



Technical Bulletin

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DAP® WELDWOOD® 2146MC Contact Adhesive High Solids Nonflammable Spray Grade

- An alternative to flammable products
- Excellent green strength
- Fast drying time

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.

Product Description:

Weldwood 2146MC Contact Adhesive is a sprayable contact adhesive specially developed to meet the reduced volatile and high coverage requirements of high-volume plastic laminate fabricators. 2146MC has excellent application properties and forms a high-strength bond that is resistant to water, many household chemicals and the effects of aging.

Suggested Uses:

For industrial or professional use only. It can be used for bonding decorative plastic laminates, wood, wood veneer, particle board, plywood, Gypsum wallboard, paper honeycomb, rigid polyurethane foam, and other similar materials. It is used in the manufacture of counter tops, table tops, desk tops, vanities, furniture, sandwich panels, doors, cabinets, partitions, wall panels, and other laminated products.

NOTE:

- Non-Flammable contact cements under pressure must not be exposed to aluminum.
- The solvents in this cement may damage painted surfaces, vinyls, and other plastics. Test a small area for damage before actual use.
- Contact adhesive is not suitable for structural bonds.
- Do not use on copper, copper alloys, some vinyls or polystyrene foam. Not recommended for post-forming applications.
- Let adhesive assemblies cure for at least 72 hours before exposing to direct sunlight or temperature above 150°F.
- Application equipment must be compatible with chlorinated solvents.

Performance Characteristics:

2146MC consistency has been carefully selected for optimum spray characteristics. The high solids formulation substantially increases square foot coverage per gallon and reduces volatile emissions. Thinning is not recommended. The formulation is specifically designed to reduce drying time to a minimum and develop high green strength to increase production time.

Surface Preparation & Application:

Surface Preparation:

Surface must be clean, dry and free from oil, dust, and other foreign material.

Application:

- 2146MC may be applied with standard hot or cold 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. Vary atomization air pressure from 20 to 90 psi depending on spray pattern desired. 20 psi provides a coarse, wet spray, 90 psi is dry and finely atomized. Adjust fluid pressure to 25 to 30 psi.
- Apply adhesive to approximately 80% coverage over the entire area. Apply additional adhesive to edges to achieve 100% coverage.
- Allow surfaces to dry before bonding. This will take 2-5 minutes when hot sprayed; 10-20 minutes when cold spray equipment is used. When dry, the adhesive will feel tacky, but will not transfer to kraft paper pressed onto the adhesive surface.
- Surfaces must be joined within two hours after application. If the surfaces are not joined within this time, they can be reactivated by applying another coat of adhesive.
- Apply pressure. A minimum of 25 psi bond pressure is suggested for best results. A pinch roller or rotary press is recommended. If not available, use a 3 inch rubber hand roller and apply pressure from the center toward the edges to avoid air pockets and bubbles. Do not use so much pressure as to crush core materials.

Physical & Chemical Characteristics:

Appearance:	Natural or Green
Base:	Synthetic Rubber
Nonvolatiles:	25%
Viscosity:	Approximately 250 cps
Wt./Gal.	10.1 lbs.
Shelf Life:	1 year minimum at 70°F
Coverage:	Approximately 480 sq. ft./gallon (single surface)
Flash Point:	None
Packaging:	

<u>UPC</u>	<u>Color</u>	<u>Size</u>
04652	Natural	5 Gallon
04654	Natural	55 Gallon
04662	Green	5 Gallon
04664	Green	55 Gallon

MSDS No. 30508

Clean Up:

Clean equipment and adhesive spills with 0912 Nonflammable solvent.

Safety:

Read the Product Label and the Material Safety Data Sheet for safety information prior to using this product. The MSDS may be obtained by calling 888-DAP-TIPS or online at www.dap.com.

Warranty Information:

DAP Inc. warrants that this product, when used in accordance with label, technical bulletins, and applicable industry standards, will be free from defects in material and manufacture for 12 months from date of purchase. If a product defect is encountered, then DAP's **sole liability** is to either supply new product or refund the purchase price, at DAP's option. **This warranty excludes all other express or implied warranties, including the implied warranties of merchantability and fitness for a particular purpose.** DAP will in no event be liable for any incidental or consequential damages. Any claims shall be deemed waived unless made in writing to us within 30 days from the date it was, or reasonably should have been, discovered.