



# Parabond M-250

## Brush Grade Extremely Flammable Contact Cement

# PARABOND ACCESSORIES

### DESCRIPTION:

Parabond M-250 is a brush/roller coat neoprene contact adhesive developed especially for bonding decorative plastic laminate to particle board in the manufacturing of counter tops. As a general purpose industrial type adhesive, M-250 can be used for non-structural bonding of wood, metal, rubber, leather, canvas, rigid polyurethane foam, paper honeycomb and many other porous and non-porous surfaces.

### SURFACE PREPARATION:

Materials to be bonded must be clean and dry; free of oil, dirt, paint, moisture, grease, etc. Adhesives and substrates must be 65°F or higher prior to, during and after bonding.

### DIRECTIONS:

1. Brush or roller coat in area equipped to exhaust the solvent vapor.
2. All motors and other equipment must be underwriter labeled (UL) explosion proof for operation.
3. Coat both surfaces to be bonded with a pattern uniform in appearance. You should have 100% surface coverage including the edges.
4. Allow the adhesive to dry completely before bonding. This will take about 15 to 25 minutes.
5. When dry, the adhesive will feel tacky, but will not transfer to the finger when touched.
6. If the two surfaces do not grab immediately when brought into contact, they have been open too long and have dried too much.
7. You can reactivate the surfaces by applying another thin coat of adhesive over each surface.
8. Force drying is recommended to give consistently high performance bonds and to eliminate variations caused by temperature and humidity.
9. Drying time can be reduced substantially by heating the coated surfaces with hot air, infrared lamps or strip heaters.
10. Production requirements will determine the amount of heat necessary and therefore the number of lamps or strips and the length of the oven.
11. Exhaust fans are necessary to remove solvent odors.

12. Position the parts carefully because no adjustment is possible after the adhesive makes contact.
13. Apply pressure. A minimum of 40 psi bond pressure is suggested for best results.
14. A pinch roller or rotary press is recommended. If not available, use a three inch rubber hand roller and apply pressure from the center toward edges to avoid air pockets and bubbles.
15. You may trim or rout immediately.
16. It is the sole responsibility of the installer to determine the suitability and compatibility of the adhesive for the end user's intended use.

### CLEAN-UP:

Our M-315 Solvent Cleaner can be used to clean up tools and excess adhesive or spills.

### COVERAGE:

120-140 sq ft / gal

### PHYSICAL PROPERTIES:

Weight/gallon 6.80 lbs  
Color Cream  
Flash point Less than 20°F (see caution)  
Shelf life 12 months min. @ 70°F in un-opened container

### FOR MORE INFORMATION READ MATERIAL SAFETY DATA SHEET

**CAUTION: Mineral Spirits are flammable. Read and follow all precautions on container label.**

### PACKAGING:

- One – Quart
- One – Gallon
- Five - Gallon

### KEEP OUT OF REACH OF CHILDREN.

### WARRANTY:

Royal Adhesives and Sealants offers a limited warranty for this product when used in accordance with printed specifications. A copy of the limited warranty can be obtained by calling technical service at 800 763-7272 or visiting [www.parabond.com](http://www.parabond.com).

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[www.parabond.com](http://www.parabond.com)

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