

FREEDOMTUFF™ FT-9390

PRODUCT DESCRIPTION

FT-9390 is a next generation, 100% solids, flexible, fast-curing, two-component polyurethane adhesive with high peel and shear strength. **FT-9390** features a 90-second cure time.

USES

- Tile adhesive
- Polyurea repair
- Wood glue
- Construction adhesive

ADVANTAGES

- High Solids (<100 g/L VOC)
- High bond strength
- No noxious odors
- USGBC LEED, EQ Credit 4.2 and 4.3: Low-emitting VOC Compliant Materials

COLOR

Opaque off-white

TYPICAL PHYSICAL PROPERTIES

Property	Test Method	Value
Mix Ratio by Volume	NA	1:1
Gel Time	NA	80-100 seconds
Tack Free Time	NA	120-150 seconds
Time to Handle	NA	5-7 minutes
Shore Hardness	ASTM D2240	65D

The values stated in this Product Data Sheet are based on system processing under controlled laboratory conditions. Equipment configuration and/or field application conditions may produce variances in the installed product values

SURFACE PREPARATION

For high strength structural bond, all surface contaminants must be completely removed (i.e., paint, oxide films, oils, dust, mold, release agents, and any other surface contaminants that could interfere with adhesion).

The following cleaning and preparation methods are suggested for common surfaces.

Steel or Aluminum

1. Wipe surfaces free of dust with oil-free solvent such as acetone or alcohol.
2. Sandblast or abrade using clean, fine grit abrasives (180 grit or finer).
3. Wipe again with solvents to remove loose particles.
4. If a primer is used, it should be applied prior to the formation of "flash rust" (dependent on environmental conditions).

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MIXING & APPLICATION

General Information:

- For optimal results, only proceed with application while air and substrate temperatures are between 40°F and 95°F. Ensure that the substrate temperature is at least 6°F above the dew point and rising.
- For maximum bond strength, apply product evenly to both surfaces to be joined.
- Join the adhesive-coated surfaces together and allow to cure at temperatures of greater than or equal to 60°F until firm. Heat less than or equal to 200°F may be applied to reduce cure time.
- Keep parts from moving until handling strength has been achieved. Contact pressure is necessary during curing process. Maximum shear strength is achieved with a 3-5 mil bond line. Maximum peel strength is achieved with a 17-25 mil bond line.
- Excess uncured adhesive can be cleaned using ketone-type solvents.
- Adhesive Coverage: A 0.005-inch thick bond line will typically yield a coverage of 320 ft² per gallon.
- High/low temperatures and/or humidity can significantly impact gel and cure times.

PACKAGING

- 200 mL side-by-side cartridges
- 600 mL side-by-side cartridges

CLEAN UP

User is responsible for reading, understanding, and following all recommendations on SDS. Dispose of all packaging and containers in accordance with local, state, and federal laws and regulations. Excess liquid materials should be mixed and allowed to cure. Once cured, dispose of cured material in accordance with local, state, and federal laws and regulations.

LIMITATIONS

The end user should check the suitability of this product prior to its application. Freedom Chemical Corporation assumes no liability for substrate defects.

SHELF LIFE & STORAGE

Shelf life is one (1) year from the date of manufacture in original, unopened, factory-sealed containers under specified storage conditions.

Shipping and storage temperatures is 65°F to 90°F at (or below) 50% Relative Humidity. Avoid freezing temperatures. Do not store containers directly on ground. Always store on pallets or otherwise elevated.

Do not open containers until ready to use. Partially filled containers should be purged of air using nitrogen blanketing and sealed tightly when not in use.