

**Product Data Sheet      TIC 6080      Rubber Contact Adhesive**

**Description**

**TIC 6080 Rubber Contact Adhesive** is a quick setting nonflammable fire-resistive, synthetic elastomeric adhesive used to adhere duct wrap, fibrous glass or mineral wool insulations to galvanized steel and aluminum air conditioning or hot air ducts, where a fire resistive dry film is required. Non-flammable chlorinated solvents eliminate explosion and fire hazards during application.

**TIC 6080 Rubber Contact Adhesive** adhere insulation to wood and concrete. In this application, the coverage may not as great as shown at left.

**TIC 6080 Rubber Contact Adhesive** gives superior service when it is used as contact adhesive to cement the laps of aluminum foil, FSK, ASJ, and FRK facings.

**TIC 6080 Rubber Contact Adhesive** contains no asbestos, lead, mercury, or mercury compounds.

**Properties**

Property	Specification	Test method
Color	Beige	TSTM-01
Application	Brush	TSTM-06
Density	1.34 ± 0.05 Kg/ℓ	ASTM D 1475
Volume non-volatile	25 ± 1 %	ASTM D 1644
Weight non-volatile	30 ± 1 %	ASTM D 1644
Coverage	1.0 Kg/m <sup>2</sup> (0.8 ℓ/m <sup>2</sup> ) Dried film thickness: 0.2 mm	TSTM-07
Bonding time	5 ~ 60 minutes	TSTM-17
Service temperature limits	(Temperature at coated surface) -196 °C ~ 93 °C (-321 °F ~ 200 °F)	TSTM-04
Wet flammability	≥ 40 °C (104 °F)	ASTM D 93
Surface burning characteristics	Classification: CLASS A Flame spread: 15 (0~25) Smoke developed: 5 (0~450) Surface: Applied over fiber reinforced cement board at a coverage rate of 25 sq.ft/gal (0.61 m <sup>2</sup> /ℓ)	ASTM E 84

**Limitations**

Store and apply between 4 °C (40 °F) and 38 °C (100 °F).

Always test plastic and painted materials for compatibility then using a solvent base product.

Do not use with flexible PVC.

Make certain this product is completely dry and the area free from solvent odor if food is involved.

**Application**

**Material Preparation**

Stir well, DO NOT THIN. Not need prime aluminum or galvanized metal. Apply only to clean, dry, dust-free surface. Keep container closed when not in use to prevent solvent evaporation. Do not use pumps or equipment that has aluminum parts in contact with the adhesive.

**Application**

- 1. Insulation Attachment** - The metal surface shall be coated by brush with TIC 6080 Rubber Contact Adhesive at coverage of 200 sq.ft/gal (4.9 m<sup>2</sup>/ℓ). Allow an open time of 5 to 60 minutes to develop full tack. Install insulation, apply pressure to assure complete and uniform contact to the metal surface.

The above application suggestions do not preclude the use of additional mechanical fastening as recommended by insulation manufacturer or required by design engineer.

- 2. Lap, Butt Strip, and Pin Patch Sealing** - All longitudinal and butt joint laps of facing shall overlap a minimum of two inches (5 cm). Apply a brush coat of Rubber Contact Adhesive at the rate of 75 sq.ft/gal (1.8 m<sup>2</sup>/ℓ). Allow an open time of 2 to 10 minutes to develop full tack.

Alternate - Apply a brush coat of Rubber Contact Adhesive at the rate of 150 sq.ft/gal (3.7 m<sup>2</sup>/ℓ) to each surfaces. Allow an open time of 5 to 60 minutes to become tacky.

Bond laps by applying uniform pressure, smoothing out to avoid wrinkles and gaps.

- 3. Brush** - Use a good brush (suitable for chlorinated solvents), making strokes as long as possible. Do not overwork.

**Clean-up**

Use xylene (flammable) or chlorinated solvent (non-flammable) for cleaning equipment.

**Note**

**Important:** We make no other warranties and expressly disclaim any warranties of merchantability or fitness for a particular purpose. If a product fails to meet this limited warranty, purchaser's sole and exclusive remedy is replacement of the product or, at our option, refund of the purchase price. Our acceptance of any orders for the product is expressly conditional upon purchaser's assent to the terms on the applicable invoice.

**Adequate Tests:** The information contained herein we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be perform by you to determine if this product meets all of your requirements. The warranted shelf life of our products is six months from date of shipment to the original purchaser.

**TIC CORPORATION**

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