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HALLTEX 3290 *Technical Data Sheet*

Halltex 3290 is a water-based contact cement with a synthetic elastomer base.

PHYSICAL CHARACTERISTICS

Total solids %:	49.5 – 52.5
Viscosity @ 24°C, cps:	4000 – 8000
Relative Density:	1.09 – 1.11
VOC:	28 – 33 g/L (2.6 – 3.0%)
Colour of Dried Film:	Light, Translucent
Cleaner:	Water (wet), **Hallmark 80** (dry)
Shelf Life:	6 months

APPLICATIONS AND FEATURES

Halltex 3290 is a water-based contact cement with excellent adhesion to a variety of substrates such as high-pressure laminates (arborite, formica), wood, metals, fibrous materials, foamed plastics, canvas, etc.

The product is brushed or rolled onto both substrates and allowed to air dry or dried by passing through a suitable oven. After drying, the substrates can be bonded immediately or up to 4 hours later.

Bonds made with **Halltex 3290** can withstand temperatures up to 130°C and are resistant to moisture, grease, and oil.

FURTHER INFORMATION

In many ways, water-based contact cements are similar to solvent-based products. Once the water or solvent carrier is removed or dried out of the adhesive, the remaining solid portion of the adhesive performs in a comparable manner. With **Halltex 3290**, water is the carrier and under normal room temperatures and humidities, approximately

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30 minutes drying time should be allowed before attempting to make a bond. High temperatures from heat lamps or drying tunnels will speed up the drying process. High humidity will slow the drying process. After the cement is dry – colour will change – the coated surfaces must be brought together and mated with enough pressure to ensure adequate contact and bonding over the entire surface. After the adhesive is dry, bonding should be completed within two hours. Bonds can be made as soon as **Halltex 3290** is dry but the longer it takes to make the bond, the stronger the initial strength will be.

Temperature of **Halltex 3290** and surfaces during fabrication must be at least 19°C (65°F). Stir gently but thoroughly before use. Apply a uniform coat to both surfaces using a nylon brush, texture-type paint roller or spray. One coat is usually sufficient with most materials; however, very porous surfaces may require more than one coat. Allow **Halltex 3290** to dry completely between coats. Dull spots when dry indicate insufficient adhesive. A uniform, glossy film indicates sufficient adhesive. If the two coated surfaces do not grab immediately when brought into contact, the adhesive has dried too long or not enough was used. Another coat of adhesive applied to each surface and allowed to dry properly will correct the situation.

Solvent-based cements and adhesives which are partially or completely dry will become soluble when exposed to similar wet product or to the solvent used in the original product. **Halltex 3290**, once it has become partially or totally dry, is not soluble in water, and as a result provides high water-resistant properties. This lack of solubility is one of the reasons it is extremely important to ensure that it does not have an opportunity to dry when present in any part of a spray system. Should the system require maintenance, which would expose the internal components of the spray guns, fluid lines, or pump to air, the spray system should be drained and flushed with a warm soap solution (Pine-Sol, Lestoil-type, etc.) and water. (Recommended mix: 1 pint Pine-Sol to 5 gallons water). **Do not use hot water**. Hot water may cause coagulation of the rubber spray nozzles. Alternatively, sections of the system may be plugged or capped to prevent drying out of the adhesive.

Viscosity control through use of a fluid heating system is not recommended or necessary when spraying **Halltex 3290**. Our product should be used as received. Uncontrolled dilution with water may create potential instability of the adhesive. Also, the presence of water in the system may produce the potential for corrosion or reaction with untreated metal.

Under normal operating conditions, the spray system should be maintained full with adhesive on a continuous basis. All connections should be air tight. Care must be taken in tightening metal PVC connections to avoid stripping threads on PVC nipples and bushings. Do not use fluid lines that have previously been used with solvent whether flammable or non-flammable. All material hoses should be polyethylene or nylon-lined.

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Do not use “rubber” lined hose. Packings and glands in contact with the adhesive should be made of Teflon. All hose and pipe fittings should be stainless steel, nickel-plated, or plastic. Do not use unplated brass or steel fittings.

Halltex 3290 must be protected from frost both in transit and storage. We recommend that the product be kept above 8°C (45°F). Frozen product will show coagulated adhesive suspended in the remaining liquid. If used, adhesion would be unacceptable and excessive plugging of filters and spray guns would occur. Ideal storage temperature is between 15 – 26°C (60 – 80°F). Prolonged storage at high temperatures will shorten our recommended shelf life of six (6) months. Floor stock should be rotated on a “First In-First Out” basis.

The high solids content of **Halltex 3290** will result in excellent coverage. On a non-porous surface, a dry film 1 mil thick will provide coverage of 900 square feet per gallon of single glue line.

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