERAGE TOO HEAVY



CORRECT APPLICATION =

20 dry gms/sqm