APAC 643 is a fast-tack, fast-grab, low soak-in adhesive. It was especially formulated to bond polyethylene to itself, concrete block, wood and many other hard-to-bond-to surfaces. APAC 643 was developed for the floor-covering industry as a well-rounded, general-purpose adhesive for carpet and pads. It may also be used to bond paper, cardboard, fabric, urethane foam, foil, metal, wood, most plastics to themselves, and a variety of other substrates. APAC 643 may be used either for permanent or temporary bonds.

FEATURES & BENEFITS
• Fast tack and fast grab
• For permanent or temporary bonds
• Useful on many construction surfaces

USES
Bonding polyurethane insulation blocks, bead board, insulation, carpet and carpet pad, polyethylene film, sanding discs, paper, cardboard, fabrics, urethane foam, foil, metal, wood and most plastics

AREAS OF USE
• Interior residential (rental apartments, condominiums and homes)
• Interior commercial (office buildings, hotels, institutions and schools)

RECOMMENDED SUBSTRATES
Exterior-grade plywood, Group 1, CC type; other approved wood underlayments (per manufacturer recommendations); concrete and properly prepared cement terrazzo; cement-based self-leveling underlayments and patching compounds; and properly prepared steel, aluminum and fiberglass

Note: Consult Technical Services for installation recommendations regarding substrates and conditions not listed.

LIMITATIONS
Do not install over any substrates containing asbestos. Product is not recommended for unsupported vinyl fabric. Certain plastic and elastomeric substrates can exhibit bond failure due to plasticizer migration. Combinations of high temperature and humidity can promote bond failure. For nonmetallic substrates, test production parts in typical operating environments for compatibility and performance.

SURFACE PREPARATION
All substrates must be structurally sound, dry, solid and stable. Substrate should be clean and free of dust, dirt, oil, grease, paint, curing agents, concrete sealers, loosely bonded toppings, loose particles, old adhesive residues, and any other substance or condition that may prevent or reduce adhesion. All surfaces must be level, even, flat and smooth. Refer to APAC’s Surface Preparation Guidelines at www.apacadhesives.com.

MIXING
Note: Choose all appropriate safety equipment before use. Refer to Material Safety Data Sheet (MSDS) for more information.
• For best results, shake well before using.

INSTALLATION
Read all installation instructions thoroughly before installation.
1. Turn off all sources of ignition, including pilot lights on HVAC and hot water tanks.
2. Keep away from heat, sparks and open flames of any kind. Use only in well-ventilated areas; open windows and doors. Do not smoke in work area.
3. Holding the can 6” to 8” away from surface to be sprayed, depress the spray tip (with arrow pointed away from body) and apply a uniform coat.
• For porous substrates: Applying two coats in a perpendicular direction to each other will increase bond strength.
• For permanent bonds: Apply a heavy coat to both surfaces.
• For temporary bonds: Apply a light coat to one surface only and bond. Read precautions on label before using.
4. Before bonding, allow coated surfaces to dry thoroughly for 10 to 20 minutes under normal conditions (at about 70˚F). When dry, the adhesive will adhere but not transfer to the finger when touched. If the adhesive dries too firmly (after more than three hours), it may be reactivated by applying another coat of adhesive.
5. Place both surfaces to be bonded in the exact position desired.
6. Apply pressure to the entire surface by using a hand roller. Pressure should be applied from the center toward the edges to prevent air entrapment and to ensure positive bonding.
7. Use mineral spirits and a white cotton cloth to remove excess adhesive. Use caution with mineral spirits, which may be harmful to some materials.

Note: To clear the spray tip, invert can and spray.
Note: This adhesive bonds instantly on contact and cannot be repositioned.
**TECHNICAL DATA**

<table>
<thead>
<tr>
<th>Feature</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Polymer type</td>
<td>Synthetic rubber</td>
</tr>
<tr>
<td>Percent solids</td>
<td>18% to 20%</td>
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<tr>
<td>VOCs</td>
<td>491 g/L</td>
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<tr>
<td>Shelf life</td>
<td>2 years</td>
</tr>
<tr>
<td>Storage conditions</td>
<td>50°F to 90°F</td>
</tr>
<tr>
<td>Flash point (Tag)</td>
<td>-156°F</td>
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</tbody>
</table>

Note: Protect containers from freezing in transit and storage. Provide for heated storage on site and deliver all materials at least 24 hours before work begins.

**PACKAGING**

<table>
<thead>
<tr>
<th>Product Code</th>
<th>Size</th>
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</thead>
<tbody>
<tr>
<td>95283221</td>
<td>14 U.S. oz. (414 mL) aerosol can</td>
</tr>
</tbody>
</table>

**FOR PROFESSIONAL USE ONLY**

Before using, user shall determine the suitability of the product for its intended use and user alone assumes all risks and liability whatsoever in connection therewith. **ANY CLAIM SHALL BE DEEMED WAIVED UNLESS MADE IN WRITING TO US WITHIN FIFTEEN (15) DAYS FROM DATE IT WAS, OR REASONABLY SHOULD HAVE BEEN, DISCOVERED.**