QUALITY FROM Henkel

Technical Data Sheet

Pattex Contact Adhesive Classic

I. Product:

Nature of product:

Solvent-based contact adhesive.

Field of application:

- 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. Not suitable for expanded polystyrene, polyethylene, polypropylene, synthetic leather and plasticized PVC.
- Fixing of soundproofing, insulating and acoustic panels (except expanded polystyrene), of suitable plastic tiles and various types of wallcoverings (not plasticized PVC or synthetic leather) onto dry, stable surfaces
- Bonding veneer strips to edges and curves

Package size:

Tubes of 50 g
Tubes of 125 g
Tins of 250 g
Tins of 650 g
Canisters of 4.5 kg

Shipping unit:

PX 40 = 4 x 10 tubes of 50 g
PX 30 = 3 x 10 tubes of 125 g
PX 12 X= 12 tins of 250 g
PX 10 = 10 tins of 650g
PX 4 = 4 Canisters of 4.5 kg

II. Characteristics:

- High shear strength
- Extremely heat resistant
- Excellent green strength

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Composition :

Polychlorbutadiene

Final bonding strength :

Reached after 3 days, depending on the materials and the pressure applied.

Density :

0.89 g/cm³

Consumption :

250 - 350 g/m² for two-sided application of adhesive

Temperature resistance :

Up to 110° C

Resistance :

The bonding are extremely resistant to water, diluted acids and alkaline solutions. They resist cold (-40°C) and heat up to 110°C.

Working temperature :

Pattex Contact Adhesive should preferably be used at room temperature of +18 to +25°C. Dry warmth accelerates evaporation of the solvents, cold slows it down.

III. Directions for use:

Material preparation :

The material to be bonded should be dry (wood 8 to 12% moisture) and free of grease and dust. Clean laminates, metal etc. with solvent (washing benzine). Additional abrading increases bonding strength with metals. Allow materials to acclimatise according to manufacturer's instruction.

Only glue working materials to non-treated surfaces (natural base).

Painted surfaces should be stripped beforehand.

Application :

Apply Pattex generously and evenly to both surfaces to be bonded - especially at the edges - with a Pattex serrated spatula or a short-bristle brush.

Evaporation :

Before joining the parts, allow solvents to evaporate. Evaporation time at normal room temperature (18 to 25°C) is approx. 15 minutes.

Important information :

Ensure constant airing. After evaporation time, bonding is possible within 2 hrs. 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 large-pored or highly absorbent materials. Before the parts can be joined, the adhesive must be dry to the touch. It should not stick to the finger or be "stringy".

Bonding / Pressing :

First of all, carefully align the parts to be bonded, adjusting will not be possible after the two adhesive films are contacted. Then press the parts together briefly, but with pressure (0.5 N/mm^2 = 5 kg/cm^2 pressure, or more). It should be noted that the bonding strength depends not on the duration but the intensity of the pressure applied. Pressing for a few seconds is sufficient. With larger areas to be bonded, e.g. laminate panels, metals etc., the pressure should be applied with a press. Depending on the work-piece, vigorous rolling (Pattex Pressure Roller) can also be sufficient. Press from centre outwards to avoid trapping air. Press carefully on edges. Where hard and inelastic bases are used, beat with a non-flexible hammer (HAZET hammer).

Further processing :

Initial bonding strength is so high, that the work-piece can be further processed immediately after pressing.

IV. Important remarks:

Cleaning tools :

Clean tools immediately after use with thinner or washing benzine.

Removal of stains :

Carefully wipe off fresh spots on work-pieces with a benzine-soaked cloth. Dried stains of Pattex Contact Adhesive on textiles can be removed by chemical cleaning. On other surfaces remove stains with thinner, test first whether it causes damage.

Storage :

Store tightly closed and at room temperature. Cold or frozen adhesive (under + 5°C) will become fully usable again if slowly acclimatised up to working temperature (approx. +20°C) and vigorously stirred. No loss of quality is suffered. During work pauses the adhesive container should be kept tightly closed in order to prevent evaporation of the solvents.

For safety instructions please look at the Safety Data Sheet.

The above instructions are based on thorough trials and on general experience gained in this field. As it is impossible to survey all installation methods and in view of various different working conditions, we cannot, however, claim that the information given is complete. We therefore recommend that tests should be carried out on your own to ensure the greatest possible success.

Henkel KGaA