

Technical Data Sheet

Technical Data Sheet
Revision: 0
Issued: 01.07.2024
Number of pages: 3

Pattex Contact Adhesive

PRODUCT DESCRIPTION

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

CHARACTERISTICS

- High initial and final strength
- High heat resistant
- Resistant to ageing
- Bonds a wide variety of similar and dissimilar Substrates

APPLICATION FIELD

- Combination bonding of wooden materials with decorative laminates, rubber, leather, cork, felt, rigid PVC, soft foams, metal, and many other materials.
- Fixing of soundproofing, insulating and acoustic panels, of suitable plastic tiles and various types of walls covering onto dry, stable surfaces
- Bonding veneer strips to edges and curves

LIMITATIONS

- Not recommended for use as a structural adhesive.
- Not suitable for polyethylene, polypropylene, expanded polystyrene, synthetic leather, Teflon, and not plasticized PVC.
- Not suitable for repair of items that hold hot liquids or where heat resistance above 80°C is required.

SAFETY INSTRUCTIONS

When working with product, it is advisable to wear gloves and safety glasses to avoid direct contact with the skin or eyes. If product comes in contact with skin or eyes flush thoroughly and immediately with water. If irritation continues, seek medical attention.

Pattex Contact Adhesive is flammable, thus keep away from naked flames and ignition sources and use in a well-ventilated area.





INSTRUCTIONS FOR USE

Surface preparation

- The material to be bonded should:
 - Be dry (wood 8 to 12% moisture)
 - Be free of grease and dust.
- Clean laminates, metal, etc., with solvent (washing benzine).
- Additional abrading increases bonding strength.
- Allow material to acclimatize according to the manufacturer's instruction.
- Only bond material to properly prepared and cleaned surfaces.
- Painted or treated surfaces should be stripped beforehand.

Directions for use

- Apply Pattex Contact Liquid generously and evenly to both surfaces, especially at the edges. Use a serrated spatula or short-bristle brush.
- Allow solvents to evaporate (10-15 minutes at 18°C to 25°C)
- Ensure constant airing during evaporation.
- Insufficient evaporation time may weaken bonding, especially for non-absorbent materials.
- Ensure an unbroken, visible film of adhesive remains after evaporation. Multiple coats may be needed for large-pored or highly absorbent materials.
- Adhesive must be dry to touch before joining parts (Should not stick to the finger or be stringy")

Bonding / Pressing:

- Carefully align the parts to be bonded; adjustment is not possible after contact.
- Press the parts together briefly but with pressure,
- Bonding strength depends on the intensity of the pressure, not the duration.
- Pressing for a few seconds is sufficient (Recommended pressure: 0.3 - 3.0 bar)
- Depending on the piece, vigorous rolling can also be sufficient.
- Press from the centre outwards to avoid trapping air.
- Press carefully on the edges.
- Where hard and elastic bases are used, beat with a non-flexible hammer.

Further processing:

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

CLEANING TOOLS

Clean tools immediately after use with thinner or washing benzine.

STORAGE

Store tightly closed and at temperature between +5°C and +30°C.

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

Product Packaging

50g tube, 125g tube, 250ml tin, 500ml tin



TECHNICAL DATA

Composition	Solvent based polychloroprene rubber
Viscosity (Brookfield RVT, 20, 50 rpm)	1.800 - 2.300 mPa.s
Density	0.84 - 0.88 g/cm ³
Heat resistance	up to 110°C
Application temperature	+18°C to +25°C
Consumption	250 - 350 g/m ²
Final strength	after 3 days
Shelf Life <i>(Note: When stored in a cool and dry place)</i>	24 months
Evaporation time <i>(Note: Evaporation rate of solvent in product increases with increasing room temperature)</i>	10 - 15 min.

HEALTH AND SAFETY

Before using the product, please see related Material Safety Data Sheet, available at 'mysds.henkel.com'.

"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 SA (Pty) Ltd

Toll Free Number: 0800 13 81 81 or visit

Website: www.pattex.co.za