

SabreGrip™

Spraying Manual



Contents

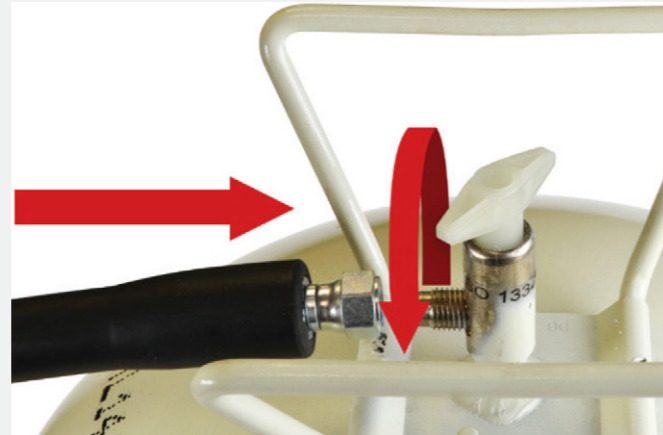
Setup Preparations	3
Web Spray	4
Mist or Pebble Spray	6
Changing to a new Canister	8
Disposing of Empty Canisters	9

Setup Preparations



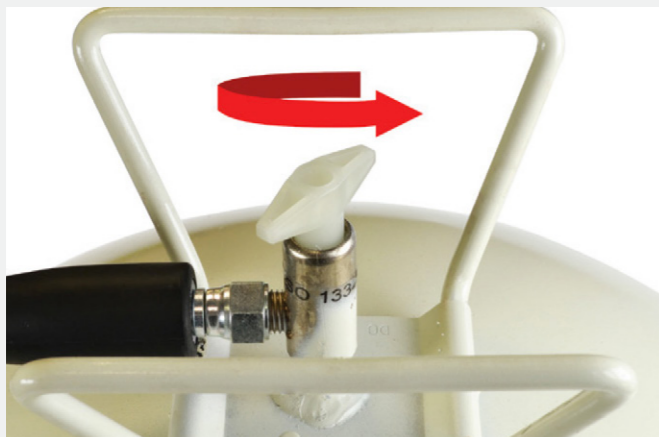
STEP 1

Screw the larger hose nut to the gun thread (clockwise) and fully tighten with a spanner. Check hose is securely attached.



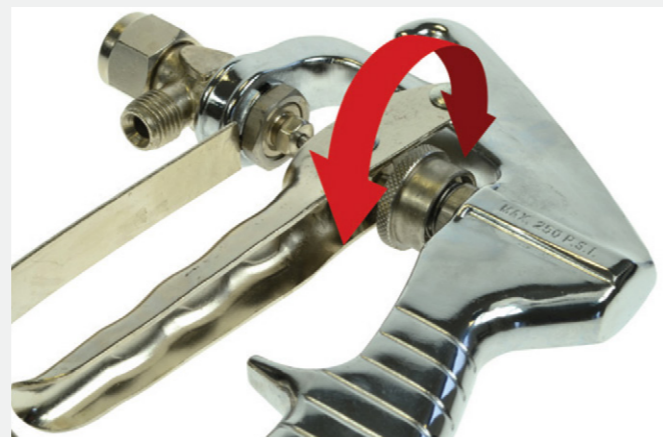
STEP 2

Screw the smaller hose nut to the canister valve (clockwise) and fully tighten with a spanner. Check the hose is securely attached.



STEP 3

Turn the canister valve anticlockwise until fully open. Check connections for any leaks and if any occur, tighten connections. DO NOT TURN THE CANISTER VALVE OFF UNTIL THE CANISTER IS EMPTY (this is to prevent the adhesive curing in the hose and gun).



STEP 4

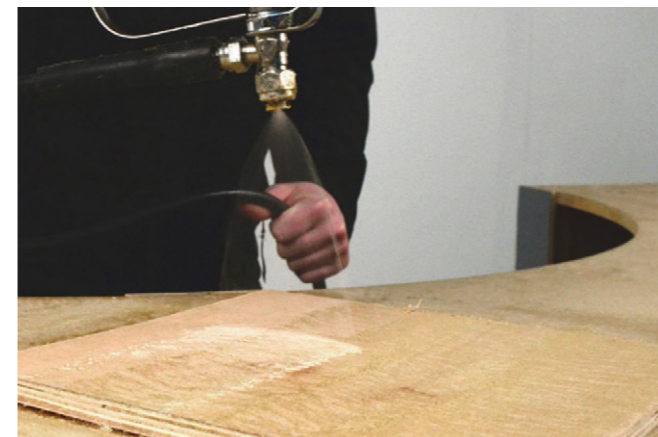
On initial use, or if the product has been standing for more than 12 hours, purge the hose. Pull the trigger and adjust the flow by turning the adjustment screw behind the trigger (anticlockwise to open and clockwise to close). Dispense and discard adhesive until a consistent spray is achieved.

Web Spray



STEP 1

Prepare the surface to be bonded; ensuring both faces are clean, free of dust, dirt and grease. If necessary wipe clean with proprietary solventbased cleaner. DO NOT USE WHITE SPIRIT, MINERAL TURPENTINE OR CITRUSBASED CLEANERS.



STEP 3

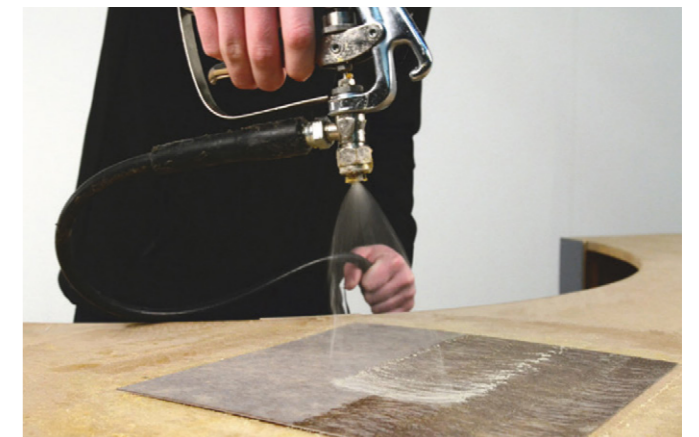
Maintain a constant speed of application during spraying, do not allow the adhesive to puddle or heavily 'wet' the surface. Maximum bond strength is achieved with coverage of 80-100%, and a minimum coat weight of 20 dry grams per m².

Application



STEP 2

Hold spray gun at a constant distance of between 100-250mm from the surface, spray the surface with approx. 50-70% overlap to successive passes for thin laminates to reduce risk of telegraphing (note: correct coverage must be achieved).



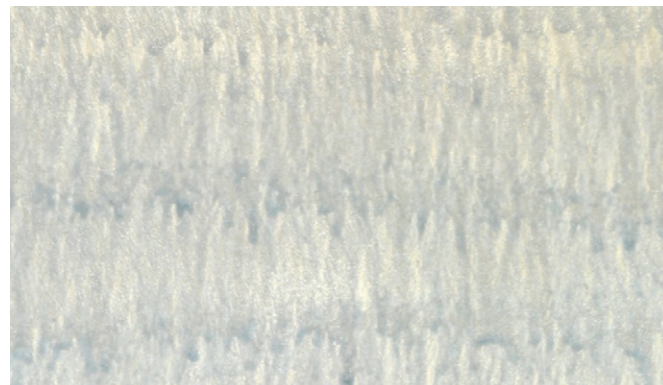
STEP 4

Maximum adhesion will be obtained by spraying mating faces at 90° to each other, i.e. one face vertically, the other face horizontally. Double coating perimeter of face and edges is recommended, including areas around subsequent cutting positions.

Web Spray



COVERAGE TOO LIGHT



COVERAGE TOO HEAVY



CORRECT APPLICATION = 20 dry gms/sqm

Bonding Techniques



75mm HAND ROLLER

- Do not angle spray gun or move in an arc while spraying. Hold gun at 90° to surface. Release trigger at end of each pass to optimize coverage.
- Many man-made boards such as plywood, flexi-ply and MDF are very absorbent and will need a primer coat (shown in 'COVERAGE TOO LIGHT' picture). Allow to dry, then apply the normal 'CORRECT APPLICATION', as shown, over top of primer coat.
- Some substrates can be difficult to bond, e.g. metal faced HPL, Colorcore etc. or products with memory (soft and thick materials may require 2 or 3 coats). Best results are obtained by multiple coats rather than one heavy coat which may result in heavy wetting and extended drying times. Always test before using in production.
- Allow adhesive to dry. Test for dryness using back of hand only; surface should be tacky but adhesive should not transfer to skin. Position substrates correctly and press together working from centre outwards. Apply adequate pressure using nip or hand roller as a minimum in order to achieve at least 35psi at glue line. Note; repositioning is NOT possible after bonding.
- Immediate trimming/routing is possible. Full strength is achieved after 24-48 hours depending on temperature and humidity.

Mist or Pebble Spray Application



STEP 1

Prepare the surface to be bonded; ensuring both faces are clean, free of dust, dirt and grease. If necessary wipe clean with proprietary solventbased cleaner. DO NOT USE WHITE SPIRIT, MINERAL TURPENTINE OR CITRUSBASED CLEANERS.



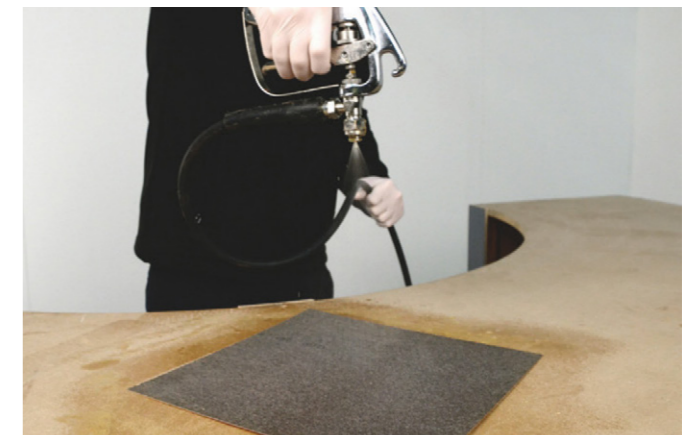
STEP 3

Maintain a constant speed of application during spraying, applying a thorough coating without allowing the adhesive to puddle or heavily 'wet' the surface. Maximum bond strength is achieved with coverage of between 80-100%. Recommended minimum coat weight - 20 dry grams per m².



STEP 2

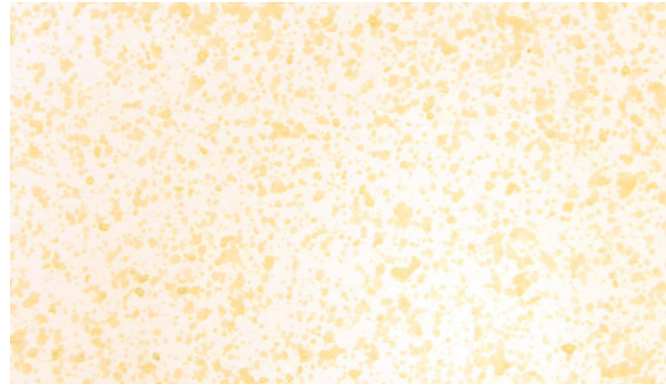
Hold spray gun at a constant 200-400mm from the surface, allowing the adhesive to droplet across the surface with approximately 50-70% overlap to successive passes for thin laminates to reduce risk of telegraphing (note: correct coat weight must be achieved).



STEP 4

Maximum adhesion is obtained by spraying mating faces at 90° to each other, i.e. one face vertically, the other face horizontally. Double coating perimeter of face and edges and cutting positions is recommended.

Mist or Pebble Spray Bonding Techniques



COVERAGE TOO LIGHT



75mm HAND ROLLER



COVERAGE TOO HEAVY

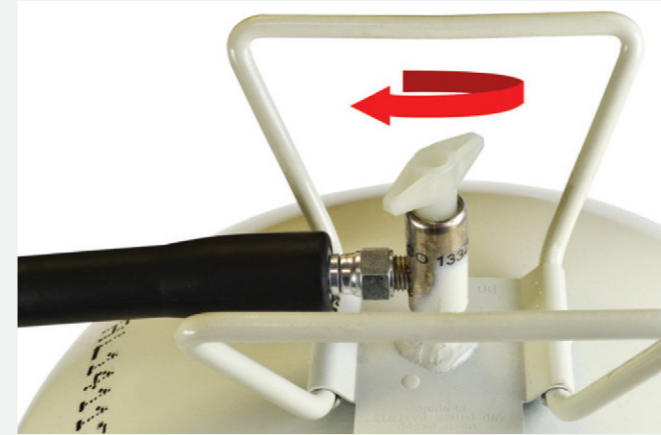


CORRECT APPLICATION = 20 dry gms/sqm

- Do not angle spray gun or move in an arc while spraying. Hold gun at 45° to surface while spraying. Release trigger at end of each pass to optimize coverage.
- Many man-made boards such as plywood, flexi-ply and MDF are very absorbent and will need a primer coat (shown in 'COVERAGE TOO LIGHT' picture). Allow to dry, then apply the normal 'CORRECT APPLICATION', as shown, over top of primer coat.
- Some substrates can be difficult to bond, e.g. metal faced HPL, Colorcore etc. or products with memory (soft and thick materials may require 2 or 3 coats). Best results are obtained by multiple coats rather than one heavy coat which may result in heavy wetting and extended drying times. Always test before using in production.
- Allow adhesive to dry. Test for dryness using back of hand only; surface should be dry and adhesive should not transfer to skin. Position substrates correctly and press together working from centre outwards. Apply adequate pressure using nip or hand roller (Note; repositioning is NOT possible after bonding).
- Immediate trimming/routing is possible. Full strength is achieved after 24-48 hours depending on temperature and humidity.

Changing to a New Canister

Important: safety glasses and gloves must be worn during the disposal process.



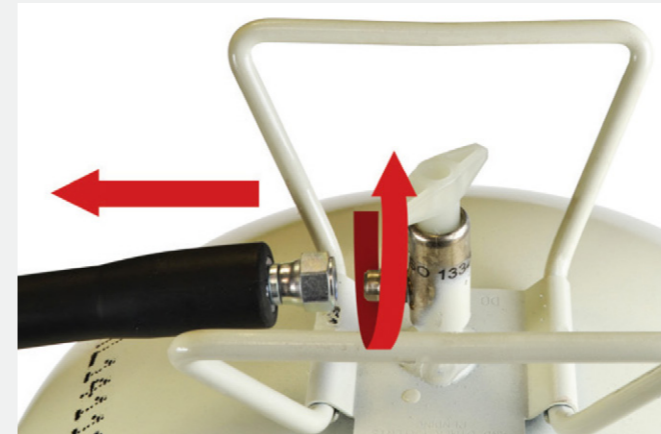
STEP 1

Turn the canister valve clockwise until fully closed.



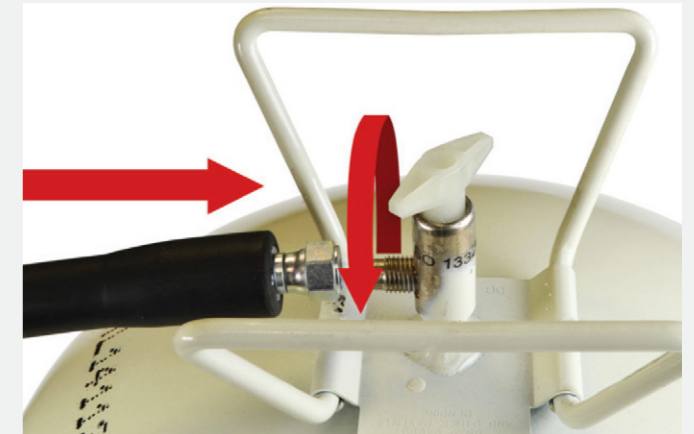
STEP 2

Pull the trigger on the gun and hold until hose is drained to expel residual pressure.



STEP 3

Unscrew the hose nut and disconnect the hose from the empty canister (move to next page for canister disposal).



STEP 4

Connect the hose and gun to the new canister (go to Step 2 of PREPARATION and follow the process through to Step 4).

Important note: this process should be followed through immediately and adhesive should be dispensed from the new Canister or the gun and hose will block and become unusable.

If you are not transferring the hose and gun to a new canister you will need to flush it with solvent to ensure it can be used again on future jobs.

Disposing of Empty Canisters



STEP 1

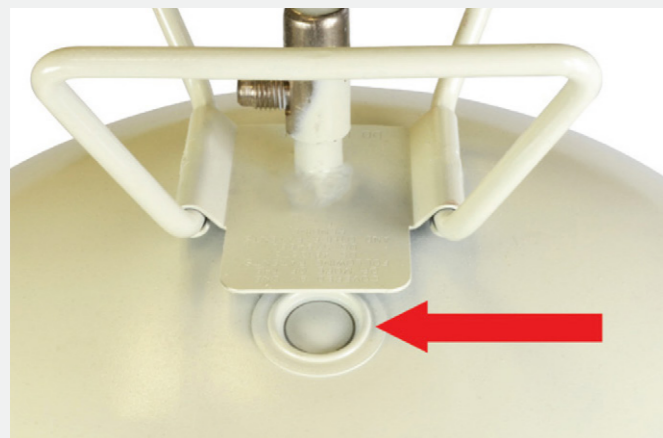
Lay the empty canister on its side with the valve pointing AWAY from the operator, and well away from sources of ignition.

STEP 2

Open the canister valve and release any residual pressure.

STEP 3

Stand canister upright. Use a hammer and brass punch or other non-sparking instrument to puncture the friable disc.



STEP 4

As long as the user is able to accept responsibility for depressurising the canister, it can be disposed of as per normal scrap metal disposal (subject to local waste regulations).

STEP 5

Find out where you can recycle your canister at <http://recyclingnearyou.com.au/>

Transport Information



During transport, the recommended PPE (Refer to MSDS), First Aid Kit and suitable Fire Extinguisher should be readily accessible in the vehicle.

Keep vehicle well ventilated at all times.

Secure canister during transportation

GUARANTEE

Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product. Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions. The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.



Sabre[®]

Good bonds last.

New Zealand

+64 6 366 0007
40-42 Cambridge St South
Levin 5510

Melbourne

+61 3 8657 5507
67 Gateway Blvd
Epping, VIC 3076

Sydney

+61 2 9098 8244
Level 6, 10 Herb Elliott Ave
Sydney Olympic Park, NSW 2127