



# TECHNICAL DATA SHEET



## PL® 620™

### Granite & Marble Construction Adhesive

**Description:** LePage PL 620 Granite & Marble Construction Adhesive is a premium quality adhesive formulated specifically for bonding marble, granite and a wide variety of other building materials. Its innovative formulation can be used in high moisture areas and will not bleed through or stain marble and granite. PL 620 is a revolutionary construction adhesive that provides superior results, has an extremely mild odour and a low VOC content, therefore making it ideal for both interior and exterior applications.

**Available As:**

Item #	Size	Package
1658765	295 ml	Paper Cartridge

**Features & Benefits:**

- High Strength – Up to 3X Stronger Than Conventional Adhesives
- Will Not Stain or Bleed Through
- Waterproof
- Broad Service Temperature Range
- Low Odor
- Low VOC Formulation

**Recommended For:**

PL 620 bonds marble and granite to stone, wood, foam, masonry, metal, concrete, OSB, brick, drywall, plywood and treated plywood.

**For Best Results:**

- Do not use on polystyrene tub surrounds
- Do not use for water submersion applications
- Do not use on polystyrene, polyethylene or polypropylene
- Certain materials such as rubbers and plastics may have bonding difficulties. Test before use

**Coverage:**

For a 295 ml cartridge:

- A 6 mm (1/4") bead extrudes approximately 9.3 m (31 ft)
- A 9.5 mm (3/8") bead extrudes approximately 4.1 m (13.6 ft)



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## Typical Uncured Physical Properties:

Color:	Tan	
Appearance:	Thick paste	
Base:	Polyurethane	
Odor:	Minimal	
% Solids:	90% by weight	
Specific Gravity:	1.26	
Flash Point:	93°C (200°F)	
Viscosity:	550,000 cps	
VOC Content:	3.5% by weight	CARB
	45 g/l	SCAQMD rule 1168
Shelf Life:	12 months from date of manufacture (unopened)	
Lot Code Explanation:	Example: 3L <b>4028</b> HP11	
Stamped on bottom plunger of cartridge	<b>4</b> = Last digit of year of manufacture <b>028</b> = Day of manufacture based on 365 days in a year So 4028 = January 28, 2014	

## Typical Application Properties:

Application Temperature:	Adhesive should be above -7°C (19°F) and 35°C (95°F) For best results, store product at room temperature 24 hours before use	
Open Time:	15 to 20 minutes*	@ 25°C (78°F) and 50% R.H.
Repositioning Time:	30 to 45 minutes*	@ 25°C (78°F) and 50% R.H.
Clamping Time:	24 hours	
Cure Time:	24 to 48 hours*	@ 25°C (78°F) and 50% R.H.
	*Times are dependent on temperature, humidity, porosity of surface bonded and amount of adhesive used	

## Typical Cured Performance Properties:

Color:	Tan	
Cured Form:	Non-flammable, rubbery solid	
Service Temperature:	-18°C (0°F) to 71°C (160°F) -18°C (0°F) to 121°C (250°F)	Long Term (Continuous) Short Term (Intermittent)
Water Resistant:	Yes	
Bond Strength*:		
Marble to Marble:	3.45 N/mm <sup>2</sup> (500 psi)	At full cure
Granite to Granite:	>3.45 N/mm <sup>2</sup> (>500 psi) Substrate failure	
	*Note: Bond strength data will vary as many variations exist in different types of stone	

## Directions:

### Tools Typically Required:

Utility knife, caulking gun, tool to puncture cartridge seal, plant mister bottle containing water.

### Safety Precautions:

Wear gloves. Cured adhesive on bare skin will not come off immediately with washing and will cause skin to darken. Cured adhesive and discoloration will come off in about 3 days.

### Preparation:

Use above -7°C (19°F). Surfaces must be clean and free of frost, standing water, grease, dust and other contaminants. Pre-fit all materials and protect finished surfaces. Cut nozzle at a 45° angle to desired bead size and puncture inner seal. Be very careful not to allow PL 620 to cure on a finished surface.

### Application:

Apply adhesive to one surface of the material being bonded. Press the surfaces firmly together within 15-20 minutes. Materials may be repositioned within 30-45 minutes after joining the surfaces. If bonding two non-porous surfaces (such as foam, metal and fiberglass), add water in the form of a very light or atomized spray from a plant mister bottle to the extruded



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adhesive. The repositioning time will then be reduced to less than 30 minutes. Use mechanical support for 24 hours while the adhesive cures. Cure time is dependent upon temperature, humidity, porosity of substrate and amount of adhesive used. Low temperature and humidity will slow cure time.

**Clean-up:**

Clean tools and adhesive residue immediately with mineral spirits. PL 620 must be removed mechanically once cured. Solvents have little effect on cured adhesive.

**Storage & Disposal:**

Not damaged by freezing. After completion of work, seal cartridge nozzle tightly with aluminum foil. Wrap the foil tightly around the nozzle and seal it with tape. Applying petroleum jelly around the opening before sealing with aluminum foil can create a more airtight seal. Product cures with exposure to moisture. Use an approved hazardous waste facility for disposal.

**Label Precautions:**

**CAUTION. POISON. CONTENTS MAY BE HARMFUL. CONTENTS MAY CATCH FIRE.** Do not get in eyes or on skin or clothing. Do not smoke. Do not breathe fumes. Do not swallow. 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. Wear chemical resistant gloves. **KEEP OUT OF REACH OF CHILDREN. FIRST AID TREATMENT:** Contains acetone and methyl acetate. If swallowed, call Poison Control Centre or doctor immediately. If in eyes or on skin, rinse well with water. If breathed in, move person into fresh air.

Refer to Material Safety Data Sheet (MSDS) for further information.

**Disclaimer:**

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