

# PATTEX

## Contact

## Liquid

**Technical Datasheet**

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### CHARACTERISTICS

- High initial and final strength
- High heat resistant
- Resistant to ageing

### DIRECTIONS FOR USE

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

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

Before joining the parts, allow solvents to evaporate. Evaporation time at normal room temperature (18 to 25°C) is approx. 10-15 minutes.

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<sup>2</sup> = 5 kp/cm<sup>2</sup> 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.

**Storage :**

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

Cold or frozen adhesive (under + 5°C) will become fully usable again if slowly acclimatised up to working temperature (approx. +20°C). 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.

**PRODUCT SAFETY**

Please see the related Product Safety Datasheet

**TECHNICAL DATA**

Composition:	Polychloropren
Density:	0.89 g/cm <sup>2</sup>
Temperature-resistance:	- 40 ° C up to 110°C
Application temperature:	Pattex Contact Liquid should preferably be used at room temperature of +18 to +25°C..
Shelf Life	24 months at cool places temperatures
Consumption:	250-350 g/m <sup>2</sup> for two-sided application of adhesive
Final strength (DIN EN 205):	Depending on surface and pressing, after 3 days.
Evaporation:	10-15 Minutes at room temperature

**IMPORTANT REMARKS**

**Cleaning tools :**

Clean tools immediately after use with thinner or washing benzene.



**Quality for Professionals**

