Heavy Duty Contact Cement

DESCRIPTION

LEPAGE® Heavy Duty Contact Cement is our strongest contact cement. This formulation is low VOC offering a bond resistant to heat, creep, water and oil. It dries quickly, bonds immediately and does not require clamping. This product is recommended for bonding flat and close mating surfaces.

Available As:

Item #	Package	Size	Colour
2994433	Metal pail	3.8 L (128 fl. oz.)	Tan
2994432	Metal tin	946 mL (32 fl. oz.)	Tan
2994431	Metal tin	236 mL (8 fl. oz.)	Tan
3002047	Metal tin	118 mL (4 fl. oz.)	Tan
2994441	Carded squeeze tube	30 mL (1 fl. oz.)	Tan

FEATURES & BENEFITS

- Delivers a strong, fast bond
- Low VOC
- Clamping not required

RECOMMENDED FOR

LePage Heavy Duty Contact Cement was designed for use on flat and close mating surfaces and is recommended for bonding wood, laminates, leather, cork, rigid PVC, metal and many other materials.

LIMITATIONS

- Not suitable for use on polystyrene or polyurethane foams
- May damage some hard plastics and painted surfaces
- Do not use on brass, copper or other copper alloys or allow contact with these materials during storage
- Thickened product cannot be thinned
- Test for compatibility before using

COVERAGE

For a 30 mL (1 fl. oz.) tube: approximately 0.2 m^2 (2.1 ft^2) one coat, one side only

For a 118 mL (4 fl. oz.) tin: approximately 0.4 m^2 (4.3 ft^2) to 0.8 m^2 (8.6 ft^2) per surface, per coat, per can

For a 236 mL (8 fl. oz.) tin: approximately 0.6 m^2 (6.5 ft^2) to 1.2 m^2 (13 ft^2) per surface, per coat, per can

For a 946 mL (32 fl. oz.) tin: approximately 2.4 m^2 (25.8 ft^2) to 3.1 m^2 (33.4 ft^2) per surface, per coat, per tin

For a 3.8 L (128 fl. oz.) pail: approximately 9.5 m^2 (102.3 ft^2) to 12.5 m^2 (134.5 ft^2) per surface, per coat, per pail

Note: Yields shown are based on theoretical calculations, for comparison purposes, and will vary depending on porosity, roughness of surface and thickness of application

TECHNICAL DATA

Typical Uncured Physical Properties		Typical Application Properties	
Colour:	Tan	Application Temperature:	Apply above 15°C (60°F)
Appearance:	Liquid	Odour:	Pungent
Base:	Synthetic Rubber	Open Time:	15 – 60 minutes*
Specific Gravity:	0.845 – 0.869 at 25°C (77°F)	Cure Time:	24 hours*
Viscosity:	1,000 - 1,400 cp	Clean Up:	Clean up wet adhesive with acetone or d-limonene based glue remover. Dry adhesive may be cut or scraped away with a sharp-edged tool.
VOC Content:	54.35 % by weight		

** At 25°C (78°F); time is dependent upon temperature, humidity, and amount of adhesive applied.*

TECHNICAL DATA

Shelf Life:	24 months from date of manufacture (unopened)	Lot Code Explanation: 22304 22 = last two digits of the year of manufacture (2022) 304 = Julian date code, 304th day of the year (October 31) Date of manufacture = October 31, 2022

Typical Cured Performance Properties

Colour:	Tan	Service Temperature:	-40°C (-40°C) to 70°C (158°F)
Water Resistance:	Yes		

DIRECTIONS

Tools Typically Required:
Stir stick, brush or short nap roller, J-roller or 3-inch wide rubber roller

Safety Precautions:
Wear gloves and use in a well-ventilated area. Read all label warnings and precautions before beginning work.

Surface Preparation:
The temperature of the adhesive, the surfaces being bonded, and the working area should be above 15°C (60°F). Surfaces must be flat and close-fitting, clean, dry, free of paint or other coatings, grease, dust, and other contaminants and irregularities. To improve adhesion to smooth or glossy surfaces, roughen by lightly sanding. Pre-fit all materials before applying adhesive as bonding will be immediate upon contact. Stir adhesive until uniform.

Application:
Apply an even, generous coat to both surfaces using a brush or short nap roller. Coverage will vary with porosity, roughness of the surface and thickness of the application. Very porous surfaces, such as particleboard and plywood, require two coats. Between coats and before joining substrates, allow a minimum of 15 minutes or longer drying time (at 23°C and 50% relative humidity) until glue doesn't transfer to a gloved finger or kraft paper. Heavy adhesive application, high humidity or low temperatures can lengthen the time for adequate drying. The adhesive must be allowed to dry before bonding but if the surfaces are left to dry too long, applying another thin coat will reactivate the adhesive.
When adequately coated, dry contact cement should have a uniform, glossy appearance. Any dull spots indicate a second coat of adhesive is required. Dull spots occur because either too little adhesive was applied or because of excessive absorption into the surfaces. When applying edge banding to particle board and plywood end cuts, a minimum of 2-3 coats to the edges will be required.

Carefully position materials since bonding is immediate and parts cannot be repositioned once contact has been made. Dowels or clean rods placed between the substrates can be used to aid in positioning when bonding large surfaces. These are then removed before making contact. Apply pressure, working the entire area from the centre to the edges using a J-roller or narrow roller over the entire surface. Roll in two directions at 90° to each other paying special attention to the edges. Apply as much pressure as possible without damaging the materials. A pinch roller or rotary press may also be used. Bonded assemblies may be trimmed, cut, or machined immediately after bonding.

Bonding failures:

Delamination and bubbling may be a result of the following:

1) Insufficient adhesive
2) Insufficient or excessive drying time before bonding. If insufficient drying time is allowed, solvents become trapped and will lead to bubbling.
3) Inadequate pressure applied when bonding
4) Inadequate contact because of irregularities in the surfaces being bonded which prevent the adhesive layers contacting each other when applying pressure
5) Excessive humidity, which can result in moisture formation at the glue line as solvent evaporates
6) Cold temperatures during application may prevent the adhesive from making adequate contact

In some cases, delamination or bubbling of the laminate can be corrected by reactivating the adhesive by using a hot iron over a towel to protect the surfaces and then immediately reapplying pressure. It may be necessary to pierce the bubble by making a very fine hole or cutting with a knife to allow any vapours to escape.

Clean-up:
Clean tools and adhesive residue immediately with Acetone or a d-limonene based adhesive remover. Cured contact cement may be carefully cut away with a sharp-edged tool.

STORAGE & DISPOSAL

Store at room temperature between 16°C (60°F) and 27°C (80°F) for optimal shelf life. Close lid tightly to prevent drying and contamination. Do not transfer to other metal containers or leave objects that may rust (e.g. brushes) sitting in the adhesive. Do not pour down drains.

Recommended method of disposal for unused product: Allow product to harden and dispose of according to provincial and federal governmental regulations.

LABEL PRECAUTIONS

POISON! DANGER! HIGHLY FLAMMABLE LIQUID AND VAPOUR. FUMES MAY BE HARMFUL AND MAY CATCH FIRE. MAY IRRITATE EYES AND SKIN. Do not breathe fumes. Do not smoke. Use only in a well-ventilated area. Keep away from flames, such as a pilot light, and any object that sparks, such as an electric motor. Do not get in eyes or on skin or clothing. Do not swallow. **KEEP OUT OF REACH OF CHILDREN.**

FIRST AID TREATMENT: Contains acetone, butyl acetate, naphtha, and butanone. If swallowed, call Poison Control Centre or doctor immediately. Do not induce vomiting. If breathed in, immediately remove the affected person to fresh air. If in eyes, rinse immediately with plenty of water for 15 minutes, and seek immediate medical attention. If on skin, immediately rinse skin thoroughly with plenty of running water. If symptoms develop and persist, seek medical attention.

Refer to Safety Data Sheet (SDS) for further information.

DISCLAIMER

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Henkel recommends purchasers/users should test the products to determine acceptable quality and suitability for the intended use. All adhesive/sealant applications should be tested under simulated or actual end use conditions to ensure the adhesive/sealant meets or exceeds all required project specifications. Since assembly conditions may be critical to adhesive/sealant performance, it is also recommended that testing be performed on specimens assembled under simulated or actual production conditions. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement, or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

LIMITED WARRANTY

This product is warranted by Henkel Corporation to be free from defects in materials when used as directed. Henkel's sole obligation shall be, at its option, to replace or refund the purchase price of product proven to be defective. Henkel makes no other warranty – express or implied – including warranties of MERCHANTABILITY and FITNESS FOR A PARTICULAR PURPOSE and will not be liable for consequential or incidental damages. For warranty assistance, contact Henkel at 1.800.624.7767 M-F 9:00 am to 4:00 pm ET.

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