



LION GRIP

Adhesive / Adhésif

R 505

FEATURES AND BENEFITS:

LIONGRIP R 505 Hi-Temp Brush Grade has been specifically formulated for industrial use in bonding a wide variety of materials, including but not limited to: decorative laminates, metals (except copper), plywood, particleboard, polyurethane foam and rigid plastics.

R 505 provides easy and uniform coverage in all types and sizes of industrial operation. It is especially good for use where climatic conditions or ambient temperatures present bonding difficulties. Its high heat resistance coupled with its high ultimate strength gives R 505 the versatility for use ranging from general laminating to post forming operation.

CHARACTERISTICS:

R 505 is a superior brush grade contact bond adhesive designed for industrial applications. It features fast drying, high tack, long open time and outstanding combinability. Strength increases with time and heat.

For bonding decorative laminates, plywood, particleboard, metal, wood, leather and most other materials.

PHYSICAL PROPERTIES:

Base:	Neoprene
Solvent:	Blend of Hydrocarbons and Ketones
Solid Content (approx.):	21% +/- 1%
Viscosity:	1200 cps
Color:	Natural
Flash Point:	-4°F
Dry Time:	5 – 10 Minutes
Open Time:	60 Minutes
VOC:	602 grams/liter (EPA Method 24)
Shelf Life:	1 year in unopened container
Recommended Coverage:	210 sq. ft./ gallon bonded surfaces
Clean Up:	Lion Grip Cleaner/Thinner RS02020L, R009 or RCCAR

PACKAGING & COLOR:

R 505 20 11	Natural	5 gal / 19 liters
R 505 4 11	Natural	1 gal / 4 liters

DISCLAIMER OF WARRANTY:

Manufacturer and distributor of this product make no warranty, express or implied, including, but not limited to any implied warranty of fitness for a particular purpose. No warranty is made as to the use or effects incidental to such use, handling or possession of the materials herein described. User is responsible for determining whether this product is fit for a particular purpose and method of application and assumes all risk and liability associated herewith. Manufacturer liability is limited to replacement of product or reimbursement of purchase cost, at its sole discretion. No representative of ours has authority to change this provision which relates to all sales.
See Material Safety Data Sheet for Proper Handling and Safety Information

REV 5/14

LIONGRIP R505

Brush and Roller Adhesive Spray

APPLICATION:

1. Substrates should be clean and free of moisture, dirt, oil and other contaminants.
 2. For best results, adhesive and substrates should be allowed to acclimate to room temperature for 24 hours (approximately 60°F or above) before adhesive application.
 3. The adhesive can be applied with a solvent-resistant brush, or a ¼" short-nap roller.
 4. The adhesive should be applied at approximately 3.0 dry grams/square foot. The adhesive should cover 100% of the substrate surface. The substrate surface should exhibit a uniform glossy sheen when the adhesive is completely dry. Dull areas indicate insufficient coverage. Adhesive should be reapplied to these areas.
 5. When bonding porous substrates, it is advisable to apply two coats of adhesive. The first coat will act as a sealer and prevent excessive absorption of adhesive into the substrate. After the first coat has dried, apply a second coat. Allow the second adhesive coating to dry completely before assembly.
 6. Allowing the contact adhesive to dry completely before assembly is essential to obtaining a secure, permanent bond. To check for adhesive dryness, press the back of your fingers onto the adhesive surface. If adhesive transfers to fingers, additional dry time is necessary. If there is no adhesive transfer, the substrates are ready for bonding.
 7. If areas exist with excessive adhesive deposition, twist the fingers while pressing them onto the adhesive layer. This will break any skin that may have formed as the adhesive dries from the top surface down. If a skin has formed, allow additional dry time to ensure complete evaporation of the solvent before bonding.
 8. Dry times can be improved through the use of air movement, drying ovens, lamps, etc.
 9. Substrates may be indexed together and bonded once the adhesive is dry. Bonds must be made within the open time of the adhesive. (Open times vary by adhesive. See Page 1.)
 10. Uniform pressure on the bonded laminates is necessary to create strong, lasting bonds. 40 pounds per linear inch is recommended to ensure complete fusion between the two layers of adhesive. A pinch roller is the ideal method for applying uniform pressure. When used properly, a J-roller can also provide sufficient pressure for bonding.
 11. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed and machined
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APPLICATION PRECAUTIONS:

Do not use in applications with copper or aluminum components.

Do not use on polystyrene foams or plasticized vinyls.

Do not mix with other adhesives. Thinning the adhesive is not recommended.

STORAGE:

Rotate stock, use oldest first.

Keep covered to prevent solvent loss and contamination.

Store product between 60 – 80°F.

Do not freeze. If frozen, return to room temperature prior to use.

If frozen, slight agitation may be required after returning to room temperature.