



Technical Bulletin

2400 Boston Street, Suite 200, Baltimore, Maryland 21224
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DAP® WELDWOOD® Original Contact Cement

- Premium Quality
- Requires only one coat on most surfaces
- Meets all CPSC requirements

Company Identification:

Manufacturer: DAP Inc., 2400 Boston St., Baltimore, Maryland 21224
Usage Information: DAP HELPLINE: 888-DAP-TIPS, 9:00 am to 7:00 pm EST.
Order Information: 800-327-3339
Fax Number: 410-534-2650
Also, visit the DAP website at www.dap.com.

Product Description:

DAP® WELDWOOD® Original Contact Cement is a neoprene rubber adhesive that forms permanent bonds 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, super-strong bond when parts are assembled and momentary pressure is applied. Meets performance requirements of Federal Specification MMM-A-130B. Meets all CPSC requirements.

Suggested Uses:

Ideal for bonding:

- High Pressure Laminates
- Wood and Plastic Veneers
- Paneling
- Leather
- Fabrics
- Rubber
- Paper
- Cardboard
- Other materials to wood, particle board, plywood, metal, concrete and similar surfaces

Performance Characteristics:

- Spreads on easily and requires only one coat on most porous and non-porous surfaces.
- Dries tack free quickly and offers a long open time of up to 2 hours.
- When pressed together, surfaces bond instantly on contact with high green strength, allowing immediate use of assembly.
- Cured bond resists the effects of heat (up to 180°F), water, weather, grease, oil and household chemicals. Interior/exterior use.

Surface Preparation & Application:

- PREPARATION: Prefit all parts before applying cement. Surfaces to be bonded must be clean, dry and free of irregularities. Remove all paint, varnish, grease, oil, dust, sawdust and other foreign materials. Roughen non-porous materials. Air and substrate temperatures should be above 65°F.

- **APPLICATION:** Stir cement thoroughly. Using a brush, short nap roller or notched spreader, apply one uniform coat of cement to each surface to be bonded, working cement in one direction only.
- Let coated surfaces dry for 15 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 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 cement and drying normally.
- Align surfaces into exact position and press together, moving from one end to the other to avoid bubbles. Cement joins on contact, surfaces cannot be shifted. 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 to the entire area using a J-Roller (not over 3 inches wide) or a wood block and hammer. 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.
- 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.
- Should not be used for structural applications, or for bonding copper, copper alloys or Styrofoam. The solvents in this cement may stain or damage painted surfaces, vinyls and some plastics. Test a small area first before actual use. Not recommended for heavy gauge metal.

Physical & Chemical Characteristics:

Volatile: Toluene, Petroleum Spirits, Methyl Ethyl Ketone
 Flash Point: 21°F Minimum, Seta-Closed Cup
 Solids: 18-20% by Weight
 Weight/Gallon: 7.4 lbs.
 Color: Tan
 Consistency: Pourable Liquid
 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: 2 Hours
 Coverage: 216 sq. ft./gallon (one side application @ 3 dry grams per sq ft).
 This is equivalent to 108 sq ft of bonded material.
 Shelf Life: 1 Year, Minimum
 Packaging:

<i>UPC</i>	<i>SIZE</i>
00271	Pint
00272	Quart
00273	Gallon
00274	5 Gallon

MSDS No. 30503

Clean Up:

Tools and other equipment may be cleaned with DAP®WELDWOOD® Contact Cement Cleaner and Thinner.

Safety:

See product label or Material Safety Data Sheet for safety information. You can request an MSDS sheet by calling 888-DAP-TIPS or by visiting our website at www.dap.com.

Limited Warranty:

DAP Inc. warrants that this product, when applied in accordance with our label, technical bulletins and applicable industry standards, will be free from defects in materials and workmanship for 12 months from the date of purchase. If a product defect is encountered, return used container and sales receipt to DAP Inc., Technical Service, 2400 Boston St. Baltimore, MD 21224. DAP's **sole liability** is either to supply new product or refund the purchase price. This limited warranty excludes all other express or implied warranties, including the warranties of **Merchantability or Fitness for a Particular Use or Purpose**. DAP will in no event be liable for any **Incidental or Consequential Damages**. Some states do not allow limitations on how long implied warranties last nor exclusions or limitations of incidental or consequential damages so the above limitations or exclusions may not apply to you. This warranty give you specific legal rights, and you may also have other rights which vary from State to State.