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Technical Data Sheet – Master File

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Revision: 1
Issued: 21.06.2018
Number of pages: 3

Pattex Contact Adhesive



Description

Pattex Contact is a general-purpose contact adhesive which is Toluene free.

Application

Pattex Contact Adhesive can be used to bond the following substrates without the need for clamping:

- wood and chipboard
- cork
- felt
- leather
- ceramics
- metals
- vinyl

The bond formed is flexible.

Technical data

Viscosity: approx. 1700 mPa.s at 25 °C
Total solids: approx. 19 %
Density (SG): approx. 0.860 at 25 °C
Drying time: approx. 25 min., varies with ambient temp, humidity, passage of air across substrates.
Open time: 15 to 45 min., varies with ambient temp, humidity, porosity of substrates
Initial bond strength: approx. 80 % of final bond strength achieved immediately (approx. 60minutes)
Final bond strength: achieved after 24 hours
Temperature resistance: -10 °C to +80 °C, depending on duration of exposure to heat and stress

Directions for use

- For optimum results, use the adhesive between 15 °C and 25 °C.
- The surface to be filled must be clean and free of dust and grease to ensure excellent bonding. Surfaces can be lightly roughed to improve the anchoring of adhesive onto the substrate.
- Stir adhesive before use.
- Apply a thin film of Pattex Contact Adhesive to both surfaces using a brush or spreader. Porous surfaces may require two coats, as the adhesive soaks into the substrate, leaving insufficient adhesive at the glue line for a satisfactory bond.
- Allow adhesive to dry. Test with the back of your fingers, not greasy fingertips.
- Join carefully, (as moving the substrates after the initial touchdown will reduce the potential bond strength), with pressure. The strength of the bond formed is a function of the pressure with which the two substrates are brought together rather than the duration of clamping. Remove excess adhesive with benzine.

Clean up

Spillage's can be cleaned with acetone or Tangit Cleaner.

Storage

Store in a cool, dry place. Strict batch rotation must be observed.

Shelf life

The life of an unopened container, stored correctly, is 12 months.

Health and Safety data

Keep lid closed always. Do not smoke, work near a naked flame or machines that produce sparks when working with Pattex Contact Adhesive. The solvent vapors are flammable. Work in a well-ventilated area.

Wash hands well after working with Pattex Contact Adhesive, and wear gloves in cases of prolonged exposure. Clean hands with solvent before the adhesive dries. Wash hands with soapy water before eating or drinking.

Pack sizes available

50ml tube
100ml tube
250 ml tin
500 ml tin
9 x 1 litre tin
6 x 2 litre tin
4 x 5 litre tin

HEALTH AND SAFETY

Before using the product please see related Material Safety Data Sheet that is available on request.

"The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application 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. f.

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