

PRODUCT DATA SHEET
THERMOSETTING
ADHESIVE
SOLVENT BASED
A344B

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Last updated: 05/04

DESCRIPTION

A-344-B is a thermosetting synthetic resin based solution. A-344-B is used to prevent corrosion and improve bonding of high-density friction material.

FEATURES & BENEFITS

- Fast drying
- Cures to form a heat, chemical and abrasion resistant surface that is hard and non-tacky

USES

- Corrosion resistant protective metal coating
- Brake shoe primer
- Improves bonding to dense friction material

TYPICAL TECHNICAL DATA:	A344B
Base:	Synthetic Resin
Color:	Amber
Total Solids (weight): (volume):	28-31% 17% (calculated)
Solvent/Thinner:	IPA
Viscosity:	20-40 cps (Brookfield RVF #1 @ 20 rpm)
Calculated Coverage:	289 ft ² /gal./mil
SAE Disc Shear Data	Sheared @ Room Temp. - 2000 psi minimum Sheared @ 400°F (204°C) - 500 psi minimum
Weight/Gallon :	7.54 lbs/gal (0.900-0.910 kg/L)
Shelf Life:	18 months from date of manufacture

Typical technical data and performance properties given for reference only (not for specification purposes)

APPLICATION METHOD

Method: Conventional or airless spray, curtain coating, brushing, dipping, or roll coating.

Surface Preparation: Clean surfaces to be bonded; metal should be degreased and grit blasted.

Application to Part: Apply A-344-B to surface(s) to be bonded. Optimal dry film thickness will be determined by part configuration and end use application. After the final coat has been applied, allow to dry. All solvents must be dried off to attain a good bond.

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APPLICATION METHOD (CONTINUED):

Keep in mind:

- Adhesive patterns having the greatest surface area will dry best.
- Humidity affects evaporation rates, which can cause a drying problem during summer months. Normal drying cycles may require season adjustments to provide adequate drying.

CURING CONDITIONS

Cure: A-344-B can be cured at 375-400°F (190-204°C) for 30 minutes with at least 50 psi pressure over entire bonded area.

** This recommended cure cycle is based on steel to steel disc shear bonding and may require adjustments for your bonding process.*

STORAGE

A-344-B, when stored in the liquid form, will meet the adhesion requirements of the SIA Adhesives, Inc. specifications after 18 months of storage in the temperature range of 40-60°F (4-15°C). Storage of A-344-B at temperatures above 60°F (15°C) may significantly reduce the product's working life.

Parts coated with A-344-B may be stored an additional 6 months at temperatures below 95°F (35°C) before bonding. Protect the adhesive surface from contamination during this storage period.

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SOLVENT FLAMMABLE SAFETY SHEET

GENERAL PRECAUTIONS

**READ MATERIAL SAFETY DATA SHEET FOR MORE SPECIFIC INFORMATION
BEFORE HANDLING, STORING OR USING THIS PRODUCT**

IMPORTANT SAFETY INFORMATION READ BEFORE USING

D A N G E R

EXTREMELY FLAMMABLE! VAPORS MAY BE EXPLOSIVE! Vapor harmful, do not breathe vapor. Harmful or fatal if swallowed. Use only in a well ventilated area. Vapors may be ignited, causing a flash fire or explosion. Extinguish all pilot lights (note that vapors can travel many feet to unextinguished pilot lights, such as furnaces and hot water heaters), flames and smoking materials. Shut off all non-explosion proof electric motors, fans and other electrical appliances until vapors are gone. Avoid prolonged or repeated breathing of vapors - excessive exposure may cause serious personal injury. If dizziness or nausea occur, obtain fresh air. Avoid contact with skin or eyes. Eye contact may cause severe irritation. If eye contact occurs, flush eyes with water for 15 minutes, then see a physician. If contact with skin occurs, wash thoroughly with soap and water. **IF SWALLOWED, DO NOT INDUCE VOMITING. SEE A PHYSICIAN IMMEDIATELY.** Store in a cool, well-ventilated place. Keep container closed tightly when not in use.

PROTECTION - Protective gloves, impervious-type eye protection, splash-proof goggles (ANSI Z87.1-1968).

CAUTION - FLAMMABLE MIXTURE. DO NOT USE NEAR FIRE OR FLAME. N.Y.F.D. C OF A NO. 459.

WASTE DISPOSAL

Observe all of the above precautions even with emptied containers and waste adhesives. Emptied containers and waste adhesive must carry the original labels through disposal and must be handled as extremely flammable and potentially explosive material. Such scrap must be stored in an isolated and segregated area while awaiting disposal and should in no event be mixed with other types of scrap. We recommend disposal by an industrial waste firm that is qualified to handle hazardous materials. Disposal should be either by controlled burning or by burial and must be in accordance with state and local regulations. Supplemental scrap container labeling clearly showing the words "**EXTREMELY FLAMMABLE**" and other warnings noted above should be applied when the original labels are obliterated during usage or when small containers are placed within larger containers.

For industrial or professional use only. If resold or repackaged for household use, containers must be labeled in accordance with the Federal Hazardous Substance Labeling Act and other laws and the label must be approved by SIA Adhesives, Inc.

LIMITED WARRANTY

Except as provided below, we warrant our products to be free of defects and manufactured to meet published physical properties when cured and tested according to applicable specifications and SIA Adhesives, Inc. standards. Under this warranty, we will provide, at no charge, product in containers to replace any product proved to be defective when applied in accordance with our written instructions, and in applications recommended by us as suitable for this product. All claims must be in writing and must be made within 30 days of shipment. The absence of claims during this period will constitute a waiver of all claims with respect to claims with respect to such product. This warranty is IN LIEU OF any and all other warranties, expressed or implied, including but not limited, any implied warranty of MERCHANTABILITY or fitness for a particular purpose.

Products which may be used as part of an application or installation which is confidential or otherwise not known to and recommended by us, are accepted "as is", and with respect to those products, there are NO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PURPOSE, OR ANY OTHER WARRANTY, EXPRESSED OR IMPLIED. The purchaser of the product must determine suitability for the intended use and assumes all risk and liability therewith, and agrees to defend, indemnify and hold us harmless from all loss, damage, expense or claims of any kind arising from the use or handling of the products, violation of any law or regulation, breach of these terms of sale, or other act or omission by purchaser or user, or their contractors, consultants, employees or agents. Our shipment of products to you will establish your receipt of and agreement with this product bulletin, the terms and conditions of sale and MSDS.

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