



Technical Bulletin

2400 Boston Street, Suite 200, Baltimore, Maryland 21224
Phone: 410-675-2100 or 800-543-3840

Revised: 7/7/2005

DAP® WELDWOOD® Gel Formula Contact Cement

- No drip, no mess
- Easy to spread
- Strong adhesion

Packaging: Pint, Quart, Gallon
Colors: Tan
UPC Numbers: 25310, 25312, 25316

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® Gel Formula Contact Cement is a polychloroprene-based 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 momentary pressure is applied.

Suggested Uses:

Ideal for bonding:

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

Performance Characteristics:

- DAP® WELDWOOD® Gel Formula Contact Cement spreads on easily and requires only one coat on most porous and non-porous surfaces.
- Exceeds industry performance requirements.
- 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, water, weather, grease, oil and most household cleaning chemicals.
- Interior/exterior use.

Surface Preparation & Application:

READ AND UNDERSTAND ALL HEALTH AND SAFETY INFORMATION ON CONTAINER BEFORE OPENING AND USING THIS PRODUCT. DO NOT USE PRODUCT IF FIRE PRECAUTIONS CANNOT BE MET.

- Prefit all parts before applying the contact cement. Surfaces to be bonded must be clean, dry and free of irregularities. Remove all paint, varnish, grease, oil, wax, dust, sawdust and other release agents foreign to the surface itself. Roughen non-porous materials.
- The temperature of surfaces and contact cement should be above 65°F for a minimum of 24 hours before and 72 hours after application to ensure proper drying bond strength.
- Stir contact cement thoroughly with a standard paint paddle or stirring stick.
- Using a paint brush, short nap roller or notched spreader, apply one even coat of contact cement to each surface to be bonded, working cement in one direction only. Multiple coats may be required on porous substrates. Allow the first coat to dry before applying next coat.
- Allow both coated surfaces to dry for 15-20 minutes (dependent on temperature, humidity and thickness of coat applied). Properly coated surfaces feel slightly tacky when dry. Test for dryness by pressing Kraft paper against adhesive surface. When dry, adhesive should bond slightly, but not transfer to the Kraft paper.
- Surfaces may be assembled up to 2 hours after cement is applied. If the surfaces are not assembled within 2 hours, the adhesive can be reactivated by applying an additional coat of contact cement.
- The contact cement bonds instantly on contact. Carefully align surfaces into the exact position and press together, moving from one end to the other to avoid bubbles. For large areas, use dowels to prevent surface contact while positioning surfaces. Place dowels every 6-12 inches. Remove dowels as surfaces are pressed together.
- Once the surfaces are joined, apply 25 lbs. per square inch of pressure to the entire area using a J-Roller (not over three inches wide) or wood block and hammer. Insufficient pressure may allow blisters or bubbles to form later. Apply pressure to the surface by starting from the center and working out to the edges. Apply extra pressure to the edges. No clamping required. Contact cement bonds instantly upon contact and reaches maximum holding strength in 7 days.
- 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 above 150°F

NOTE:

- This contact cement should not be used for structural applications, or bonding copper, copper alloys or polystyrene foam. The solvents in this cement may stain or damage painted surfaces, vinyls and some plastics. Test a small area prior to actual use. Not recommended for heavy gauge metal
- Gel Original Contact Cement has a flat finish when dry.

Physical & Chemical Characteristics:

Flash Point:	>21°F
Solids weight %:	21
Density:	7.4 lbs/gallon
VOC, less water and exempt solvents:	700 g/L
Odor:	Solvent
Color:	Tan
Consistency:	Gel
Application Temperature Range:	65°F to 110° F (18°C to 43°C)
Service Temperature Range:	-40°F to 180°F (-40°C to 82°C)
Bond Strength:	Excellent
Open Time:	2 hours or less (dependent on temperature, humidity and thickness of coat)
Coverage @ 3 dry grams per square foot: 115 sq ft of bonded material.	Approximately 230 square feet per gallon. This is equivalent to
Shelf Life:	12-18 months

Clean Up:

Clean tools and work area with DAP WELDWOOD® Contact Cement Cleaner and Thinner or Xylene.

Safety:

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

Warranty Information:

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 material 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 Services, 2400 Boston Street, 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 of 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 gives you specific legal rights, and you may also have other rights, which vary from State to State.