



PRODUCT APPLICATIONS

UPACO Adhesives

Foam Fabricating
Adhesives Group

The UPACO division of Worthen Industries manufactures a broad array of adhesives and related products for the foam fabricating industry. We designed many of these products to solve specific problems for our customers and we developed all of them with consistent performance in mind. A partial listing of our products used in the foam fabricating industry follows.



NATURAL RUBBER WATER-BASED PRODUCTS (*Renewable Resource*)

Natural latex adhesives offer excellent versatility for furniture grade cushion manufacturing, at a low cost. These products are for combining foam to foam, foam to fiber, foam to fabric, or fiber to fiber. Fabond 858 is a workhorse adhesive for cushion fabrication, and is very fast setting, especially when wrapping fiber. Fabond 805 is a contact adhesive, designed to give strong bonds to dense foam to wood combinations for office chair seats. Equipment needed for delivery of natural latex adhesives can be as simple as gravity feeding to spray guns, but ventilation is vital to draw “overspray” adhesive particles away from employees and surrounding work areas.

Product	Viscosity	Solids	Tack Time	Application	Method of APPL
FABOND 858	400 CPS	63%	15 - 30 SEC	HIGHER DENSITY FOAM, OPEN -TIME, MATTRESSES	SPRAY
FABOND 805	500 CPS	60%	* N/A	DENSE FOAM, SEAT BOT-TOMS, WOOD, HEAT RESIS-TANCE	SPRAY, DRY TO TACK, & PRESS

COLORS: Note these products are offered in White (dries nearly Clear) or Yellow for added visibility.

SYNTHETIC RUBBER WATERBASED PRODUCTS

Synthetic adhesives are offered for combining more difficult substrates or if faster tack or a faster final bond is needed. They work well on rigid foam, plastic, metal and wood. Synthetic spray adhesives provide very fast bonds, from an instant bond using Fabond 886 2-part adhesive, or Fabond 499, a one part foam to foam fabrication adhesive. For high volume cushion or mattress manufacturing, a roll-coater applied product such as Fabond 780 can provide very high production rates.

Product	Viscosity	Solids	Description	Tack Time	Application	Method of APPL
FABOND 499	70 CPS	45%	ONE-PART	10 SEC.	FOAM TO FOAM	
FABOND 486	100 CPS	56%	ONE-PART	10 SEC.	HEAT RESISTANCE	CAN BE GRAVITY FEED, PUMP SYS-TEMS, PRESSURE
FABOND 780	1100 CPS	52%	ONE-PART	10 SEC.	FOAM & FABRICS	POTS
FABOND 914	1250 CPS	50%	ONE-PART	5 SEC.	DENSE FOAM, MAT-TRESSES	
FABOND 886	100 CPS	56%	TWO-PART	INSTANT	AUTOMOTIVE	DIAPHRAM PUMP OR PRESSURE POTS

COLORS: Note these products are offered in White (dries nearly Clear) , Yellow, Blue, or Red for added visibility.



SOLVENT BASED PRODUCTS

These products are offered in Acetone/ Heptane solvent blends, and offer the most versatility in fabrication possibilities. UPACO 3694-0 is ultra -filtered for fine spray patterns, and offers outstanding versatility and one-way application for many substrate combinations. High Mileage products offer opportunities for adhesive savings over standard products in the market today. “Acetone Only” adhesive Slabond 523 is VOC free. Due to the flammability of Acetone/ Heptane products, care must be taken in the design of grounded, spark-proof delivery and ventilation systems, and employees need additional training in Grounding and Bonding of pumps and containers, etc. UPACO can assist you with these important issues.

Product	Viscosity	Solids	Tack Time	Application	Method of APPL
3694	150 CPS	40%	5 SEC.	FINE PATTERNS, ONE-WAY	PUMP & SPRAY PISTON PUMP, DIAPHRAM PUMPS, PRESSURE POTS, OR GUNS WITH CUP RESERVOIRS
3693	75 CPS	35%	10 SEC.	FABRICATION WORK-HORSE	
3656-0	350 CPS	35%	10 SEC.	HIGH MILAGE, NORMAL SPEED	
SLABOND 523	100 CPS	25%	15 SEC.	“ACETONE ONLY” NO VOC’ S OR HAPS TO REPORT	

COLORS: Note these products are offered in Clear, or Red and Orange (inquire) for added visibility.

BAUMER SLITTER ADHESIVES AND REINFORCING TAPE

Baumer-slitter adhesives offered have very good holding power for large buns. The exemption of Acetone from the EPA’s VOC list led to the development of Slabond 523, often referred to as “Acetone Only” adhesive. Slabond 523 offers foam pouring plants a solvent adhesive with no additional VOCs to report, and it is often used for fabricating as well for this reason. NYLCO, a sister company to UPACO, manufactures coated products, such as tapes. NYLCO SF399 tape is used when additional reinforcement is desired on extra heavy loop slitter applications.

Product	Viscosity	Solids	Solvent	Application	Method of APPL
SLABOND 523	100 CPS	25%	ACETONE	NO VOCS OR HAPS TO REPORT	PISTON PUMP, SPRAY

COLORS: Note SLABOND products are offered in Clear, or Orange (inquire) for added visibility.

NYLCO SF-399 TAPE 6” & 12” WIDTHS		100%	N/A	APPLY TAPE AFTER GLUING FOR REINFORCEMENT	POLYESTER BACKING/ RELEASE PAPER
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FOAM FABRICATING ADHESIVES GROUP

100% SOLIDS HOT MELT PRODUCTS

Hot melt adhesives are popular for instant bonding capabilities and absence of VOCs. Because of the ability to bond plastics when applied hot, these products are the best choice when fabricating specialty packaging, adhering closed-cell foams to corrugated, for example. For foam fabrication, the equipment can be expensive, and is cumbersome in hand applications. However, a hot melt system with automated spraying can be very efficient and cost effective. UPACO offers two basic types of products: pressure sensitive, and non-pressure sensitive. Pressure sensitive adhesives, such as UPACO 9571, have a nearly indefinite open-time, and are excellent for bonding plastics, such as puff-pack wrapping or closed cell foams. UPACO 9025 is non-pressure sensitive, and is designed for fabricating applications. 9025 is designed to have an extended open-time, but eventually will become non-tacky and flexible, leaving seams non-dimpling and soft.

Product	Viscosity	Softening Point	Product Use
9025-F	3000cps @ 325°F	189°F Ring and Ball	Foam to foam spray or roll coat, reduced pressure sensitivity when cool, high strength
9571-2	9680cps @ 325°F	14 min. on 120°F deadload	Pressure sensitive for film wrap of foam rolls
9509-2	4100cps @ 325°F	PSA	Low visc. sprayable, pressure sensitive for fiber and foam low tension applications

SLIP COATINGS FOR CUSHION STUFFERS

Foamcoat products are acetone-based coatings designed to provide slip in cushion stuffing operations. These products are sprayed in a very light mist, and the acetone carrier dries away very quickly. Acetone is exempt from VOC reporting. Foamcoat is available in bulk containers, an economical replacement for spray cans.

Product	Viscosity	Solids	Solvent	Application	Method of APPL
FOAMCOAT 916 A	150 CPS	25%	ACETONE	SLIP COATING FOR TYPICAL FOAM CUSHIONS	FINE SPRAY, PISTON PUMP, PRESSURE POTS

FOAM CONVERTING – WATERBASED LAMINATING PRODUCTS

Foamlam adhesives are proven products for wide-web, roll-fed foam laminators. Designed as very unique, high solids adhesives for high wet tack, these products are used for laminations of scrims, fabrics, and vinyls to foams. Foamlam 8201 will pass specifications for automotive interior laminations including adhesion and burn tests (please inquire). Foamlams require nipping and oven drying for maximum efficiency, but do not contain solvents of any kind. UPACO can assist you with your converting concepts.

Product	Viscosity	Solids	Application	Method of APPL
FOAMLAM 8201	5500 CPS	64%	LAMINATIONS OF SCRIM, FABRICS, OR VINYL TO FOAM	LAMINATOR, NIPPED, OVEN DRIED
FABOND 780	1100 CPS	55%	FOAM AND FIBER, MATTRESSES	ROLL COATER
FOAMLAM 935	1300CPS	45%	FOAM MATTRESSES	ROLL COATER



The UPACO Foam Fabricating Group is proud to offer high quality products and service to the Furniture and Bedding Industry. Contact UPACO Adhesives @ (800) 446-9984, and speak to Steve Adams, or Ian Churcher, or e-mail us via info@upaco-richmond.com, or through our website @ www.worthenind.com.