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TECHNICAL DATA SHEET

PRES-TITE® BLUE CONTACT CEMENT
Premium Quality

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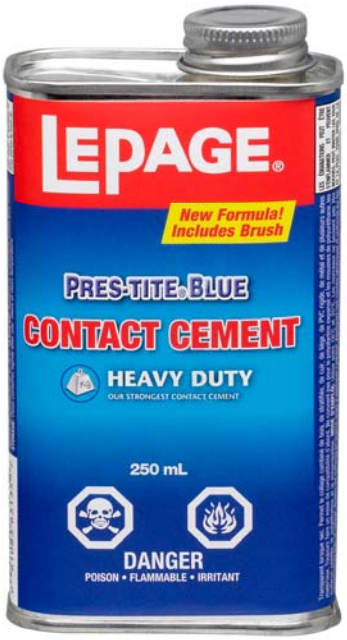

Item #	Package	Size
1504637	Carded Tube	30 mL
1504724	Metal Tin with Brush	250 mL

DESCRIPTION

LePage® Pres-Tite® Blue Contact Cement is a premium grade solvent-based adhesive that offers a high strength bond resistant to heat, creep, water and oil. It dries quickly and bonds on contact thus eliminating clamping. Pres-Tite® Blue Contact Cement has 1.5 times better coverage and strength than multi-purpose contact cements.

RECOMMENDED FOR:

Laminating flat and close mating surfaces. Bonds plastic laminates, veneers, plywood, particleboard, wallboard, metals (ferrous and non ferrous), cork, fabric and rubber. Ideal for bonding decorative laminates or wood veneer to cabinets, counter or desk tops and other large flat surfaces where clamping is not possible. Use for jobs around the home such as repairing fabric seat covers, shoes, weather stripping and replacing loose flooring.

NOT RECOMMENDED FOR:

- Polystyrene and polyurethane foam
- May damage some hard plastics and painted surfaces. Test small area before using. During drying solvents may affect adjacent plastic surfaces.
- Bonding materials that will be exposed to continual heavy loads

FEATURES & BENEFITS:

Feature	Benefits
Bonds on contact	Eliminates clamping
Increased coverage and strength	Reduces amount of adhesive required to complete project
Dries quickly	Quick completion of project
Dries clear	Ideal for visible joints and for bonding transparent materials
Heat Resistance	Withstands temperatures of up to 70°C (158°F)

COVERAGE

- A 30 mL tube will cover approximately 0.2 m^2 of surface (one coat and one side only)
- A 250 mL can will cover approximately 1.2 to 1.8 m^2 of surface (one coat and one side only)

DIRECTIONS

Tools Typically Required:
Stir stick, brush or short nap roller, J-roller or 3-inch wide rubber roller.

Safety Precautions:
Well-ventilated area, gloves. Read label warnings and precautions below.

Preparation:

The temperature of the adhesive, the surfaces being bonded and the working area should be between 18°C (64°F) and 25°C (77°F). Surfaces must be clean, dry, free of paint or other coatings, grease, dust and other contaminants and irregularities. Pre-fit all materials, as bonding will be immediate upon contact. To improve adhesion to very smooth or glossy surfaces, roughen by sanding lightly.

Application:

Apply an even, generous coat to both surfaces using a spatula or short-bristle brush. Coverage will vary with porosity, roughness of the surface and thickness of application. Very porous surfaces, such as particleboard, require two coats. Between coats and before joining the substrates, allow 10 to 15 minutes drying time. Heavy adhesive application, high humidity or low temperatures will lengthen the time for adequate drying. Typically the adhesive will dry in 10-15 minutes at 23°C and 50% relative humidity. Test for dryness by pressing a small piece of clean Kraft paper on the adhesive. If no adhesive transfers to the paper then the adhesive is dry enough to bond. If the surfaces are left to dry beyond one hour, applying another thin coat will reactivate the adhesive. Again the adhesive must be allowed to dry before bonding. When adequately coated, dry contact cement should have a uniform, glossy appearance. Any dull spots indicate a second coat of adhesive is required. Dull spots occur because either too little adhesive was applied or because of excessive absorption into the surfaces.

Carefully position materials since bonding is immediate and parts cannot be repositioned once contact has been made. Dowels or clean rods placed between the substrates can be used to aid in positioning when bonding large surfaces. These are then removed before making contact. Apply pressure, working the entire area from the centre to the edges using a J-roller or 3-inch wide rubber hand roller. Roll in two directions at 90° to each other paying special attention to the edges. Apply as much pressure as possible without damaging the materials. A pinch roller or rotary press may also be used. Bonded assemblies may be trimmed, cut or machined immediately after bonding.

If bonding polystyrene or polyurethane foam to metal, apply Pres-Tite® Blue Contact Cement to the metal surface and Pres-Tite® Green Contact Cement to the polystyrene or polyurethane foam. Observe the recommended drying times for each adhesive, join and press together.

Bonding failures:

Delamination and bubbling can be a result of the following:

1) Insufficient adhesive,
2) Insufficient or excessive drying time before bonding. If insufficient drying time is allowed, solvents become trapped and will lead to bubbling.
3) Inadequate pressure applied when bonding,
4) Inadequate contact because of irregularities in the surfaces being bonded which prevent the adhesive layers contacting each other when applying pressure,
5) Excessive humidity, which can result in moisture formation at the glue line as solvent evaporates.
6) Cold temperatures during application, which reduces the contactability of the adhesive.

In some cases delamination or bubbling of the laminate can be corrected by reactivating the adhesive using a hot iron over a towel to protect the surfaces and then immediately reapplying pressure. It may be necessary to pierce the bubble with a very fine hole or knife cut to allow any vapours to escape.

Clean-up

Clean tools and adhesive residue immediately with Acetone or a d-limonene based adhesive remover. Cured contact cement may be carefully cut away with a sharp-edged tool.

STORAGE AND DISPOSAL

Store adhesive between 5°C (41°F) and 40°C (104°F). Adhesive may gel if frozen but will return to normal viscosity at 21 to 25°C if stirred vigorously. If stored above this temperature, the product maybe irreversibly damaged. Close lid tightly to prevent drying and contamination. Do not dispose of down drains. Store away from heat, flame and spark in a cool, well-ventilated area. Use an approved hazardous waste facility for disposal.

LABEL PRECAUTIONS

FUMES MAY CATCH FIRE AND MAY BE HARMFUL. MAY IRRITATE EYES AND SKIN. Do not smoke. Use only in a well ventilated area. Keep away from flames, such as a pilot light, and any object that sparks, such as an electric motor. Avoid breathing vapours and contact with eyes and skin. KEEP OUT OF REACH OF CHILDREN. FIRST AID TREATMENT: Contains acetone and butyl acetate. If swallowed, call Poison Control Centre or doctor immediately. If in eyes or on skin, rinse well with water. If breathed in, move person to fresh air.

Refer to the Material Safety Data Sheet (MSDS) for further information

DISCLAIMER

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Purchasers should test the products to determine acceptable quality and suitability for their own intended use. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

TECHNICAL DATA

Typical Uncured Physical Properties

Colour:	Clear and colourless
Appearance:	Thick liquid
Solvent:	Acetone
Viscosity:	3,000 to 3,500 cps
% Solids:	16 – 18% by weight
Flashpoint:	-9°C (15.8°F)
VOC Content:	< 15 % by weight (or 111.2 g/L)
Shelf Life:	24 months from date of manufacture (Unopened)
Lot Code Explanation: (Lot code stamped on lid of can or on crimped end of squeeze tube)	YYDDD YY = Last two digits of year of manufacture DDD = Day of manufacture based on 365 days in a year For example: 09061 = 61st day of 2009 = March 2, 2009

Typical Application Properties

Application Temperature:	Apply between 18°C (64°F) and 25°C (77°F)
Open time:	10 to 60 minutes @ 25°C (78°F)
Full Bond Strength:	72 hours
Odour:	Solvent (use in a well-ventilated area)

Typical Cured Performance Properties

Colour:	Clear
Water Resistance:	Yes
Service Temperature:	-40°C (-40°F) to 70°C (158°F)
Peel Results (Cold Rolled Steel):	
15 min Open Time; Tested @ 24 hours:	27 ± 7 lb / in
15 min Open Time; 7 day Cure + 28 days @ 50°C:	62 ± 4 lb / in
60 min Open Time; Tested @ 24 hours:	29 ± 11 lb / in
60 min Open Time; 7 day Cure + 28 days at 50°C:	56 ± 12 lb / in

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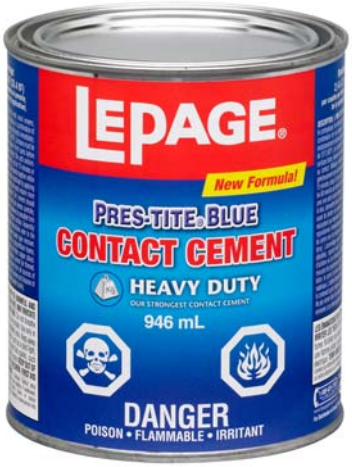

Item #	Package	Size
1504725	Metal Tin	500 mL
1504619	Metal Tin	946 mL
1504629	Metal Pail	3.8 L

DESCRIPTION

LePage® Pres-Tite® Blue Contact Cement is a premium grade solvent-based adhesive that offers a high strength bond resistant to heat, creep, water and oil. It dries quickly and bonds on contact thus eliminating clamping. Pres-Tite® Blue Contact Cement has 1.5 times better coverage and strength than multi-purpose contact cements.

RECOMMENDED FOR:

Laminating flat and close mating surfaces. Bonds plastic laminates, veneers, plywood, particleboard, wallboard, metals (ferrous and non ferrous), cork, fabric and rubber. Ideal for bonding decorative laminates or wood veneer to cabinets, counter or desk tops and other large flat surfaces where clamping is not possible. Use for jobs around the home such as repairing fabric seat covers, shoes, weather stripping and replacing loose flooring.

LIMITATIONS

- Not compatible with polystyrene and polyurethane foam
- May damage some hard plastics and painted surfaces. Test small area before using. During drying solvents may affect adjacent plastic surfaces.
- Do not use for bonding brass, copper and other copper alloys or allow contact with these materials during storage.
- Not to be used for bonding materials that will be exposed to continual heavy loads
- Thickened product cannot be thinned

FEATURES & BENEFITS

Feature	Benefits
Bonds on contact……	Eliminates clamping
Increased coverage and strength…….……	Reduces amount of adhesive required to complete project
Dries quickly……	Quick completion of project

COVERAGE

- 500 mL can: Approximately 1.3 m^2 (14 ft^2) to 1.7 m^2 (18.3 ft^2)per surface per coat per can
- 946 mL can: Approximately 2.4 m^2 (25.8 ft^2) to 3.1 m^2 (33.4 ft^2)per surface per coat per can
- 3.8 L pail: Approximately 9.5 m^2 (102.3 ft^2) to 12.5 m^2 (134.5 ft^2)per surface per coat per can

*Note: Coverage values are dependent on porosity and roughness of surface and thickness of adhesive application

DIRECTIONS

Tools Typically Required:
Stir stick, brush or short nap roller, J-roller or 3-inch wide rubber roller.

Safety Precautions:
Apply and cure in a well-ventilated area. Wear gloves and wash hands after use. Read all label warnings and precautions below.

Preparation:
The temperature of the adhesive, the surfaces being bonded and the working area should be at or above 15°C (60°F). Surfaces must be clean, dry, free of paint or other coatings, grease, dust and other contaminants and irregularities. Pre-fit all materials, as bonding will be immediate upon contact. To improve adhesion to very smooth or glossy surfaces, roughen by sanding lightly. Stir adhesive until uniform. If the contact cement appears too thick due to solvent evaporation, use LePage Contact Cement Thinner to restore original consistency. Do not use thinner for thinning the contact cement to obtain better coverage, as this will alter the adhesive and may lead to bonding failure.

Application:

Apply an even, generous coat to both surfaces using a brush or short nap roller. Coverage will vary with porosity, roughness of the surface and thickness of application. Very porous surfaces, such as particleboard, require two coats. Between coats and before joining the substrates, allow 10 to 60 minutes drying. Heavy adhesive application, high humidity or low temperatures will lengthen the time for adequate drying. Typically the adhesive will dry in 10-15 minutes at 23°C and 50% relative humidity. Test for dryness by pressing a small piece of clean Kraft paper on the adhesive. If no adhesive transfers to the paper then the adhesive is dry enough to bond. If the surfaces are left to dry beyond one hour, applying another thin coat will reactivate the adhesive. Again the adhesive must be allowed to dry before bonding. When adequately coated, dry contact cement should have a uniform, glossy appearance. Any dull spots indicate a second coat of adhesive is required. Dull spots occur because either too little adhesive was applied or because of excessive absorption into the surfaces.

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Bonding failures:
Delamination and bubbling can be a result of the following:

7) Insufficient adhesive,
8) Insufficient or excessive drying time before bonding. If insufficient drying time is allowed, solvents become trapped and will lead to bubbling.
9) Inadequate pressure applied when bonding,
10) Inadequate contact because of irregularities in the surfaces being bonded which prevent the adhesive layers contacting each other when applying pressure,
11) Excessive humidity, which can result in moisture formation at the glue line as solvent evaporates.
12) Cold temperatures during application reduces the contactability of the adhesive.

In some cases delamination or bubbling of the laminate can be corrected by reactivating the adhesive using a hot iron over a towel to protect the surfaces and then immediately reapplying pressure. It may be necessary to pierce the bubble with a very fine hole or knife cut to allow any vapours to escape.

Clean-up
Clean tools and adhesive residue immediately with Acetone or d-limonene based glue remover. Cured contact cement may be carefully cut away with a sharp-edged tool.

STORAGE AND DISPOSAL

Not damaged by freezing. Adhesive may gel if frozen but will return to normal viscosity at 21 to 25°C. Close lid tightly to prevent drying and contamination. Do not dispose of down drains. Store away from heat, flame and spark in a cool, well-ventilated area. Use an approved hazardous waste facility for disposal.

LABEL PRECAUTIONS

FUMES MAY BE HARMFUL AND MAY CATCH FIRE. MAY IRRITATE EYES AND SKIN. Do not breathe fumes. Do not smoke. Use only in a well ventilated area. Keep away from flames, such as a pilot light, and any object that sparks, such as an electric motor. **KEEP OUT OF REACH OF CHILDREN. FIRST AID TREATMENT:** Contains Methyl Ethyl Ketone (MEK), Heptane, and Naphtha. If swallowed, call Poison Control Centre or doctor immediately. If breathed in, move person into fresh air.

Refer to the Material Safety Data Sheet (MSDS) for further information

DISCLAIMER

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Purchasers should test the products to determine acceptable quality and suitability for their own intended use. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

TECHNICAL DATA

Typical Uncured Physical Properties

Colour:	Yellow-tan
Appearance:	Thick liquid
Base:	Polychloroprene synthetic rubber
Solvent:	MEK, Heptane and Naphtha
Flashpoint:	-9°C (15.8°F)
VOC Content:	644.8 g/L
Shelf Life:	24 months from date of manufacture (Unopened)
Lot Code Explanation: (Lot code stamped on lid of can)	YYDDD YY = Last two digits of year of manufacture DDD = Day of manufacture based on 365 days in a year For example: 09061 = 61st day of 2009 = March 2, 2009

Typical Application Properties

Application Temperature:	Apply above 15°C (60°F)
Open time:	10 to 60 minutes @ 25°C (78°F)
Odour:	Solvent (use in a well-ventilated area)

Typical Cured Performance Properties

Colour:	Yellow-tan
Water Resistance:	Yes
Peel Strength (Cold Rolled Steel) (Open Time (min) T Cure Time):	
15T0:	21 ± 1 lb / in
15T24h:	33 ± 7 lb / in
60T24h:	65 ± 9 lb / in
15T7d:	26 ± 9 lb / in
60T7d:	39 ± 9 lb / in

Service Temperature:	Up to 60°C (140°F)