



LION GRIP

Adhesive / Adhésif

R 518

FEATURES AND BENEFITS:

LIONGRIP R 518 is an economy grade, high solids and fast drying contact adhesive designed for flat work. It makes a great choice for most permanent adhesive applications wood, plastic laminates, gypsum, metals (except copper) and many other products.

R 518 bonds well to a wide variety of substrates. It has tack, is flexible, non-wrinkling and waterproof. Use for decorative laminates, edgebanding wood, veneers, foam, headliners, fiberglass and plastic.

CHARACTERISTICS:

R 518 has exceptional tack and shear strength, high heat and UV stability; water resistance, fast drying, precise application control, and long open time. Adhesive and surfaces should be at least 60°F or higher for best results.

PHYSICAL PROPERTIES:

Base:	Neoprene
Solvent:	Organic Solvents
Solid Content (approx.):	17.5% +/- 1%
Viscosity:	210 cps
Color:	Natural/Red
Flash Point:	-20°F
Density:	7.01 lbs/gallon
Dry Time:	3 – 5 Minutes
Open Time:	60 Minutes
VOC:	575 grams/liter (EPA Method 24)
Shelf Life:	1 year in unopened container
Recommended Coverage:	133 sq. ft./ gallon bonded surfaces
Clean Up:	Lion Grip Cleaner/Thinner RS02020L, R009 or RCCAR

PACKAGING & COLOR:

R 518 20 11L	Natural	5 gal / 19 liters
R 518 20 80L	Red	5 gal / 19 liters
R 518 54 11L	Natural	54 gal / 205 liters
R 518 54 80L	Red	54 gal / 205 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 warrantee 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 R518

Economy Adhesive Spray Grade

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 (approximately 60°F or above) before adhesive application.
3. The adhesive should be applied at approximately 2.5 grams/square foot. The adhesive should cover 80% 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.
4. 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.
5. 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.
6. 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.
7. Dry times can be improved through the use of air movement, drying ovens, lamps, etc.
8. 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).
9. 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.
10. All contact adhesive bonds are immediately able to be routed, trimmed, cut, filed and machined.

SPRAY INFORMATION:

	Manual	Systems	Automatic	Systems
	Binks	DeVilbiss	Binks	DeVilbiss
Spray Gun	95, 2001, 2100	JGA510, MSA510	21,95A	AGX550
Fluid Tip	63B-SS	FX	63C-SS	FX
Fluid Needle	663A, 563A	FX	263A, 663A	FX
Air Cap	66SD-3	24	66SD-3	24

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.
- Do not freeze. Store product between 60 – 80°F
- If frozen, return to room temperature prior to use.
- If frozen, slight agitation may be required after returning to room temperature.