PATTEX CONTACT ADHESIVE

Technical Data Sheet v.1, September 2025

CHARACTERISTICS

- High initial and final strength
- High heat resistant
- Resistant to ageing

APPLICATION FIELD

- Combination bonding of wooden materials with decorative laminates such as Resopal®, Formica® etc., rubber, leather, cork, felt, rigid PVC, soft foams, metal and many other materials.
- Not suitable for polyethylene, polypropylene expanded polystyrene, synthetic leather and plasticized PVC.
- Fixing of soundproofing, insulating and acoustic panels (except expanded polystyrene), of suitable plastic tiles and various types of wall covering (not plasticized PVC or synthetic leather) onto dry, stable surfaces
- Bonding veneer strips to edges and curves

INSTRUCTIONS FOR USE

Surface preparation

- The material to be bonded should be: dry (wood 8% to 12% moisture), free of grease and dust
- Clean laminates, metal, etc., with solvent (washing benzine)
- Additional abrading increases bonding strength
- Allow material to acclimatize according to the manufacturer's instruction
- Only bond material to properly prepared and cleaned surfaces
- Painted or treated surfaces should be stripped beforehand

Application

Apply PATTEX CONTACT ADHESIVE generously and evenly to both surfaces to be bonded - especially at the edges - with a Pattex serrated spatula or a short-bristle brush.

Before joining the parts, allow solvents to evaporate. Evaporation time at normal room temperature (18°C to 25°C°C) is approx. 10-15 minutes.

Ensure constant airing. After evaporation time, bonding is possible within 2 hrs. Too less evaporation time especially for non-absorbent materials may cause weaker initial bonding results. After evaporation of the solvents there must be an unbroken, visible film of adhesive left on the surface. It may be necessary to apply several coats of adhesive to large-pored or highly absorbent materials. Before the parts can be joined, the adhesive must be dry to the touch. It should not stick to the finger or be "stringy".

Bonding / Pressing

First of all, carefully align the parts to be bonded, adjusting will not be possible after the two adhesive films are contacted. Then press the parts together briefly, but with pressure. It should be noted that the bonding strength depends not on the duration but the intensity of the pressure applied. Pressing for a few seconds is sufficient.

With larger areas to be bonded, e.g. laminate panels, metals etc., the pressure should be applied with a press (recommended pressure: 0.3 N/mm² - 3.0 bar). Depending on the work-piece, vigorous rolling (Pattex Pressure Roller) can also be sufficient. Press from centre outwards to avoid trapping air. Press carefully on edges. Where hard and inelastic bases are used, beat with a non-flexible hammer (HAZET hammer).

Further processing

Initial bonding strength is so high, that the work-piece can be further processed immediately after pressing.

APPENDIX

Consumption and other information

Product packaging	
Tube, g	50
Tube, g	125
Tin, ml	250
Tin, ml	500

TECHNICAL DATA

Composition	Solvent based polychloroprene rubber
Viscosity, mPa.s	1.800 - 2.300
Density, g/cm³	0.84 – 0.88
Heat resistance, °C	up to 110
Application temperature, °C	+18 to +25
Consumption, g/m²	250 - 350
Final strength	after 3 days
Shelf life, months *(Note: When stored in a cool and dry place)*	24
Evaporation time, min. *(Note: Evaporation rate of solvent in product increases with increasing room temperature)*	10 - 15
Press carefully on edges.	

LIMITATIONS

Cleaning

Clean tools immediately after use with thinner or washing benzine.

Storage

Store tightly closed and at temperature between +5°C and +30°C. Cold or frozen adhesive (under + 5°C) will become fully usable again if slowly acclimatized up to working temperature (approx. +20°C). No loss of quality is suffered. During work interruptions the adhesive container should be kept tightly closed in order to prevent evaporation of the solvents.

HEALTH AND SAFETY

Before using the product, please see related Material Safety Data Sheet, available at ‘mysds.henkel.com’.

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