



TECHNICAL DATA SHEET



Henkel Canada Corporation
Professional and Consumer Adhesives
Mississauga, ON L5N 6C3
Phone 1-800-624-7767
Fax (440) 250-9661
www.henkel.com www.lepage.com



DESCRIPTION

LePage® Pro Carpenter's Glue is a ready-to-use, multi-purpose, high tack, polyvinyl acetate woodworking adhesive ("aliphatic resin" glue). It is specially formulated for carpentry and cabinet making. Pro Carpenter's Glue has a greater wet tack than white glues, which allows faster gripping action and less slippage during the clamping process. It dries to a tough, high strength, humidity resistant bond. LePage Pro Carpenter's Glue dries to a translucent light yellow to blend with many wood grains, especially pine and is sandable and paintable LePage Pro Carpenter's Glue is non-toxic as per U.S. Federal Consumer Product Safety Commission, ASTM D 4236 and contains no urea formaldehyde. It also conforms to CSA 0112.4, CGSB 71-GP-5 and ASTM D4317-88 (10.2).

The 400 mL and 800 mL sizes of LePage Pro Carpenter's glue are available in the convenient Easy Flow Bottle. The Easy Flow System™ features include: an extended nozzle for precise application and flow control, a tapered nozzle ideal for biscuit joint applications, a re-sealable airtight cap with built-in tip holder and a wide neck for easy refilling. The bottle is easy to squeeze with its flat side and non-slip grip. There are also extra sealant threads for adding extra sealant nozzles.

RECOMMENDED FOR:

An interior wood adhesive for making tight fitting joints required in quality cabinet making, carpentry work, furniture and general wood gluing. Where a water-resistant adhesive is required use LePage Outdoor Wood Glue. Bonds porous substrates such as wood, wood compositions, veneer, cardboard, leather and cork.

NOT RECOMMENDED FOR:

- Joints that require gap filling
- Bonding two porous substrates. (e.g. plastic or metal)
- Applications that will be subject to direct water contact unless sealed and maintained with a waterproof coating prior to contact
- Structural applications (e.g. Load bearing applications in building construction)
- Storage in metal containers

Item #	Packaging	Size
530539	Oval Bottle	150 mL
442184	Easy Flow Bottle	400 mL
649429	Easy Flow Bottle	800 mL
530538	Plastic Jug	3 L

FEATURES & BENEFITS

Feature	Benefits
Adhesive:	
Sandable.....	Easy removal once cured
Paintable.....	Unaffected by finishes
Dries translucent yellow	Blends with many wood tones
Non-Toxic	Harmless
Bonds with 2 tons of strength.....	Bond is stronger than the wood
Not damaged by freezing.....	Stable up to five freeze/thaw cycles
Easy Flow System:	
Tapered nozzle.....	Precise application
Wide neck.....	Easy to refill
Re-sealable threaded cap.....	Air tight seal for long storage life
One flat size.....	Bottle will not roll away if placed on its side
Non-slip grip.....	Easy to handle
Easy-to-squeeze bottle.....	Excellent flow control



COVERAGE:

Approximately 3.9 m²/L (159 ft²/gallon) per surface @ 10 mils (0.010 inches) wet.

DIRECTIONS:

Tools Typically Required:

Wood clamps, damp cloth or rag and sandpaper.

Safety Precautions:

Wash hands after use.

Preparation:

Apply and cure adhesive when materials, working environment, and glue are at a working temperature above 15°C (59°F). Wood surfaces to be bonded must be clean, dry and dressed so that they are close fitting without gaps. Use woods with a moisture content between 7% and 12%. Extremely dry wood will soak up the water in the adhesive before the curing process can occur. Oily woods such as teak and rosewood should be freshly dressed and degreased using acetone. (Note: Acetone is highly flammable. Follow manufacturer's safety warnings.) Do not dilute the adhesive.

Application:

Spread LePage® Pro Carpenter's Glue evenly on both surfaces. Open time should be limited to 5 minutes. Join and clamp under moderate pressure, 345 to 1034 kPa (50 to 150 psi), until close fitting (i.e. no gap). Use higher pressure range for hardwood. Avoid excessive pressure, which will result in starved glue joints. Remove any "squeeze-out" with a scraper or by wiping with a clean, damp cloth. Allow a minimum clamping time of 25 minutes. For oily woods, allow extra clamping and drying time. When laminating multiple layers of wood or gluing assemblies under stress, allow additional clamping time. After clamping, allow glued sections to remain undisturbed overnight before subjecting to further finishing. Remove dried glue from surfaces by sanding or machining prior to staining or varnishing. Failure to do so will result in a white spot when using stains or clear coats.

Clean-up

Wipe excess glue immediately with a damp cloth. Wash hands immediately with soap and warm water. Cured adhesive may be carefully cut away with a sharp-edged tool or sanded. Rubbing with hot soapy water or steaming will aid removal. Paint strippers will also remove dried glue.

STORAGE AND DISPOSAL

Store above freezing. Freeze / thaw stable up to 5 cycles. Store in tightly closed containers at a storage temperature of 5°C (41°F) to 32°C (90°F). Do not store in metal containers. For unwanted product, allow to harden and dispose of with trash.

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>	Translucent pale yellow	<u>Application Temperature:</u>	Use above 15°C (59°F)
<u>Appearance:</u>	Free flowing liquid	<u>Odour:</u>	Minimal, acetic acid
<u>Base:</u>	Polyvinyl acetate	<u>Open Time:</u>	5 minutes
<u>Solvent:</u>	Water	<u>Clamping Time:</u>	25 minutes
<u>Specific Gravity:</u>	1.08	<u>Dry Time:</u>	24 hours @ 25°C (78°F) and 50% RH. Strength continues to develop for 7 days. Cold and damp conditions will lengthen dry time.
<u>Viscosity:</u>	6,000 – 10,000 cps (@ 20 rpm, 23°C)	<u>Clean Up:</u>	Uncured adhesive: Soap and water
<u>pH:</u>	4.5		
<u>VOC Content:</u>	0.37% by weight (4.00 g/l calculated)		

Shelf Life: 18 months from date of manufacture
 (Unopened)

Lot Code Explanation: **YM123-YYDDD**

YM123 = Batch Code = Manufacturing Code
 Y= Year
 M = Month
 123 = The batch # of a product manufacture
 in that given month and year.

(Lot code stamped on
 neck of bottle)

For Example:
 CE028
 C = Year = 2013
 E = Month = May
 028 = This is the 28th batch of this product
 to be manufactured in May 2013.

YYDDD = Date Code = Packaging Code
 YY = Last two digits of year of
 manufacture
 DDD = Day of manufacture
 based on 365 days in a year

For Example:
 13126
 = 126th day of 2013
 = May 6, 2013

Year		Month	
2006	F	January	A
2007	G	February	B
2008	H	March	C
2009	J	April	D
2010	K	May	E
2011	A	June	F
2012	B	July	G
2013	C	August	H
2014	D	September	J
2015	E	October	K
2016	F	November	M
2017	G	December	N

Note: I, L and O have been skipped so as not to confuse
 the letters with numbers.

Typical Cured Performance Properties

Colour: Translucent pale yellow

Cured Form: Hard, non-flexible

Paintable: Yes

Sandable: Yes

Specifications: Conforms to:

- CSA 0112.4,
- CGSB 71-GP5
- ASTM D 4317-88 (10.2)
- ASTM D 4236

Compression Shear Strength (ASTM D 905) :

- | | |
|---|---|
| ▪ Hard white maple, 60 min clamp, 24 hour dry time | 17.2 ± 2.4 N/mm ² (2494 ± 347 psi) |
| ▪ Marble (unpolished) to plywood, 1 kg pressure for 24 hours, 7 day dry time | 5.5 ± 1.4 N/mm ² (797 ± 201 psi) |
| ▪ Marble (polished) to plywood, 1 kg pressure for 24 hours, 7 day dry time | 4.6 ± 0.7 N/mm ² (666 ± 100 psi) |
| ▪ Granite (unpolished) to plywood, 1 kg pressure for 24 hours, 7 day dry time | 6.3 ± 1.4 N/mm ² (917 ± 203 psi) |
| ▪ Glass to pine, 1 kg pressure for 24 hours, 7 day dry time | 16.9 ± 5.2 N/mm ² (2454 ± 749 psi) |
| ▪ Maple to aluminum (sandblasted), 7 day dry time | 19.1 ± 2.7 N/mm ² (2772 ± 394 psi) |
| ▪ Pine to plastic laminate (back), 7 day dry time | 5.9 ± 0.7 N/mm ² (857 ± 108 psi) |