

**DOLPHIN 7420**

**WATER BORNE CONTACT ADHESIVE**

**DESCRIPTION:** A high strength, acrylic latex adhesive designed for interior trim assembly in the transportation industry. This sprayable, water borne adhesive offers the fast grab of conventional contact cements without the hazards of solvents. **DOLPHIN 7420** will bond carpet, fabrics, foams, vinyl, and rubber to wood, fiberglass resin, aluminum, stainless steel, steels and most primed and painted surfaces. In many assemblies, the bond strength is greater than the strength of the adhered. Bond strength is maintained throughout the service range of -20°F ( -30°C ) to 250°F ( 120°C ). Once dried, **DOLPHIN 7420** has excellent water and humidity resistance.

**APPLICATION:** **DOLPHIN 7420** is supplied at a viscosity suitable for pressure pot application, but can be applied with a brush or roller. For best results, apply 4 mils of adhesive to both surfaces to be joined and allow adhesive to dry before bringing the surfaces together. In moderate humidity conditions, the assembly can be made 5 to 30 minutes after the adhesive is applied. If one of the materials being bonded is porous, the surfaces may be mated wet and the water will evaporate through the porous material. Positioning must be done immediately after the materials being bonded are mated; shortly after assembly, the adhesive bond will be too strong to permit repositioning. When dried, it retains slight tackiness, or pressure sensitivity, so that some rebonding can be attained. Full strength will develop in approximately 48 hours.

**DOLPHIN 7420** may be thinned with water, however this will increase the dry time. Water may be used to remove wet adhesive from tools and equipment. After the adhesive has dried, use toluene or ketone solvents to remove unwanted adhesive.

**PROPERTIES:**

Specific Gravity	1.03 – 1.09
Solids	53 – 58%
pH	7 - 8
Dry Time:	10 minutes set to touch
ASTM D 1640 @ 68°F; 50%R.H.	45 minutes through dry

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**DOLPHIN 7420**

**FOLLOWING TESTS WERE PERFORMED  
AFTER DRYING 7 DAYS @ 68°F (20°C); 50% R.H.**

Adhesion, Shear  
ASTM D816

150 lbs/in<sup>2</sup> – aluminum to plywood  
110 lbs/in<sup>2</sup> – fiberglass to plywood  
150 lbs/in<sup>2</sup> – Formica to plywood  
100 lbs/in<sup>2</sup> – rubber floor to plywood  
100 lbs/in<sup>2</sup> - rubber floor to plywood  
Rubber failed– rubber floor to plywood  
@ -35°F  
40 lbs/in<sup>2</sup> – rubber floor to plywood  
@ 180°F

Adhesion, 180° Peel  
ASTM D903

20 lbs/in – wood to test ribbon  
15 lbs/in – aluminum to test ribbon  
12 lbs/in – rubber floor to test ribbon  
10 lbs/in – carpet to plywood  
10 lbs/in – vinyl to plywood  
Rubber failed– rubber floor to plywood  
@ -35°F  
10 lbs/in – rubber flooring to plywood  
@ 180°F

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