



# Product Evaluation Report

**PER-05003**

This Document Published By:

*Progressive Engineering Inc.*

Initial Listing  
August, 1998

Re-Approved  
April, 2008

58640 State Road 15  
Goshen, Indiana 46528

574-533-0337  
[www.p-e-i.com](http://www.p-e-i.com)

**Listed Product**

**ITW Tacc Polyurethane Center F6400LV**

One-Part Polyurethane Structural Adhesive

**Listed For**

**ITW Tacc Polyurethane Center**

195 DeMille

LaPeer, MI 48446

**Approved Manufacturer**

**ITW Tacc Polyurethane Center**

195 DeMille

LaPeer, MI 48446

*Progressive Engineering Inc. is an accredited Testing Laboratory and Third Party Quality Control Agency. This Product Evaluation Report represents a product that Pei has a follow-up service agreement with. This Product Evaluation Report in no way implies warranty for this product or relieves ITW TACC Polyurethane Center of their liabilities for this product. Pei is accredited to comply with ISO Standard 17020 and 17025. This Product Evaluation Report is an official document if it is within one year of the initial or renewal date.*

**Listing Details**

F6400LV Adhesive is a structural adhesive used to bond wood, gypsum board and plywood by applying adhesive beads between these materials and using mechanical fasteners.

**Product Description**

F6400LV is a One-Part, moisture cure polyurethane adhesive meant to be used in an indoor manufacturing facility. F6400LV is not to be applied in an outdoor uncontrolled environment.

**General Product Use**

1. F6400LV is to be applied in temperature conditions between 60<sup>0</sup>F. to 90<sup>0</sup>F. and should remain in those conditions for a minimum of 24 hours.
2. All substrate surfaces should also be between 60<sup>0</sup>F. And 90<sup>0</sup>F.
3. Proper storage temperature of F6400LV should be 60<sup>0</sup>F. to 110<sup>0</sup>F.
4. All surfaces must be free from grease, oil, mold release agents, gypsum dust and all loose particles.
- 5 F6400LV is applied using 1/16" to 1/8" wide continuous beads by using a squeeze bottle or pressurized dispensing equipment.
6. The maximum open time for F6400LV is 15 minutes.
7. Construction of assemblies using F6400LV and their design values should be as described in the following test reports.

**Tested to**

California CA 25-4  
**Pei** 93-7 Standard  
ASTM E 72

ASTM C 557  
ASTM D 3498  
ASTM D 6464

AFG01

**Product Documentation**

A MSDS sheet dated 8/8/2002

F6400LV Guidelines for Use, Application, safe handling dated January 17, 2006

A Quality Control Manual Dated 6/8/2006

Letters dated September 29, 1998 and August 15, 2003

A follow-up Listing & Inspection agreement between *Progressive Engineering Inc.* and **ITW TACC Polyurethane Center**

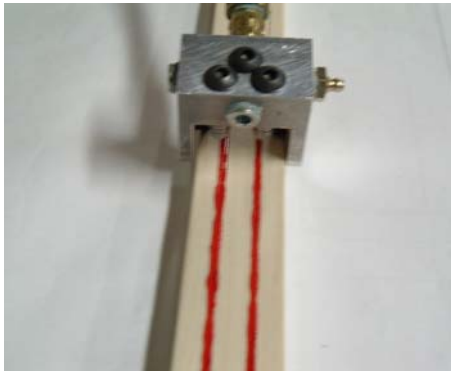
The following is a list of the *PEI* test reports for F6400LV adhesive.

1989-1850A	1997-1800	1998-2308C	2003-0949A
1989-1850B	1997-2080A	1998-2744A	2003-0949B
1993-0374	1997-2080B	1998-2744B	2003-0949C
1997-1388A	1997-2080C	1998-2744C	2003-0949D
1997-1388B	1997-2080D	1998-3484	2003-0949D
1997-1388C	1997-2080E	2000-1240	2003-0949E
1997-1388D	1997-2080F	2000-1416	
1997-1388E	1998-1898	2000-1518	
1997-1610	1998-2308A	2002-1692	
1997-1636	1998-2308B	2003-0677	

**Product Labeling**

Each container shipped of F6400LV that is covered by this Product Evaluation Report must have a label attached with at least the following information:

1. ITW TACC's name and address.
2. Date of manufacture
3. Shelf Life
4. This Product Evaluation Report number & Pei's logo



Single/Dual Bead Application Head



F6400LV - 55 gallon  
Plastic Drum Container



Typical F6400LV Application



F6400LV - 275 gallon Tote Container  
Sealed Gravity Feed Supply Setup