



The Dependable and Durable Adhesive from the leader in PU solutions – Foam Supplies.



Entry and garage doors. Recreational vehicle components. Building and construction products like structural insulated panels (SIPs). For these commercial adhesive applications and many more, nothing meets the challenge like OnePart – the industrial strength adhesive from Foam Supplies, Inc.

OnePart is part of a family of FSI urethane adhesives designed with uncompromised quality. It's been proven effective, time after time, for many industrial and commercial applications, and in fact, is a more efficient and economical option to traditional tube and caulk applications.

What's more, OnePart is also environmentally benign. It's VOC exempt, formaldehyde-free and does not contribute to global warming or ozone depletion. Plus, OnePart adhesive has third party certification for various testing requirements including, but not limited to, IM 022, CA 25-4 Standards and ASTM E 72.



PHYSICAL PROPERTIES

- Type: Moisture-Cure Urethane Adhesive
- Color: Brownish
- 100% Solids
- Net Weight: 9.3 lbs/gal
- Viscosity (cps @ 77°F/25°C): 4,300 - 4,900
- Reactivity Range:
 - Open Time: 30 sec - 47 min
 - Set-Up Time: 1 min - 95 min
- Storage Temperature: 50 - 90°F
- Six-month shelf life

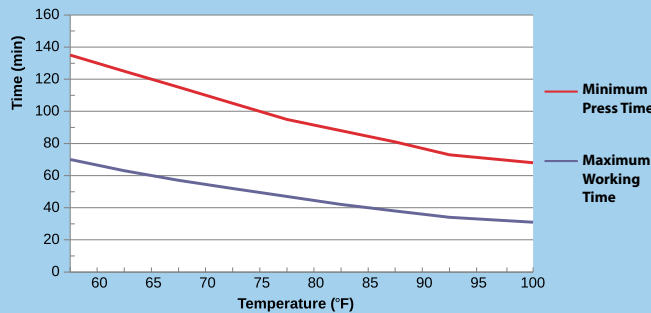
KEY BENEFITS

- Good Mechanical Properties
- No Fillers
- Third Party Certified
- Large Range of Reactivities
- Various Delivery Methods
- Worldwide Availability
- Environmentally Benign
 - Zero Global Warming
 - Non Smog Producing
 - Zero Ozone Depleting
 - Formaldehyde Free

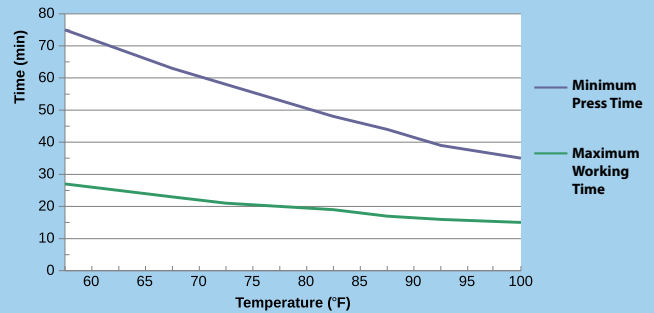
CERTIFICATIONS

- CA 25-4 Standards
- ASTM E 72-80
- ASTM C 557
- ICC-ES AC0005-05
- IM 022/AC05
- IM 036/AC04

Estimated Cure Time for OnePart 47



Estimated Cure Time for OnePart 20



Specifications (from PEI Listing Report)

TABLE 1: NOMINAL APPLICATION SPECIFICATIONS

Adhesive	Application Method	Adhesive Applied	Water Applied	Ambient Temp.	Ambient RH
OnePart 2	Bead or Roll Coat	12 g/ft ²	2 g/ft ²	73.4°F	50%
OnePart 20	Bead or Roll Coat	12 g/ft ²	2 g/ft ²	73.4°F	50%
OnePart 35	Bead or Roll Coat	12 g/ft ²	2 g/ft ²	73.4°F	50%
OnePart 47	Bead or Roll Coat	12 g/ft ²	2 g/ft ²	73.4°F	50%

TABLE 2: NOMINAL CURING SPECIFICATIONS

Adhesive	Relative Humidity	Chemical Temp.	Open Time ¹	Closed Time ²	Press Time ³	Press Pressure
OnePart 2	50%	75°F	0.5 min	1.0 min	6 min	3 psi
OnePart 20	50%	75°F	1.25 min	11.25 min	67 min	3 psi
OnePart 35	50%	75°F	2.25 min	27.75 min	130 min	3 psi
OnePart 47	50%	75°F	3 min	30 min	180 min	3 psi

¹Open Time is defined as the maximum amount of time elapsed from adhesive application until the adhesive is covered with another substrate.

²Closed Time is the maximum cumulative amount of time elapsed from the adhesive application, when it is covered with another substrate, until the assembly is under pressure.

³Press Time is the minimum amount of time the assembly is maintained under pressure.

To obtain the most current PEI Listing Report, visit <http://www.p-e-i.com/reports.html>.