



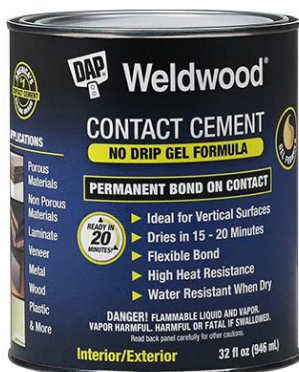
# TECHNICAL DATA SHEET

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

## DAP® WELDWOOD® Gel Formula Contact Cement

### PRODUCT DESCRIPTION

**DAP WELDWOOD Gel Formula Contact Cement** is a polychloroprene-based contact adhesive that forms a permanent bond 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, high-strength bond when parts are assembled and pressure is applied.



PACKAGING	COLOR	UPC
Pint	Tan	7079825310
Quart	Tan	7079825312
Gallon	Tan	7079825316

### KEY FEATURES & BENEFITS

- **No drip, no mess**
- **Easy to spread**
- **High strength, permanent bond**

### PERFORMANCE CHARACTERISTICS

- DAP WELDWOOD Gel Formula Contact Cement spreads on easily and requires only one coat on most porous and non-porous surfaces.
- Dries in 15-20 minutes and offers a long open time of up to 1-1/2 to 2 hours.
- When pressed together, surfaces bond instantly on contact with high green strength, allowing immediate use of the assembly.
- Cured bond resists the effects of heat and water.
- Interior/exterior use.



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## SUGGESTED USES

Ideal for bonding:

- Decorative laminates
- Veneers
- Paper
- Cork
- Cloth, Leather
- Backed vinyl to itself or bonded to particle board
- Particle board
- Medium density fiber board
- Drywall
- Plywood
- Wood
- Glass or fiberglass

## APPLICATION

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

The surfaces to be bonded must be clean, dry and free of all foreign material. Previously applied finishes should be removed and the parts must be pre-fitted before any adhesive is applied. The temperature of the adhesive, the surfaces being bonded, and the working area should be at or above 65°F.

### **Preparation:**

- Stir contact cement thoroughly with a standard paint paddle or stirring stick. Prefit all parts before applying cement. Surfaces to be bonded must be clean, dry and free of foreign materials. Roughen non-porous materials. The temperature of the air, surfaces and adhesive should be above 65°F for a minimum of 24 hours before application and 72 hours after application.

### **Application:**

- Using a paint brush, short nap roller, or finishing trowel, apply one uniform coat of cement to each surface to be bonded, working cement in one direction only.
- Let coated surfaces dry for 15-20 minutes. Dry time may vary with temperature, humidity and thickness of coat applied. Properly coated surfaces feel tacky and appear glossy when dry. Test for dryness by pressing kraft paper against adhesive surface. When dry, adhesive should bond slightly to, but not transfer to, the kraft paper. Recoat any dull spots after first coat is dry. Two coats may be required on rough or porous or absorbent surfaces.

### **Assembly:**

- Surfaces may be assembled up to 2 hours after cement is applied. If the cement is allowed to dry more than 2 hours, reactivate it by applying another coat of Contact Cement and allow to dry as previously instructed.
- Align surfaces into exact position and press together, moving from one end to the other or from the center to the edges to avoid bubbles. Cement permanently bonds on contact so surfaces cannot be shifted once joined. 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.
- Apply firm pressure (a minimum of 25lbs per square inch) to the entire area using a J-Roller (not over 3 inches wide). Insufficient pressure may allow blisters or bubbles to form later. Work from the center to the edges to avoid bubbles. Apply extra pressure to edges.



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- Trimming or finishing operations can be performed immediately after bonding. Let adhesive assemblies cure for at least 72 hours before exposure to direct sunlight or temperatures over 150°F.

## NOTE:

- This contact cement should not be used for structural applications, or for bonding copper, copper alloys, metal alloys, or polystyrene foams. Not recommended for heavy gauge metal. 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.
- Gel Original Contact Cement has a flat finish when dry.

## TYPICAL PHYSICAL & CHEMICAL PROPERTIES

Adhesive Base:	Synthetic rubbers & resins
Volatile:	Toluene, Petroleum Spirits, Methyl Ethyl Ketone
Flash Point:	>21°F Minimum
Solids:	21% by Weight
Weight/Gallon:	7.3lbs/gal
Color:	Tan
Consistency:	Gel
Odor:	Solvent
VOC, less water and exempt solvents:	700 g/L
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 230 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:	705.5 g/l (80.4%)



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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)**