

Technical Data Sheet

Pattex 100% Glue 50 g Bottle

CHARACTERISTICS

- 0% solvents – Suitable for use on polystyrene
- 100% concentrated formula – extra bonding power
- Extra strong and shock resistant – suitable for use in vehicles
- UV resistant – suitable for outdoor applications
- Waterproof once cured – suitable for use in bathrooms and kitchens
- Flexible – suitable for use on shoes
- Can resist temperatures between -50 °C and 80 °C – suitable for use in vehicles
- Fully transparent – suitable for glass and crystal applications
- Adjustable for up to 30 minutes – perfect for crafting applications

APPLICATION FIELD

- For DIY, repair and modelling work in and around the house
- Glues and coats many absorbent and non-absorbent materials like aluminium, concrete, stainless steel, tiles, glass, wood, ceramic, cork, copper^{*1)}, varnished surfaces^{*2)}, glass-fibre reinforced polyester (GFP), leather, linen, brass^{*1)}, paper, cardboard, rigid PVC, polycarbonate, steel, polystyrene foam (Styrofoam®), mirrors^{*3)}, stones/natural stones, zinc
- For producing decorative objects with a crystal-clear coating
- Not suitable for polyethylene (PE), polypropylene (PP), polytetrafluoro-ethylene (PTFE) (Teflon®), ABS and rigid polystyrene.

INSTRUCTIONS FOR USE

Pretreatment

The surfaces to be joined must be load-bearing, dry and free of grease and dust. If necessary, vacuum the surfaces and clean them with a solvent (e.g. cleaner's naphtha, alcohol). Completely remove old adhesive and sealant residues as well as badly adhering paint coats. If necessary, protect adjoining areas by masking



them off with films or adhesive tapes.

^{*1)} Before application, carry out tests to ensure the compatibility of Pattex 100% Glue with non-ferrous metals like copper, bronze and brass.

^{*2)} Before application, carry out tests and check on a case-to-case basis if Pattex 100% Glue is compatible with different coating systems (paints, varnishes, powder coatings).

^{*3)} Only glue mirrors whose reflection and protective coating complies with DIN 1238, 5.1 and DIN EN 1036.

Application

The application of Pattex 100% Glue depends on the materials to be glued. Usually, single-sided application is sufficient. The amount of adhesive depends on the absorbency of the substrate. Smooth materials of no or low absorbency can be safely glued already with a relatively small amount of adhesive / thin layer of adhesive. Very porous materials of high absorbency require a larger amount of adhesive – in special cases even application on both sides. Join the parts immediately after applying the adhesive and secure them for at least 30 minutes with adhesive tape or a screw clamp.

Pattex 100% Glue cures by absorbing moisture from the environment. It must therefore be ensured by all applications that moisture – either from the ambient air (air humidity / water vapour) or from the substrate – can reach the bonded area to diffuse into the adhesive.

Non-absorbent, smooth materials (plastics, metals) are normally water-impermeable. If both surfaces to be joined are made of such materials, they can better be glued with Pattex 100% Glue if surfaces have been pre-wetted immediately before applying the adhesive, e.g. by wiping with a damp cloth. Make sure to avoid wetness, pooling water or drop formation. In case of large areas, take care that the moisture film does not dry off before applying the adhesive.

Absorbent substrates are normally water-permeable. The adhesive can therefore be applied over the full surface without problems. In general, the curing process can be considerably accelerated for both absorbent and non-absorbent substrates if the surface is pre-wetted. Under normal circumstances, it is sufficient to wipe off the areas to be glued with a damp cloth before applying the adhesive.

Pattex 100% Glue can be applied on damp substrates without problems. The adhesive reaches its maximum strength after it has fully cured AND after the adherent surfaces have fully dried. If the adherent surfaces remain wet or under water, this will distinctly reduce the maximum adhesive strength. In particular, this applies to absorbent substrates like concrete or masonry.

Important information:
Compatibility with paints

Pattex 100% Glue is compatible with acrylic paints, DD lacquers (polyurethane-based varnishes) and alkyd resin varnishes. When using alkyd resin paints, drying may be delayed. Pattex 100% Glue is not compatible with one-component PU paints.

TECHNICAL DATA

Composition	Silane-curing polymer
Density	1.10 g/cm ³ at 25°C
Colour	transparent
Application temperature	-5°C up to +40°C

Open time(at 13°C, 50% R.H.)	10-15 min
Consumption	230 g/m ² when applied on one side; the required amount depends on the substrate absorbency
Final strength (DIN EN 205)	After about one day, depending on temperature, humidity and substrate material
Temperature resistance	-40°C to +80°C (short-term exposure)
Tensile shear strength according to DIN EN 205	2.0 – 4.0 N/mm ²
Shelf Life	12 months

LIMITATIONS

Cleaning tools

Clean the tools immediately after use with alcohol or cleaner's naphtha.

Storage

Store the product tightly closed in a cool and dry place.

HEALTH AND SAFETY

Before using the product please see related Material Safety Data Sheet that is available on request. Pattex 100% Glue has been classified as non-hazardous according to the current Dangerous Preparations Directive. Please make sure to observe the hygiene measures specified in the Safety Data Sheet.

DISPOSAL

Fully dried product residues can be disposed of as domestic waste. Dispose of non hardened product residues according to the applicable local regulations. Large product amounts must be disposed of separately. Waste disposal code (according to EWC): 08 04 10.

“The information provided in this Technical Data Sheet (TDS) including the recommendations for use and applications of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.”

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