



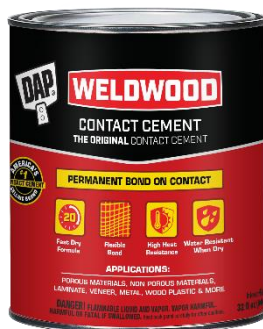
# TECHNICAL DATA SHEET

2400 Boston Street | Suite 200 | Baltimore, MD | 21224

## DAP® WELDWOOD® Original Contact Cement

### PRODUCT DESCRIPTION

**DAP WELDWOOD Original Contact Cement** is a polychloroprene rubber-based contact adhesive that forms permanent bonds on a variety of surfaces. This professional quality adhesive offers instant adhesion to eliminate the need for clamps or temporary fasteners. Used extensively to bond high pressure laminates for counter tops, tabletops, and cabinets. Forms a durable, super-strong bond when parts are assembled, and momentary pressure is applied. Meets performance requirements of Federal Specification A-A-1936A (superseding Federal Specification MMM-A-130B). Meets all CPSC requirements.



PACKAGING	COLOR	UPC
Pint	Tan	7079800271
Quart	Tan	7079800272
Gallon	Tan	7079800273

### KEY FEATURES & BENEFITS

- Premium, professional quality adhesive
- Dries in 15-20 minutes
- High heat resistance
- Water resistant when dry

### PERFORMANCE CHARACTERISTICS

- Spreads on easily and requires only one coat on most porous and non-porous surfaces.
- Dries tack free quickly and offers a long open time of up to 2 hours.
- When pressed together, surfaces bond instantly on contact with high green strength, allowing immediate use of assembly.
- Cured bond resists the effects of heat (up to 180°F), water, weather, grease, oil and household chemicals. Interior/exterior use.



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## SUGGESTED USES

Ideal for bonding:

- High Pressure Laminates
- Wood and Plastic Veneers
- Paneling
- Leather
- Fabrics
- Rubber
- Paper
- Cardboard
- Bonding other materials to wood, particle board, plywood, metal, concrete and similar surfaces

## APPLICATION

### **Surface Preparation & Application:**

Read, understand and follow all instructions and health and safety information before opening and using this product. Make sure the coated surfaces feel tacky before bonding.

### **Preparation:**

1. Stir Contact Cement thoroughly with a standard paint paddle or stirring stick.
2. Pre-fit all parts before applying Contact Cement.
3. Both surfaces must be clean, dry and free of foreign materials. Painted or non-porous surfaces must be roughened before adhesive is applied. For best results, at least one surface to be bonded should be porous.
4. The temperature of air, adhesive and surfaces should be above 65°F (18°C) for a minimum of 24 hours before and after application to ensure proper drying and bond strength.

### **Application:**

**Spray Application:** Satisfactory spray results can be achieved with practically any air spray equipment. Contact industrial spray gun manufacturers for their latest model recommendations and the proper pressure and spray settings.

1. All wetted application (pressure pot) components must be plastic, stainless steel or nickel plated. Hose should be either nylon lined or flexible polyethylene.
2. Direct spray perpendicular to the plane of the substrate from approximately 10 to 12 inches away. Spray a coat of cement on both surfaces to be bonded.
3. Application of 2.5 to 3.5 grams of dry cement per square foot provides an excellent bond. More than one coat is recommended for porous substrates. Apply additional coats after first has dried (60-70 minutes).

### **Brush or Roller Application & Assembly:**

1. Using a paint brush, short nap roller or finishing trowel, apply an even coat of adhesive to both surfaces. If the dried surface has a glossy appearance (like varnished surface) sufficient adhesive has been applied. If substrates are porous more than one coat may be required.
2. Allow both surfaces to dry 15-20 minutes (dependent on temperature and humidity). Dry Contact Cement will feel tacky and appear glossy. If surfaces are not assembled within 2-3 hours, applying an additional coat of Contact Cement can reactivate adhesive.



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3. Align surfaces into exact position and press together, moving from one end to the other to avoid bubbles. Contact cement bonds permanently with pressure and work cannot be shifted into place after firm contact is made. For large areas, use dowels to prevent surface contact while positioning surfaces. Place dowels every 6 to 12 inches. Remove dowels as surfaces are pressed together.
4. Once surfaces are joined, 25 lbs. per square inch of pressure should be evenly applied to surface starting in center and working out to edges. This is equivalent to 75 lbs. of pressure being applied to a 3-inch "J" roller. Apply as much pressure as possible, being careful not to crush the core materials. Insufficient pressure may allow blisters or bubbles to form later. This can be readily achieved if bonded surface is on a solid waist-high workbench.
5. No clamping required. Contact Cement bonds permanently when sufficient pressure is applied and reaches maximum holding strength in 7 days.
6. Trimming or finishing operations may be performed immediately after bonding. Allow at least 72 hours of curing before exposing bonded assemblies to direct sunlight or temperatures over 150 °F (66°C).

## NOTE:

This contact cement should not be used for structural applications, or for bonding copper, copper alloys or polystyrene foams. For other foams, a test application is recommended. The solvents in this cement may stain or damage painted surfaces, vinyls and some plastics. Test a small area first before actual use. Not recommended for heavy gauge metal.

## TYPICAL PHYSICAL & CHEMICAL PROPERTIES

Adhesive Base:	Synthetic rubbers & resins
Volatile:	Toluene, Petroleum Spirits, Methyl Ethyl Ketone
Flash Point:	21°F Minimum, Seta-Close Cup
Solids:	20% by Weight
Weight/Gallon:	7.4lbs/gal
Color:	Tan
Consistency:	Pourable Liquid
Application Temperature:	65°F to 110°F
Service Temperature Range:	-40°F to 180°F (-40°C to 82°C)
Bond Strength:	Excellent
Open Time:	Up to 2 Hours
Coverage:	Approximately 216 sq. ft/gallon
Shelf Life:	12 months
Odor:	Solvent
Freeze-Thaw Stability:	Does not freeze (may thicken with cold temperatures, allow to warm to room temperature and agitate container prior to use)
VOC, less water and exempt solvents:	702.8 g/l (62.9%)



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## CLEAN UP & STORAGE

Clean excess wet adhesive from surfaces and tools with mineral spirits. Dried adhesive must be cut or scraped away. Clean hands with warm water and soap. DO NOT use solvents to remove product from skin. Store container in cool, dry place away from extreme heat or cold.

## SAFETY

See product label or Safety Data Sheet (SDS) for health and safety information. You can request an SDS sheet by calling 888-DAP-TIPS or by visiting our website at [dap.com](http://dap.com).

## WARRANTY

LIMITED WARRANTY: If product fails when used as directed within one year of purchase, DAP will provide replacement product or refund sales price: call 888-DAP-TIPS with your sales receipt and product container available, to arrange for warranty fulfillment. DAP is not liable for incidental or consequential damages.

## COMPANY IDENTIFICATION

**Manufacturer:** DAP Products Inc., 2400 Boston Street, Baltimore, Maryland 21224

**Usage Information:** Call **888-DAP-TIPS** or visit [dap.com](http://dap.com) & click on "Ask the Expert"

**Order Information:** 800-327-3339 or [orders@dap.com](mailto:orders@dap.com)

**Fax Number:** 410-558-1068

**Also, visit the DAP website at [dap.com](http://dap.com)**