



Technical Data Sheet



Technical Data Sheet
Ref: NRPTX8000TDS
Issued: 20.04.20
Number of pages: 3

PatTex Solvent Free Contact Adhesive



CHARACTERISTICS

- Water based contact adhesive
- Heat- resistant
- Homogeneous adhesive film
- User - friendly formulation
- High solids for high bonding strength
- Fast tacking for immediate handling
- High coverage & efficiency
- Easy cleaning of working tools with water

APPLICATION FIELD

- For easy and rapid bonding of large areas and lamination of substrates with high pressure laminate etc.
- For bonding decorative laminates and veneer strips, wood, MDF, metal, cork, leather, rubber, rigid PVC, soft foams etc.

INSTRUCTIONS FOR USE

Pretreatment

Surfaces must be close fitting, clean, dry and free from dust, grease or paint. Coated or treated surfaces should be stripped and cleaned beforehand.

Important: Clean laminates, metal etc. with methylated sprit and allow to dry before applying adhesive. Abrasion of surfaces to be bonded will increase bond strength. Allow materials to acclimatise according to manufacturer's instructions before bonding.



Application

1. Apply a thin, even coat of adhesive to both surfaces, especially at the edges, using a serrated spreader or clean, short bristled brush. Ensure the entire surface to be bonded is covered. For best results apply adhesive at temperature of +18°C to +25°C
2. Allow the adhesive to dry until it turns from white to completely transparent and touch dry. There must be an unbroken, visible film of adhesive left on the surface. It may be necessary to apply several coats of adhesive to highly absorbent materials. Parts to be bonded should be pressed within 30 minutes after drying.
3. Carefully align parts and press together. Apply firm pressure for a few seconds from the centre of the bonded area outwards, ensuring that any air bubbles are pressed out. Press carefully on edges. Use a rubber roller on large surface areas such as laminate panels. **Important:** Bonding will be instant and not repositionable

TECHNICAL DATA

Composition	Water-based, resin modified polymer dispersion
Solid content	Approx. 55%
Heat resistance	- 30°C up to 110°C
Evaporation time	The adhesive should be clearly transparent before the materials are being bonded. (Visible test: Adhesive colour changes from white to clear). Before pressing the parts together, the surfaces must be touch-dry (Finger-test)
Open time/ application time	After drying of the adhesive, bonding is possible within 30 minutes
Application temperature	+18 to +25°C Heat accelerates, cold slows down the evaporation
Consumption	100-150 g/m ²
Final strength (DIN EN 205)	3 days depending on surface area and pressure applied
Shelf Life	24 months From date of production, when stored in cool, dry conditions, protected from sunlight
Evaporation time	The adhesive should be clearly transparent before the materials are being bonded. (Visible test: Adhesive colour changes from white to clear). Before pressing the parts together, the surfaces must be touch-dry (Finger-test)

LIMITATIONS

Not suitable for polyethylene (PE), polypropylene (PP), expanded polystyrene, synthetic leather and plasticised PVC.

Adhesive should be used on flat, horizontal surfaces.

Cleaning tools

Clean tools immediately after use with water.

Storage

Store tightly closed and at room temperature. Avoid temperatures lower +5°C and above +50°C.



PACKAGING

35g aluminium tube

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.

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.

Henkel Norden AB

Box 151 22

Gustavslundsvägen 151A

SE-167 15 Bromma, Sweden