The Dependable and Durable Adhesives for RVs, Entry Doors, Garage Doors, Manufactured Homes, SIPs and More.

ADHESIVES
by Foam Supplies

certifications
• PEI Standard No. 89-1
• PEI Standard No. 93-7
• PEI Standard No. 93-8
• PEI Standard No. 99-23
• ASTM E 72
• ASTM C 557
• ASTM E 84
• UL-1715

One Part Adhesives by Foam Supplies

foam supplies, inc.
FoamNail® and OnePart:
The trusted names in adhesives from the leader in PU solutions, Foam Supplies, Inc.

No matter what type of application you have, FoamNail® and OnePart – industrial strength adhesives from Foam Supplies – can meet the challenge. That’s because FoamNail® and OnePart are a family of urethane adhesives designed with uncompromised quality. Our adhesives have been used successfully time after time in a wide range of industrial and commercial applications, from entry and garage doors, to manufactured homes, RVs, and building components like structural insulated panels (SIPs) and much more.

FoamNail® is a two-part adhesive, while OnePart is a moisture cure adhesive. But whether you choose FoamNail® or OnePart, you’ll find these adhesives to be environmentally benign, economical and extremely effective. FoamNail® and OnePart are VOC exempt, formaldehyde-free and do not contribute to global warming or ozone depletion. What’s more, our adhesives are substantially lower cost alternatives to other adhesive options. FoamNail® and OnePart adhesives also have 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

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**Estimated Cure Time for OnePart 47**

![Cure Time Graph for OnePart 47](image1)

**Estimated Cure Time for OnePart 20**

![Cure Time Graph for OnePart 20](image2)

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**Specifications (from PEI Listing Report)**

**TABLE 1: NOMINAL APPLICATION SPECIFICATIONS**

<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Application Method</th>
<th>Adhesive Applied</th>
<th>Water Applied</th>
<th>Ambient Temp</th>
<th>Ambient RH</th>
</tr>
</thead>
<tbody>
<tr>
<td>OnePart-2</td>
<td>Bead or Roll Coat</td>
<td>12 g/ft²</td>
<td>2 g/ft²</td>
<td>73.4°F</td>
<td>50%</td>
</tr>
<tr>
<td>OnePart-20</td>
<td>Bead or Roll Coat</td>
<td>12 g/ft²</td>
<td>2 g/ft²</td>
<td>73.4°F</td>
<td>50%</td>
</tr>
<tr>
<td>OnePart-35</td>
<td>Bead or Roll Coat</td>
<td>12 g/ft²</td>
<td>2 g/ft²</td>
<td>73.4°F</td>
<td>50%</td>
</tr>
<tr>
<td>OnePart-47</td>
<td>Bead or Roll Coat</td>
<td>12 g/ft²</td>
<td>2 g/ft²</td>
<td>73.4°F</td>
<td>50%</td>
</tr>
</tbody>
</table>

**TABLE 2: NOMINAL CURING SPECIFICATIONS**

<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Relative Humidity</th>
<th>Chemical Temp.</th>
<th>Open Time</th>
<th>Closed Time</th>
<th>Press Time</th>
<th>Press Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>OnePart-2</td>
<td>50%</td>
<td>75°F</td>
<td>0.5 min</td>
<td>1.0 min</td>
<td>6 min</td>
<td>3 psi</td>
</tr>
<tr>
<td>OnePart-20</td>
<td>50%</td>
<td>75°F</td>
<td>1.25 min</td>
<td>11.25 min</td>
<td>67 min</td>
<td>3 psi</td>
</tr>
<tr>
<td>OnePart-35</td>
<td>50%</td>
<td>75°F</td>
<td>2.25 min</td>
<td>27.75 min</td>
<td>130 min</td>
<td>3 psi</td>
</tr>
<tr>
<td>OnePart-47</td>
<td>50%</td>
<td>75°F</td>
<td>3 min</td>
<td>30 min</td>
<td>180 min</td>
<td>3 psi</td>
</tr>
</tbody>
</table>

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

*Closed 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.

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

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To obtain the most current PEI Listing Report visit [http://www.p-e-i.com/reports.html](http://www.p-e-i.com/reports.html)
### Key Benefits
- Good mechanical properties
- Various third party certifications
- Excellent test results
- Pressurized and standard delivery available
- Significantly lower cost option to traditional tube and caulk applications
- Industry best shelf life
- Worldwide availability

### Pressurized Delivery Benefits
- Safest delivery system in industry
- Best environmental delivery – little to no material waste
- Reduces human exposure to chemicals
- Reduces parts and maintenance costs for dispensing equipment
- Frees up valuable floor space

### Certifications
- PEI Standard No. 89-1
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**Example A**

FoamNail® provides a strong adhesive bond when the lumber is straight and fits flush (Example A), and also fills in any gaps when the lumber is warped and cannot fit flush (Example B). (Note: Example A and Example B cross sections were cut from the same lumber/gypsum construction.)

**Example B**

FoamNail® shown applied along the intersection of the gypsum and the lumber according to FSI application instructions.

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**Wood Framing**

**Foam Bead**

**Gypsum Board**

1-1/8” Minimum

3/4” Minimum

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