



# Technical Bulletin

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

Revised: 7/7/2005

## 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](http://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 joints 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>
<b>00271</b>	Pint
<b>00272</b>	Quart
<b>00273</b>	Gallon
<b>00274</b>	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](http://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.

An **RPM** Company



# Technical Bulletin

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Revised: 07/7/2005

## DAP® WELDWOOD® Nonflammable Contact Cement

- Complies with all current VOC requirements
- Environmentally friendly
- Exceeds industry performance requirements
- Low odor, easy water clean-up
- Dries in 30-40 minutes

**Packaging:** Pint, Quart, Gallon  
**Color:** Natural  
**UPC Number:** 25330, 25332, 25336

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Order Information: 800-327-3339  
Fax Number: 410-534-2650  
Also, visit the DAP website at [www.dap.com](http://www.dap.com).

### 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 30-40 minute dry time and 2.5 – 3.0 hour assembly/working time. The additional bonding time allows extra time between adhesive application and actual surface bonding. It is resistant to the effects of water and most household cleaning agents. Bonds become stronger and more resistant as they age.

### Suggested Uses:

*Ideal for bonding:*

- *Decorative Laminates*
- *Paper backed veneers*
- *Paper*
- *Cork*
- *Cloth*
- *Cloth-Backed Vinyl to Itself or Bonded to Particle Board*
- *Flakeboard*
- *Drywall*
- *Medium Density Fiber Board*
- *Wood*
- *Plywood*

### For Best Results:

- Not suitable for structural applications.
- Not for use with copper or copper alloys.
- Allow assemblies to cure for 72 hours before exposing to direct sunlight.
- Maintain stable temperature during curing period.

- Not recommended for bonding High Pressure Laminate to High Pressure Laminate (or any other nonporous to nonporous application).
- A small area should be tested first to ensure desired results.

### **Surface Preparation & Application:**

Read and understand all health and safety information before opening and using this product. This product is nonflammable as defined by the Federal Hazardous Substance Act but will ignite at temperatures above 140°F.

### **Preparation:**

1. Stir Contact Cement thoroughly with a standard paint paddle or stirring stick.
2. Prefit all parts before applying Contact Cement.
3. Both surfaces must be clean, dry and free of loose paint, varnish, grease, wax, oil, dust, sawdust or other release agents foreign to the surface itself. Painted or non-porous surfaces must be scarified (roughened) before adhesive is applied. For best results, at least one surface to be bonded should be porous (able to absorb water).
4. The temperature of surfaces and adhesive 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 such as Binks® (888-992-4657) or DeVilbiss® (800-338-4448) for their latest model recommendations and the proper pressure and spray settings.

- Fluid pressure should be 15 to 20 psi. Atomization air pressure should be 10 to 20 psi.
- All wetted application (pressure pot) components must be plastic, stainless steel or nickel plated. Hose should be either nylon lined or flexible polyethylene.
- 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.
- 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 (30-40 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.
2. Allow both surfaces to dry 30-40 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 instantly on contact and work cannot be shifted into place. 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. Possible substitute is a hard wood block and hammer.
5. No clamping required. Contact Cement bonds instantly upon contact 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).

**Physical & Chemical Characteristics:**

Flash Point:	>140°F
Solids:	53-55% by weight
Density:	9.3 lbs./Gallon
VOC, less water and exempt solvents:	<80 g/l (4%)
Odor:	Slightly Solvent
Color:	Natural
Consistency:	Like paint
Application Temperature Range:	65°F to 120°F (18°C to 49°C)
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 @ 3 dry grams per square foot:	Approximately 760 square feet per gallon
Shelf Life:	12 Months
Freeze-Thaw Stability:	5 Cycles @ 0°F
MSDS No.:	000 30534 001

**Clean Up & Storage:**

Remove excess adhesive and clean tools with mild detergent and water when wet. Mineral spirits and scraper knife are required when Contact Cement has dried. Product has a 12 month shelf life when stores in a cool dry place. Product will withstand five freeze thaw cycles without affecting performance. Follow original directions for reuse. Maximum storage time will be achieved if storage container has minimal air entrapment with a tight lid.

**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](http://www.dap.com) or calling 888-DAP-TIPS.

**Limited Warranty:**

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