

ADHESIVE DESCRIPTION

Fiber Tack MT-1 is a NON-HAP proprietary reactive based polymer spray tack adhesive that is design to bond dry reinforcements and composite matrices including cores in place prior to introducing resin through various processes like resin infusion, RTM, VARTM, RTM Light or fiberglass pre-forms. MT-1 is uniquely formulated to be compatible, with most resin systems mainly polyester, vinyl ester and epoxy resins^{1, 2}. The product is solvent based and after spraying builds tack within seconds and will be tack free in approximately 2-3 minutes¹. Packaging options include pint sample, quart and 5 gallon or 55 gallon containers. Aerosol packaging options available!

KEY FEATURES

- Compatible with VE, Polyester and Epoxy²
- Limited to no loss in laminate properties at higher application levels
- Tack time 15-20 sec, tack free 2-3 minutes¹
- Mechanically bonds or holds most types of reinforcements
- Not affected by ambient temperature/humidity¹
- Maintains position of reinforcement for days without sagging
- Easy to clean up with most organic solvents
- Very effective tack mechanism
- Use less than competitive brands

TYPICAL ADHESIVE CHARACTERISTICS @ 75° F (24° C)

<u>Liquid Characteristic</u>	<u>Adhesive</u>
Gardner color:	1-2
Tack STT:	2-3 minutes
VOC g/l:	540-561g/l
VOC lb/gal:	4.5-4.68lb/gal
Viscosity, Zahn 2 cup:	15sec
Unit weight, lb/gallon:	7.5-7.8lb/gal

APPLICATION

Follow instructions provided or contact your Engineered Bonding Solutions representative for proper types of spray equipment and suitable substrates prior to starting the spray tack application. Open tack time is the approximate time after spray application until the product dries tack free. The user should only apply to an area that reinforcements will be adhered within corresponding tack time, see note 1. Tack time can and should be evaluated, prior to initial application. When using prior to vacuum assisted RTM or infusion process, all remaining solvent is completely removed. Product is packaged in easy to open containers; 5 gallon containers have a screw cap pour spout. Product does not settle and it is not necessary to mix before use. User will transfer contents to an air assisted HVLP type gun for best performance, there are other pressure pot spray units (but you need to spray fine mist and thus require atomization air). Typically applications of less than 15-30 gsm are adequate to sufficiently hold reinforcements and independent tests have not shown any measurable loss in physical properties. It is strongly recommended that the user test on their surfaces, gelcoats or fabric reinforcements to determine suitability and substantiate with physical testing. Contents are Highly Flammable, use in a well-ventilated area or use proper Personal Protective Equipment (PPE) and the use of a VOC respirator is recommended! *Read Material Safety Data Sheet before handling or using this product.*

IMPORTANT NOTES:

1. The tack time is dependent on temperature, colder temperature will increase the flash time for solvent and lengthen time to full tack and warmer conditions will decrease the effective tack time. Solubility of MT-1 and subsequent wetting of reinforcements are also affected by temperature, colder temperatures will have adverse effects on wet out of reinforcements solubility of MT-1 and should be avoided the best results are achieved $\geq 75^{\circ}\text{F}$.
2. Independent testing has shown little to no appreciable physical properties loss in bending shear testing at higher than normal applications (≤ 90 gsm) on VE and Polyester laminates. Using a typical infusion grade Bis A epoxy also has shown no appreciable loss in physical properties at normal application levels ≤ 30 gsm. Note higher applied levels on reinforcements that are infused with Epoxy resins may show drop in properties compared with styrenated polyester resins.

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