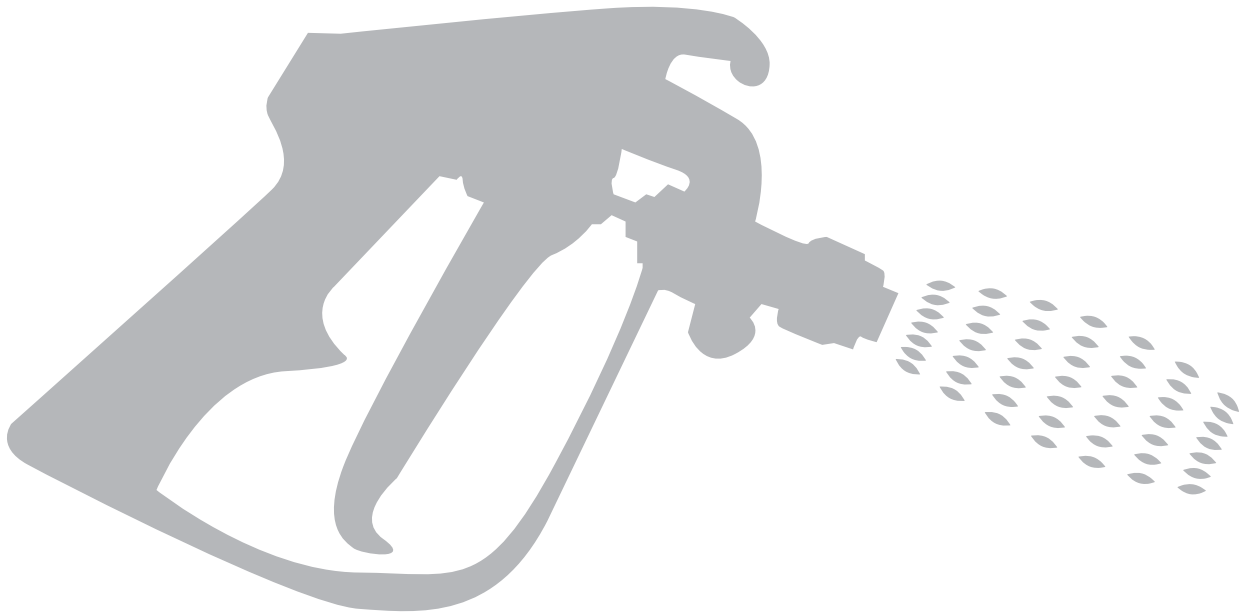


**Tensorgrip<sup>®</sup>**  
ADHESIVES THAT OUTPERFORM

# SPRAY MANUAL

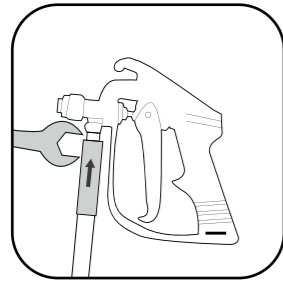


# CONTENTS

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Contents	1
Setting Up Your Canister	2
Identifying The Spray Pattern	3
How to Spray TensorGrip®	3
Fixing a Leaking Spray Gun	6
Changing to a New Canister	7
Disposing of empty Canisters	8
Cleaning Your Gun	9

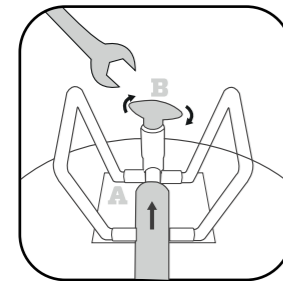
# SETTING UP YOUR CANISTER



## STEP 1

Attach the large end of the hose to the spray gun. Ensure the fitting is tight to prevent leakage.

Note: The fitting is NOT a swivel connection, it MUST be firmly tightened.

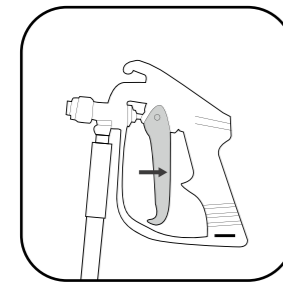


## STEP 2

Screw the small end of the hose to canister valve (A). Ensure fitting is tight to prevent leakage.

Twist valve (B) to open the canister. The hose will become pressurised.

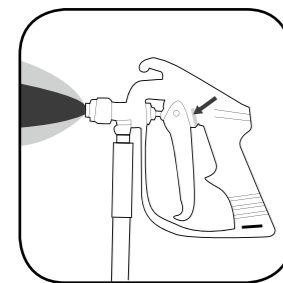
Check both fittings for leaks. Tighten to stop leakage.



## STEP 3

Pull trigger to release air build-up in the hose. This is complete when adhesive begins to spray.

(Note: this will take longer for water-based adhesives)



## STEP 4

Rotate the locking screw behind the trigger to adjust the spray width.

Hold gun 10-15cm from surface and spray with even coats.

For optimum adhesive performance, please ensure you have the correct gun tip and hose.

A list of corresponding gun tips and hoses for each adhesive is available from the resources section of our website <http://www.tensorglobal.com/australia/resources-and-media/>

Adhesive temperature must remain between 16-27°C while in use.

**DO NOT store canisters directly on concrete floor.**

# IDENTIFYING THE SPRAY PATTERN

Correct Application of TensorGrip® Spray adhesive products is essential for a successful life long bond. To ensure that you are applying your adhesive correctly, you first need to identify the appropriate spray pattern for your chosen adhesive. This information is on the canister label. Your label will contain one of the following icons on its label.



Web Spray



Mist Spray



Pebble Spray



Snowflake Spray



Bead Pattern

Once you have identified the correct spray pattern for your adhesive, follow the directions in this manual for correct application of your adhesive.

## EXCEPTIONS

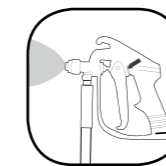
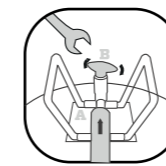
When using **TC43 FOR BONDING FABRIC LAYERS DURING RTM INFUSION**, the full coverage of its web spray properties is not required. For this specific application only use the Mist Spray application instructions. For all other applications of TC43 use the regular Web Spray application instructions.

# HOW TO SPRAY TENSORGRIP®

Unless otherwise directed, spray both surfaces to be bonded.

Make sure that the surfaces are clean, dry and free from dirt, dust, oil, loose paint, wax or grease, etc. For best results, the temperature of the adhesive and the surfaces being bonded should be between 16 °C - 27 °C. Ensure there is adequate ventilation in your workspace. Forced air ventilation is recommended

When possible we recommend shaking the canister well before using. Attach and secure hose tightly onto the spray gun with required tip. Attach the other end of the hose onto the canister. Make sure the hose-valve connections are secured tightly. Open the valve on the canister slowly and fully, check for leaks during this process. Unlock the trigger on the spray gun to start spraying.



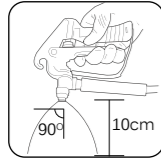
Prior to use, check compatibility by spraying a small test patch of the adhesive on the substrate.

If the spray tip clogs, unscrew the spray tip from the gun and clean with the recommended cleaner (or similar). **DO NOT** use a pin on the spray tip orifice.

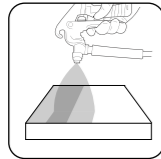
**Note:** Maximum adhesion can be obtained by spraying joining faces at a 90° angle (i.e spray one surface vertically and the other horizontally).



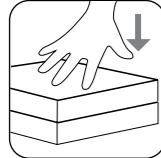
## WEB SPRAY



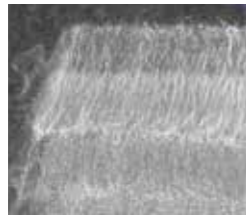
Hold gun 10cm from surface at a 90° angle.



Spray evenly on surface with a 50% overlap for full coverage. Except for TC43 during vacuum infusion, apply one even coat of adhesive onto matting, with no overlap. Leave surfaces to tack off for 1-2 minutes, or until dry to touch using the back of your knuckles.



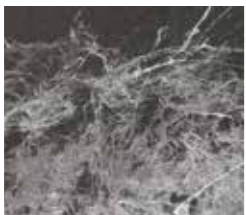
Place surfaces together and apply even pressure to establish the bond. A roller or rubber mallet can be used where appropriate to ensure even pressure across the entire bond surface.



✓ You Should be able to clearly see the web pattern of the adhesive on the surface of your substrate.



✗ If you can see air bubbles or buildup of adhesive in your spray pattern, then you are either spraying too close to the surface of the substrate or moving your gun too slowly.



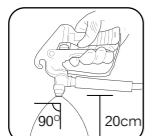
✗ If the spray pattern on your substrate looks wispy (like spiderweb), then you are spraying from too far away. Move your gun a little closer to the substrate.



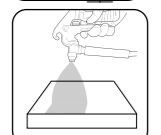
✗ If your spray pattern is thin and looks drawn out, then you are spraying too quickly.



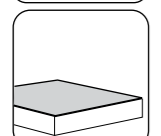
## MIST SPRAY



Hold gun 20-40cm from surface at a 90° angle.



Spray quickly and evenly on surface.

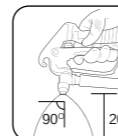


Place surfaces together and apply even pressure to establish the bond.

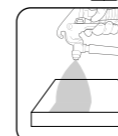
Maintain a constant speed of application during spraying, applying a thorough coating without allowing the adhesive to puddle or heavily 'wet' the surface. Maximum bond strength is achieved with coverage of between 80-100%. You may need to over-spray the edges of your substrate to ensure full coverage right to the edge.



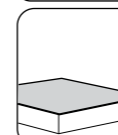
## PEBBLE SPRAY



Hold gun 20-40cm from surface at a 90° angle.



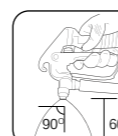
Spray evenly so that the droplets fall across the entire surface of the substrate. DO NOT allow the adhesive to puddle or heavily 'wet' the surface. Maximum bond strength is achieved with coverage of between 80-100%.



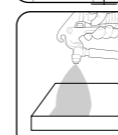
Place surfaces together and apply even pressure to establish the bond. Use of a roller for this process is recommended to ensure even pressure across the entire bonding surface.



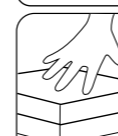
## SNOWFLAKE SPRAY



Hold gun 60-90cm from surface at a 90° angle.



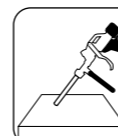
Spray evenly across the surface. Wait 1-2 Minutes until the adhesive is touch dry.



Place substrate onto surface and press down to strengthen the bond.



## BEAD PATTERN



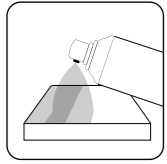
Hold gun close to the surface at a 45° angle.



Apply strips of adhesive approx. 10-20 cm apart to one substrate.



Place surfaces together and apply gentle pressure to allow the foamy adhesive to spread across the surface of the substrate.



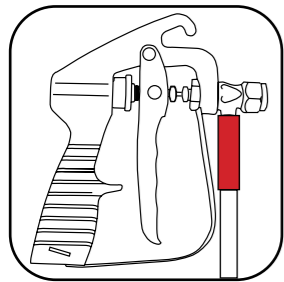
For all spray types, aerosol cans need to be held at 45 degrees to the substrate when spraying onto a horizontal surface. This will ensure a consistent spray pattern until the can is empty.



For more information, tutorial videos are available to watch on our Youtube channel.  
<https://www.youtube.com/tensorglobal>

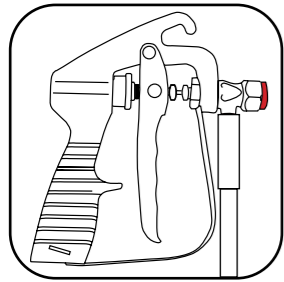
## FIXING A LEAKING SPRAY GUN

Here's a four point checklist if your gun is leaking.



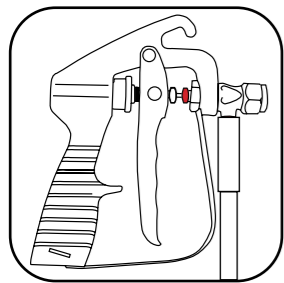
- 1. Check the hose connection to the gun. Does your hose swivel?**

If so, it is too loose and needs tightening. The gun and hose are designed to join almost seamlessly together. This is to provide the adhesive with a straight, unbroken trajectory to the gun tip. Any breaks or gaps in this line will mean the adhesive will leak out.



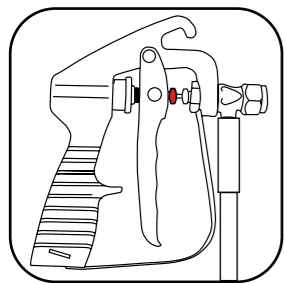
- 2. Check the Gun tip.**

Over time dried adhesive can build up on the gun tip. When this happens, the gun may not close properly, so the adhesive continues to dribble out after the trigger is released. To fix this, simply remove the gun tip and clean with TensorGrip C101. In extreme cases, a replacement tip may be required.



- 3. Tighten the backing seal.**

The adhesive only passes through a very small part of the gun when being sprayed. To prevent the adhesive from leaking out of this area, it is sealed. This seal is held in place by a nut. Over time, this nut can become loose, causing the seal to move out of place. This needs to be tightened. However, be careful not to make this too tight, as it will cause the sliding pin to bind and the trigger will become stiff. Using a 10mm spanner gently tighten the nut 1/4 turn at a time. testing the trigger movement between each turn.

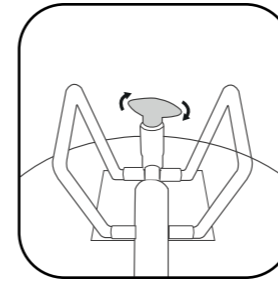


- 4. Tighten the opposing nut.**

Ensure the nut on the opposite end of the threaded rod is finger tight against the gun trigger. This will allow the pin to seal and prevent leaking. Do not tighten this screw with a spanner as this will break the pin.

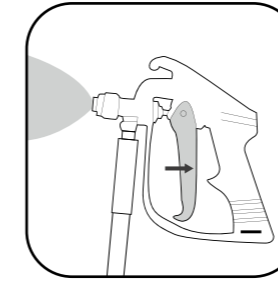
## CHANGING TO A NEW CANISTER

When your canister is empty you can simply connect your gun and hose to a new canister to continue using the TensorGrip adhesive. Please wear safety gloves and goggles during this process.



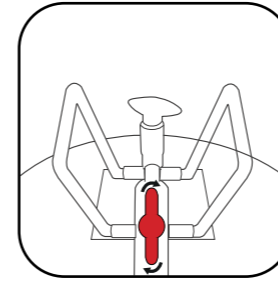
### STEP 1

Twist the canister valve clockwise until finger tight to close the canister.



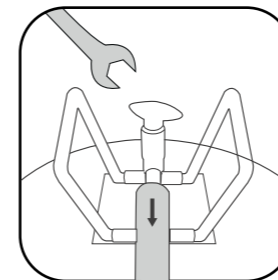
### STEP 2

With the gun pointed toward a waste bin or similar, pull the trigger to fully release a small amount of pressure and adhesive from the hose.



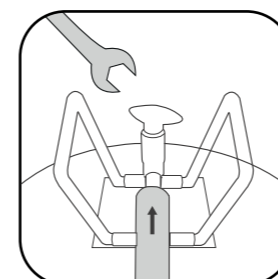
### STEP 3

Twist the hose valve clockwise to close.



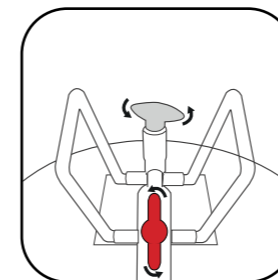
### STEP 2

Unscrew the nut on the end of the hose and remove the hose from the empty canister.



### STEP 3

Attach the hose to the new canister and tighten the connecting nut with a spanner.

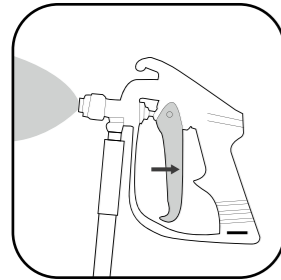


### STEP 4

Open the RED valve on the hose.  
Twist the canister valve anti-clockwise until fully open.

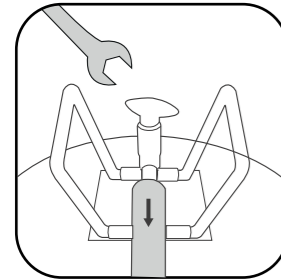
# DISPOSING OF EMPTY CANISTERS

If you have attached your gun and hose to a new canister for continued use please skip to Step 3. If you will not be using your gun and hose and wish to store it please start from step 1. Please wear safety gloves and goggles during this process.



## STEP 1

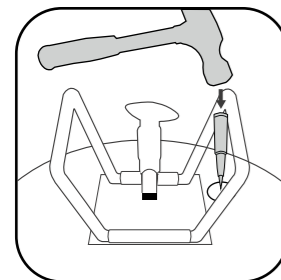
Pull trigger on the gun to fully release remaining pressure and adhesive from the canister. Wait until no more adhesive flows from the gun before continuing.



## STEP 2

Unscrew the hose from the empty canister and attach to the new canister immediately.

If the hose is empty it can be stored for a short time without being connected to a new canister. If you will be storing the hose for more than a few days however, please connect it to a cleaning canister to clean it out before storing it. If left with adhesive residue in your hose the adhesive may set and make your hose unusable.



## STEP 3

Ensure that the canister valve is fully open.

In an open ventiated area, lay the canister on its side so that the hose connection point faces away from you.

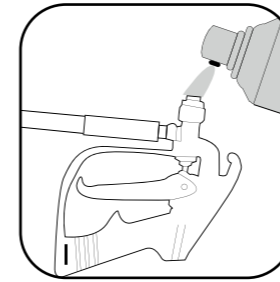
Using a hammer and punch, punch a hole in the small disc next to the canister carry handles.



The canister can be recycled as waste metal at a suitable metal recycling facility, subject to local regulations and rules.

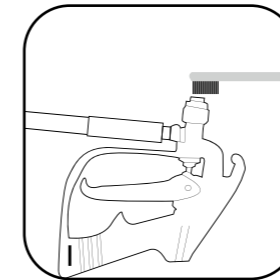
# CLEANING YOUR GUN

You will find that, from time to time, your gun tip will build up dried adhesive which will need to be cleaned off in order to maintain an accurate spray pattern.



## STEP 1

Spray the dirty gun tip with TensorGrip® C101 Citrus cleaner or S105 Acetone cleaner.



## STEP 2

Brush off the adhesive residue using a wire brush.

The TensorGrip® ZAP-IT kit comes with everything you need to keep your gun in peak performance.

**Tensor** is Manufactured in Australia by



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