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

Specifications (from PEI Listing Report)

TABLE 1: NOMINAL APPLICATION SPECIFICATIONS

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<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>
<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>

Minimum Press Time
- OnePart 47: 0.5 min
- OnePart 20: 0.75 min
- OnePart 35: 1.25 min
- OnePart 47: 3 min

Maximum Working Time
- OnePart 47: 20 min
- OnePart 20: 35 min
- OnePart 35: 47 min
- OnePart 47: 67 min

TABLE 2: NOMINAL CURING SPECIFICATIONS

<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Relative Humidity</th>
<th>Chemical Temp.</th>
<th>Open Time¹</th>
<th>Closed Time²</th>
<th>Press Time³</th>
<th>Press Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>OnePart 47</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>

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.