Henkel

TECHNICAL DATA SHEET

LEPAGE
**HEAVY DUTY
SPRAY ADHESIVE**

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Item #	Package	Size
1726250	Spray Can	468 g

DESCRIPTION:

LePage® Heavy Duty Spray Adhesive is a premium quality formulation that creates high strength and temperature-resistant permanent bonds. It dries clear and resists yellowing. Suitable for light and demanding applications and can be used indoors and outdoors. Ideal where support is not possible.

RECOMMENDED FOR:

Decorative laminate/trim work, marine applications, upholstery work, van/motor home conversions, kick plates, signage, wood, metal, glass, carpet and plastics (polypropylene, acrylics, PVC and more). LePage Heavy Duty Spray Adhesive can also be used to strengthen adhesive bonds for building weatherization systems (house wraps and flashing tapes) in cold weather applications.

NOT RECOMMENDED FOR:

- Foam board
- Unsupported vinyl fabric
- Installing / repairing car headliners
- Certain plastics and elastomeric substrates can exhibit bond failure due to plasticizer migration.
- Combinations of high temperature and high humidity can promote bond failure
- Exposure to sunlight or UV *

FEATURES & BENEFITS:

Feature	Benefits
High temperature resistant……………..……...	Can be used outdoors*
Dries clear ……………………………….…….	Invisible bond
Can apply multiple coats…………………..….	Increases bond strength
Does not bubble………………………………..	No reworking

COVERAGE:

Estimated coverage per can per coat when sprayed at a rate of approximately 3.5 seconds per 0.91 m (1 yard) from a distance of 20.3 cm (8 inches) from the surface is 7.0 ± 0.3 m² (75 ± 4 ft²).

DIRECTIONS:

Tools Typically Required
Kraft paper or other material to protect surrounding area.

Safety Precautions:
Well-ventilated area, wash hands after use.

Preparation:
For best performance, the adhesive and materials should be between 13°C (56°F) and 35°C (95°F). Shake can well before using (10-12 times). Surfaces must be clean, dry and free of foreign materials. Protect finished surfaces. Pre-fit all materials. Testing of substrates for compatibility is recommended. Repositioning is not possible. Turn spray tip so that the black dot is aligned with the nozzle.

Application:
Hold can in a vertical position. Point valve towards surface and spray from a distance of 20 to 25 cm (8” to 10”). Keep the can moving to create an even coat and avoid build-up on the surface. Start and stop the spray just off the work to prevent runs and sags. Apply an even coat to both surfaces to be bonded and allow to dry 2 to 5 minutes between coats. Apply maximum pressure over entire surface. Adhesive loses tack after approximately 10 minutes. Recoat if time exceeded. Porous surfaces will require more than one coat.

As an adhesive primer for building weatherization systems (house wraps and flashing tapes): The adhesive can be stored during cold weather application for up to 30 minutes at -18°C (0°F) before spraying. Apply one coat of the adhesive to one surface (i.e. OSB or house wrap) and immediately apply the adhesive surface of the flashing tape to the primed surface after approximately 10 seconds and apply pressure.

Clean-up:
After use, invert spray can and spray for approximately 2 seconds (or until spray is free of adhesive) to clear valve and spray tip. Clean spray tip with turpentine or mineral spirits. Note: When using solvents for cleanup, use proper precautionary measure.

STORAGE AND DISPOSAL

Store above freezing. Do not store at temperatures above 50°C (120°F). Store at room temperature away from direct sunlight. Use an approved hazardous waste facility for disposal.

LABEL PRECAUTIONS

EXTREME DANGER. VERY FLAMMABLE. CONTENTS MAY CATCH FIRE. CONTAINER MAY EXPLODE IF HEATED. Do not smoke. Do not puncture. Do not burn. Do not get in eyes or on skin or clothing. Do not breathe fumes. Use only in a well ventilated area. Keep away from flames, such as a pilot light, and any object that sparks, such as an electric motor. Store away from heat. **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:

Appearance:	Off-white liquid
Base:	Synthetic Rubber
VOC Content:	54.80% by weight
Specific Gravity:	0.83 – 0.84
Shelf Life:	24 months (unopened)
Lot Code Explanation: (Stamped on bottom of aerosol can)	For example: **13 285** A11J1 13 = Last two digits of year of manufacture (13 = 2013) 285 = Day of manufacture based on 365 days per year (285 = 285th day of year = Oct. 12th) Therefore, the date of manufacture = October 12th, 2013

Typical Application Properties

Application Temperature:	
Contact bonding	For best performance, the adhesive and materials should be between 13°C (56°F) and 35°C (95°F).
As a primer / adhesion promoter for building weatherization systems (house wraps and flashing tapes)	The adhesive can be stored and applied for up to 30 minutes at -18°C (0°F) prior to applying.
Open Time:	10 minutes
Odor:	Solvent (use in a well-ventilated area)

Typical Cured Performance Properties

Tensile Lap Shear Strength: (1 coat, 2 minute open time, 24 hr cure)	
Pine	0.61 N/mm^2 (88 psi)
Aluminum	0.41 N/mm^2 (59 psi)
PVC	0.54 N/mm^2 (78 psi)
Polypropylene	0.51 N/mm^2 (74 psi)
Acrylic	0.88 N/mm^2 (127 psi)
ABS	0.51 N/mm^2 (74 psi)
Tensile Lap Shear Strength: (2 coats, 2 minute open time, 24 hr cure)	
Pine	0.74 N/mm^2 (108 psi)
180° Canvas Peel Strength: (2 coats to canvas, 1 coat to other substrate, 2 minutes open time, 7 day cure)	
Aluminum	0.63 N/mm (3.6 lb/in) width peel
PVC – Rigid	0.61 N/mm (3.5 lb/in) width peel
ABS	0.68 N/mm (3.9 lb/in) width peel
Acrylic	0.74 N/mm (3.9 lb/in) width peel
Polycarbonate	0.74 N/mm (4.2 lb/in) width peel
T-Peel Strength: Felt to Felt: (2 coats, 2 minutes open time, 7 days dry)	1.40 N/mm (8.0 lb/in) width peel (substrate failure)
Climbing Drum Peel Strength (ASTM D1995) (Aluminum to aluminum, 1 coat to each surface, 10 minutes open time, 24 hour cure @ 23°C (73°F))	8.8 N/mm (5 lb/in) width peel
Specifications	Flame Spread Index: 5
ASTM E84: sprayed on inert substrate (fiber cement Board)	Smoke Development Index: 0
Adhesive Primer / Promoter for flashing tapes	
ASTM D3330 Standard Test Method for Peel Adhesion of pressure-Sensitive Tape Method F at room temperature	
Flashing to vinyl, aluminum	Approx 1.3 N/mm (7.3 lb/inch)
OSB	Approximately 1.9 N/mm (10.7 lb/inch)
Exterior gypsum	Approximately 1.7 N/mm (9.5 lb/inch)
AAMA 713-08 Voluntary Test method to Determine Chemical Compatibility of Sealants and Self-Adhering Flexible Flashings	No drain down or incompatibility after two weeks with building wrap, polyurethane and polystyrene foam
ASTM D3273 Fungal Resistance Test	Adhesive did not support fungal growth
ASTM D5893 (ASTM C679): Tack Free Time	
@ -3.8°C (25°F)	5 minutes
@ 21°C (70°F)	1 minute