



TECHNICAL DATA SHEET

LEPAGE® PRES-TITE® GREEN CONTACT CEMENT

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DESCRIPTION

LePage® Pres-tite® Green Contact Cement is a water-based contact adhesive that provides strong, tough bonds with excellent hot-creep resistance. It applies smoothly without stringing and evenly by brush, roller or spraying. The high solids content gives coverage three times greater than solvent-based contact cements. Safe to use and cleans up easily with soap and water.

RECOMMENDED FOR:

Laminating flat and close mating surfaces. Bonds plastic laminates, particleboard, plywood, wallboard, veneers, cork, fabric and polystyrene and polyurethane foam. Ideal for bonding decorative laminates and veneers 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, loose laminate banding and replacing loose flooring.

NOT RECOMMENDED FOR:

- Metal bonding
- Very thin wood veneers. Excessive dimensional change may occur which may lead to cracking when drying
- Bonding materials that will be exposed to continual heavy loads (structural applications)

FEATURES & BENEFITS:

Feature	Benefits
Water based contact cement.....	Low VOC content, low odour, solvent free and non-toxic
Bonds on contact.....	Eliminates clamping
High solids content.....	Three times greater coverage than solvent-based contact cements

COVERAGE

Approximately 7.8 to 9.3 m²/L (317 to 378 ft²/gallon) per coat per surface depending on porosity and roughness of the surface.

DIRECTIONS

Tools Typically Required:

Stir stick, brush, short nap roller or stainless steel spray, J-roller or 3-inch wide rubber roller.

Safety Precautions:

Wear gloves.

Preparation:

The temperature of the adhesive, the surfaces being bonded and the working area should be at or above 18°C (65°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 surfaces, roughen by sanding. After sanding, remove all dust and particles from surface. Stir contact cement until uniform. Do not mix with other adhesives or dilute with water.



Item #	Package	Size
1505670	Plastic Bottle with Brush	237 mL
1536624	Plastic Bottle	1.5 L

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 30 to 40 minutes drying time or until the adhesive turns from a milky white to a transparent gloss. Heavy adhesive application, high humidity or low temperatures will lengthen the time for adequate drying. Typically the adhesive will dry in 30 to 40 minutes at 23°C and 50% relative humidity. Drying time can be accelerated by the use of hot air ovens, fans or heat (IR) lamps. Join surfaces within one hour after last coat of adhesive has been applied. 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. Dry contact cement should have a uniform glossy appearance when adequately coated. Any dull spots indicate a second coat of adhesive is necessary. Dull spots occur because too little adhesive was applied or because of excessive absorption into the surfaces.

Position materials carefully 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 to 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.

It is possible to bond polystyrene and polyurethane foam to metal by applying solvent-based 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 result because of:

- 1) Insufficient adhesive,
- 2) Insufficient or excessive drying time before bonding.
- 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) Application or bonding below the recommended minimum temperature.

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 warm, soapy water. Cured contact cement may be carefully cut away with a sharp-edged tool.

STORAGE AND DISPOSAL

DAMAGED BY FREEZING. Store at room temperature between 16°C (60°F) and 27°C (80°F) for optimal shelf life. Close lid tightly to prevent drying and contamination. Do not transfer to other metal containers or leave objects that may rust (e.g. brushes) sitting in the adhesive. Do not pour down drains. Allow product to harden and dispose with trash or use an approved household hazardous waste facility.

LABEL PRECAUTIONS

KEEP OUT OF REACH OF CHILDREN.

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		Typical Application Properties	
<u>Colour:</u>	White	<u>Application Temperature:</u>	Apply above 18°C (65°F)
<u>Appearance:</u>	Liquid	<u>Odour:</u>	Minimal
<u>Base:</u>	Polychloroprene Synthetic Rubber	<u>Dry Time:</u>	30 to 40 minutes
<u>% Solids:</u>	51.5 – 55%		
<u>Viscosity</u> (at 20 RPM and 25°C):	600 to 1500 cps		
<u>Specific Gravity:</u>	1.1		
<u>pH:</u>	9.0 to 9.4		
<u>VOC Content:</u>	< 10 g/L (0.92% by weight)		
<u>Shelf Life:</u>	18 months from date of manufacture (Unopened)		
<u>Lot Code Explanation:</u>	For example: AE025- 11179 -06549		
(Lot code stamped on bottom of bottle)	11179 = YYDDD YY = Last two digits of year of manufacture DDD = Day of manufacture based on 365 days in a year For example: 11179 = 179 th day of 2011 = June 28 th , 2011		

Typical Cured Performance Properties			
<u>Colour:</u>	Transparent, glossy	<u>Service Temperature:</u>	Up to 70°C (158°F)
<u>Shear Strength (ASTM D 1995, Maple):</u>			
30 minutes open time, after 7 days	466 psi		
60 minutes open time, after 7 days	451 psi		