[METRIC]
A-A-1936A
August 12, 1996
SUPERSEDING
A-A-1936
April 12, 1996

COMMERCIAL ITEM DESCRIPTION

ADHESIVE, CONTACT, NEOPRENE RUBBER

The General Services Administration has authorized the use of this commercial item description as a replacement for Federal Specification MMM-A-130B, for all Federal Agencies

1 SCOPE This commercial item description covers three types of neoprene adhesive suitable for contact bonding of many materials such as leather, wood, fabrics, unglazed ceramics, wall boards and carpet to each other It may be used to bond plastic decorative laminates to wood and metal surfaces These adhesives are intended to be applied by brush or spray

2 CLASSIFICATION The adhesive shall be of the following types and grades

Type I - Solvent type, High VOC
Type II - Water dispersion type
Type III - Solvent type, High solids, lower VOC
Grade A - apply by brush
Grade B - apply by spray

3 SALIENT CHARACTERISTICS

3 1 The product shall meet the requirements in Table I

TABLE I

Characteristic	Type I	Type II	Type III	Test[1]
Volatile Organic Content g/L, maximum	—	250	540	BAAQMD Manual of Proc[4] Method 22 (Ty I and III) Method 21 (Ty II)
Non-volatile content, %(wt) minimum	15	46	23	ASTM D 1490 (Ty I) ASTM D 1489(Ty II)
Density, g/ml (lb/gl)	78- 87 (6 5-7 3)	1 03-1 12 (8 5-9 3)	78- 87 (6 5-7 3)	ASTM D 1875
Ash content, %(wt)	3-20	3-20	3-20	ASTM D 297
Viscosity, centipoise Grade A Grade B maximum	400-1500 250	400-3000 250	400-1500 250	ASTM D 1084 Method B,
Shear strength [2] kPa (psi) minimum Before aging After aging 1 cycle	1030 (150) 1380 (200)	1 1030 (150) 1380 (200)	1030 (150) 1380 (200)	ASTM D 1002[3] ASTM D 1183 Proc A

[1] Manufacturer may use tests shown in this table or an equivalent test to verify compliance to these requirements The tests listed will be used in case of dispute

[2] Use a dry coating weight of 20 to 30 grams/sq meter (2 to 3 grams per sq ft) in accordance with ASTM D 898

[3] bonding 6 mm Gr A fir plywood to 1 5 mm plastic laminate

[4] BAAQMD Manual of Procedures Volume III Method 21 or 22 is available from Bay Area Quality Management District ATTN Public Information 939 Ellis Street San Francisco CA 94109

Beneficial comments recommendations additions deletions, clarification's etc and any data which may improve this document should be sent to General Services Administration Engineering and Commodity Management Division (10FTE) 400 15th St SW Auburn WA 98001

FSC 8040

3 2 Prohibited material The product shall not contain (other than trace impurity amounts not to exceed 06% liquid wt, as tested in accordance with the appropriate ASTM method) any of the following hydrolyzable chlorine derivatives, ethylene based glycol ethers and their acetates, any carcinogen, as defined in 29 CFR 1910 1200, any of the chemicals on the EPA 33/50 program in the following list [benzene cadmium & compounds carbon tetrachlonde chloroform chromium & compounds, cyanides, lead & compounds mercury & compounds methyl isobutyl ketone methylene chlonde, nickel & compounds tetrachloroethylene trichloroethane trichloroethylene, and xylenes] nor any ozone depleting compound [as listed in the Federal Register notice of July 30 1992 (57 Fed Reg 33753) which include chlorofluorocarbons halons, carbon tetrachloride, methyl chloroform and hydrochlorofluorocarbons]

3 3 Edge lift Bond a 30 cm x 30 cm piece of 1 5 mm thickness high pressure decorative plastic laminate to a 30 cm x 30 cm x1 2 cm piece of fir plywood following adhesive manufacturer instructions (see Table I footnote 2) Age 24 hours 23°C and 50% relative humidity Trim 2.5 cm from each edge of the assembly leaving a 25 cm x 25 cm test specimen Heat the specimen in an air circulating oven for 2 hours at 60°C Cool to standard conditions The distance that the plastic laminate has separated from the plywood shall not exceed 1 5 mm

3 4 Open time Apply adhesive to a piece of 1 2 cm thickness fir plywood and a matching piece of 1 5 mm thickness high pressure decorative plastic laminate according to manufacturer's directions (see Table I footnote 2) Dry for one hour, then bond the plastic laminate over the plywood so that one inch of laminate extends over the plywood on two sides Roll with a hand roller using body pressure to establish the bond The laminate shall not peel from the plywood

3 5 Shelf storage life A container of the adhesive, after storage for 12 months from the date of manufacture at 23°C and a relative humidity of 50%, shall have no gelling, stringing or other nonuniformity, and it shall meet all requirements in Table I

4 QUALITY ASSURANCE PROVISIONS

4 1 3 1 Commercial Quality The products provided shall conform to the producer's own drawings, specifications, standards, and quality assurance practices and be the same product offered for sale in the commercial market The government reserves the right to require proof of such conformance prior to first delivery and thereafter as may be otherwise provided for under the provisions of the contract

5 PACKAGING The packaging and packing shall be as specified in the contract or order

6 NOTES

6 1 Intended use This adhesive is intended for high strength contact bonding of a wide variety of materials including metal, wood, plastics and fabrics to themselves and each other The adhesive may be used to install cove base corners and roll edge counter top materials Type I and II correspond to Types I and II of MMM-A-130 Type III is added for users in VOC regulated areas

6 2 Referenced documents

Federal Regulations

29 CFR Part 1910 1200

The code of Federal Regulations (CFR) is for sale mail order by the Superintendent of Documents ATTN New Order PO Box 371954 Pittsburgh PA 15250-7954

ASTM Methods

ASTM D 297 - Chemical Analysis of Rubber Products
ASTM D 898 - Applied Weight Per Unit Area of Dried Adhesive Solids
ASTM D 1002 - Strength Properties of Adhesive in Shear by Tension Loading (Metal to Metal)
ASTM D 1084 - Viscosity of Adhesives
ASTM D 1183 - Resistance of Adhesives to Cyclic Laboratory Aging Conditions
ASTM D 1489 - Nonvolatile content of Aqueous Adhesives
ASTM D 1490 - Nonvolatile Content of Urea-Formaldehyde Resin Solutions
ASTM D 1875 - Density of Adhesives in Fluid Form

ASTM standards are available from the American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshocken PA 19428-2959 The issue of the ASTM test methods in effect on the date of the solicitation shall be used to determine compliance with these requirements

MILITARY INTERESTS

Custodians
Air Force - 99

Review Activity
Army - MI
Air Force - 84
Navy YD-1

CIVIL AGENCY INTERESTS

Coordinating Activities
COM - NBS
GSA - PCD

Preparing Activity
GSA-FSS