

Technical Data

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(Supersedes all previous Data Pages)

## Industrial Mastic 959

### FEATURES

- Light colored mastic adhesive.
- Quick setting, excellent wet strength.
- Dries to a tough, flexible, water resistant state.
- Bonds a variety of materials including glass and many metals and plastics.
- Used extensively for mirror bonding.

**Note:** Since the type and quality of mirror backings varies, it is recommended that this product be tested for staining over a one week period on a representative mirror specimen.

### TYPICAL PHYSICAL PROPERTIES

**Note:** The following technical information and data should be considered as representative or typical only and should not be used for specification purposes.

<b>Viscosity (approx.):</b>	80,000 – 200,000 cps
<b>Brookfield Viscometer:</b>	RVF #7 Sp. @ 10 rpm @ 80°F
<b>Solids Content (by wt.):</b>	55-68%
<b>Base:</b>	SBR
<b>Color:</b>	Cream
<b>Net weight (approx.):</b>	8.6 – 9.0 lbs./gal.
<b>Flash point:</b>	-14°F (T.C.C.)
<b>Solvent:</b>	Petroleum Distillate acetone, toluene

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## HANDLING/APPLICATION INFORMATION

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### Direction For Use:

1. **Surface Preparation:** Surface must be clean, dry and dust free. Wiping with solvent such as Scotch-Grip™ Solvent No. 3 or Methyl Ethyl Ketone (MEK) will aid in removing oil or dirt.\*
2. **Application:** This product is best applied by spatula, notched trowel or pressure-flow. "Butter" or trowel mastic to one surface. Bond within 5-10 minutes after spreading adhesive, pressing firmly to ensure intimate contact at all points.
3. **Drying Time:** Under normal drying conditions maximum strengths are usually achieved within 72 hours after bonding on porous surfaces with some exposure to air.
6. **Cleanup:** Excess adhesive may be removed with solvent such as Scotch-Grip Solvent No. 2 or MEK.\*

\*When using solvents, extinguish all sources of ignition and observe manufacturer's directions and precautions for handling such materials.

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## APPLICATION EQUIPMENT SUGGESTIONS

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Appropriate application equipment enhances adhesive performance. We suggest the following application equipment for the user's evaluation in light of the user's particular purpose and method of application.

1. **Pumping:** A 9:1 ratio minimum, ball check type valve, 11 cu. in. displacement per cycle with a double acting 4½ air motor minimum. Use an inductor type follower plate with elevator. Packings and glands, in contact with the adhesive should be Teflon.\*  
  
\*Teflon is a registered trademark of E.I. Dupont deNemours Co.
2. **Hoses:** Hoses, pipe fittings and pipe used to convey this material must be capable of withstanding the pressures developed by the recommended pump. All hoses should be nitrile, polysulfide or nylon lined.
3. **Flow Guns:** Tip seal type flow gun with ⅛" tip.
4. **Pressure Filling Caulking Guns:** Use same equipment as Nos. 1, 2 and 3 above.
5. **Manual Filling Caulking Guns:** Kenmar Manufacturing Co. Model 4T, Aro Corp. Model 611-402 hand gun filler with follower plate or Graco Model 225-975 gun loader with follower plate.

## APPLICATION EQUIPMENT SUGGESTIONS (continued)

6. Reference Information: Material temperature 60°F, tip seal flow gun with 1/8" tip.

Hose Assembly	Material Pressure psi	Output Lb./Min.	Material Pressure psi	Output Lb./Min.
Ten Foot Length 3/4 I.D. Hose	540	4.0	198	.9
Twenty Foot Length 3/4 I.D. Hose	720	4.2	198	.36
Twenty Foot Length 3/4 I.D. Hose + Ten Foot Length 1/2 I.D. Hose	810	2.8	198	.13
Twenty Foot Length 1/2 I.D. Hose	810	2.0	198	.1
Ten Foot Length 1/2 I.D. Hose	810	3.9	198	.18
Ten Foot Length 1/2 I.D. Hose + Ten Foot Length 3/4 I.D. Hose	810	.2	198	0
Twenty Foot Length 1/4 I.D. Hose	810	.05	—	—

Note: Material pressure = operating air pressure x pump ratio.

## TYPICAL ADHESIVE PERFORMANCE CHARACTERISTICS

### Overlap Shear Strength—1/8" Birch/Birch

Time @ 75°F	Test Temp	Value (psi)
3 weeks	75°F	134
3 weeks	180°F	7

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## STORAGE AND SHELF LIFE

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### Storage:

Store product at 60-80°F for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures cause increased viscosity of a temporary nature. Rotate stock on a "first in-first out" basis.

### Shelf Life:

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 9 months.

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**PRECAUTIONARY INFORMATION:** Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product.

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For Additional Product Safety and Health Information:  
See Material Safety Data Sheet or call

78-6900-2824-2

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