



Technical Data

Solvent	Dimethoxymethane
Propellant	Hydrocarbon
Solids content (approx.)	27%
Spray pattern	Web
Colour	Clear
Coverage (approx.)	6m ²
VOC	583 g/l
Heat Resistance	100°C
Open time	Up to 120 min.
Drying time	1-2 min.
Shelf life	12 months
Storage temperature	15°C - 35°C

DASA DS-404 Aerosol

Features

- Non-chlorinated
- Limited health hazards
- Uniform spray
- Fast easy application
- Fast drying
- High temperature resistance
- Long open time

Properties & application

- Our next generation adhesive using innovative solvent technology, meaning that the adhesive maintains a low hazard to human health due to its low toxicity, as well as providing minimal impact to the environment. It has high bond strength, high heat resistance and fast drying times but is completely non- chlorinated.
- Designed for bonding a wide variety of substrates, including wood, metals, rubber, fabric, most plastics, cardboard, polythene and concrete, as well as decorative laminates. Ideal for permanent bonds that require good initial bond strength. It provides good temperature resistance and if protected from contamination has an open time of several hours.
- Always test a small sample of the materials first to ensure the suitability of the product for the application.

DO NOT USE ON FLEXIBLE PVC OR EXPANDED POLYSTYRENE.

Directions for use

1. Surfaces should be clean, dry and free from grease, oil and dust. Excessive dust will impair performance.
2. Substrates should be conditioned before assembly. This is particularly important with laminates. Condition for 48 hours at 20°C with a relative humidity of 45-55%. Air should be able to circulate freely around the components.
3. Hold the aerosol at approximately 70° to the surface and apply a uniform coat of adhesive to both substrates, ensuring 80-100% coverage. Spray one surface vertically the other horizontally. Pay particular attention to the edges.
4. Porous substrates may require two applications
5. Drying takes approximately 1 to 2 minutes depending on substrates, ambient temperature and humidity. Over spraying and pooling of the adhesive will increase the drying time.
6. To prevent the spray nozzle from blocking at the end of each period of use, turn the can upside down and press nozzle until spray is clear of adhesive.
7. It is important to remember that **DASA DS-404** is a contact adhesive and forms a bond by sticking to itself, so there must be sufficient adhesive on both surfaces for this to happen.
8. Allow the adhesive to tack up and protect from contamination whilst this happens. The adhesive is ready to bond when it feels dry to the touch and does not transfer.
9. Once the two surfaces have been brought together, an aggressive bond will be made.
10. Apply a uniform pressure over the work piece, starting in the middle and working outwards, to ensure full contact. Pay particular attention to the edges. A roller will give the best results.
11. Full cure will take 24 hours.

Limitations

DS-404 dries in two minutes under normal conditions, but this will vary under different temperatures and humidities. High humidity and low temperatures will slow the drying time and if the temperature gets very low, can produce bloom. Bloom is moisture which forms on the glue line caused by solvent evaporation lowering the air temperature above it.

Storage

Protect from extremes of temperature in a controlled environment between 15 and 35°C, and away from direct sunlight. Do not stand on a cold concrete floor. Low temperatures can result in irreparable separation of the adhesive. Stored under the correct conditions, in original, unopened containers, the product will have a shelf life of 12 months.

DO NOT ALLOW THE PRODUCT TO FREEZE

Disclaimer

All the information in the Data Sheet is based on practical experience and is published in good faith. However, because we have no control over the manner or conditions in which our products are used, or over work undertaken or end product manufactured by the purchaser, we cannot accept liability for results. Responsibility for ascertaining the suitability of products for his purposes rests with the purchaser. All conditions, representations, statements, warranties or guarantees whatsoever, whether express, implied or statutory, in respect of any goods manufactured, sold or supplied by us are hereby expressly excluded and we accept no liability in respect of any claim for damage or consequential loss caused to any property arising directly or indirectly out of the use of our products or goods.

DASA International B.V.

Bergerweg 62-M
1815 AE Alkmaar
The Netherlands

Tel: +31 72 571 99 17
Mail: info@dasa-international.com
Web: www.dasa-international.com

© 2023 DASA International B.V. Version 202307V1

All rights reserved. This publication or any portion thereof may not be reproduced or used in any manner whatsoever without the express written permission of the publisher.