



# Technical Data Sheet



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## Pattex Transparent Contact Adhesive



### CHARACTERISTICS

- Transparent contact adhesive
- Flexible
- Resistant to ageing
- High initial tack
- No plasticiser migration

### APPLICATION FIELD

- Combination bonding of wooden materials with decorative laminates such as Resopal®, Formica® etc., rubber, leather, cork, felt, rigid PVC, soft foams, metal and many other materials.
- Especial high bonding strength when bonding hard and soft plastics (e.g. hard and soft PVC, Polycarbonate, Plexiglas®, ABS, Polystyrene).
- Suitable for visible glue joints, transparent materials, paper and cardboard

### 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 white 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 for approx. 5 to 10 minutes until touch dry (the adhesive film must not stick to the finger). After evaporation of the solvents 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.
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	Polyurethane
Density	Ca. 0,87 g / cm <sup>3</sup>
Heat resistance	-40°C up to +70 °C
Open time	After evaporation time, bonding is possible within 60 minutes
Application temperature	Pattex Contact transparent should preferably be used at temperature of +18°C to +25°C
Consumption	250-350 g/cm <sup>3</sup>
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	5-10 minutes At room temperature, depending on surface properties

## LIMITATIONS

Not suitable for polyethylene, polypropylene, expanded polystyrene, synthetic leather and PTFE.

Adhesive should be used on flat, horizontal surfaces.

### Cleaning tools

Clean tools immediately after use with thinner or acetone.

### Storage

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

## PACKAGING

50g 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.

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