



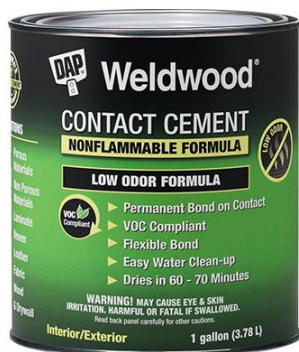
TECHNICAL DATA SHEET

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

DAP® WELDWOOD® Nonflammable Contact Cement

PRODUCT DESCRIPTION

DAP WELDWOOD Nonflammable Contact Cement is a high-solids polychloroprene-based, waterborne contact adhesive that specifically meets the stringent requirements of the professional user. This versatile product offers 60-70-minute dry time and 2.5 to 3-hour assembly/working time. The additional bonding time allows extra time between adhesive application and actual surface bonding. Dry time and open time dependent on temperature and humidity.



PACKAGING	COLOR	UPC
Pint	Natural	7079825330
Quart	Natural	7079825332
Gallon	Natural	7079825336

KEY FEATURES & BENEFITS

- **Complies with all current VOC requirements**
- **Non-Flammable formula**
- **Low odor, easy water clean-up**

PERFORMANCE CHARACTERISTICS

- Spreads on easily and requires only one coat on most porous and non-porous surfaces.
- Dries tack free and offers a long open time of up to 3 hours.
- Water Resistant.
- Cured bond resists the effects of heat (up to 180°F), 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. This is a waterborne adhesive with a longer open time that can vary depending on temperature and humidity. **NOTE:** 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 material. Painted or non-porous surfaces must be roughened before adhesive is applied. At least one surface to be bonded must 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.



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2. Allow both surfaces to dry 60-70 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 Nonflammable Contact Cement can reactivate adhesive.
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. 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.

TYPICAL PHYSICAL & CHEMICAL PROPERTIES

Adhesive Base:	Synthetic rubbers & resins
Volatile:	Water, Toluene
Flash Point:	> 200°F
Solids:	53-55% by Weight
Weight/Gallon:	9.3lbs/gal
Color:	Natural
Consistency:	Pourable Liquid
Application Temperature:	65°F to 120°F
Service Temperature Range:	-40°F to 180°F (-40°C to 82°C)
Bond Strength:	Excellent
Open Time:	2.5 to 3.0 Hours
Coverage:	Approximately 760 square feet per gallon
Shelf Life:	1 Year, minimum
Odor:	Slightly Solvent
Freeze-Thaw Stability:	5 cycles @ 0°F



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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.

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 & click on "Ask the Expert"

Order Information: 800-327-3339 or orders@dap.com

Fax Number: 410-558-1068

Also, visit the DAP website at dap.com