



**POWERHOLD**

# CONTACT CEMENT

**Cemento de contacto**

## DESCRIPTION:

Powerhold 500 is a brush/roller coat neoprene contact adhesive developed especially for bonding decorative plastic laminate to particle board in the manufacturing of counter tops. As a general purpose industrial type adhesive, PH 500 can be used for non-structural bonding of wood, metal, rubber, leather, canvas, rigid polyurethane foam, paper honeycomb and many other porous and non-porous surfaces.

## SURFACE PREPARATION:

Materials to be bonded must be clean and dry; free of oil, dirt, paint, moisture, grease, etc. Adhesives and substrates must be 65°F or higher prior to, during and after bonding.

## DIRECTIONS:

1. Brush or roller coat in area equipped to exhaust the solvent vapor.
2. All motors and other equipment must be underwriter labeled (UL) explosion proof for operation.
3. Coat both surfaces to be bonded with a pattern uniform in appearance. You should have 100% surface coverage including the edges.
4. Allow the adhesive to dry completely before bonding. This will take about 15 to 25 minutes.
5. When dry, the adhesive will feel tacky, but will not transfer to the finger when touched.
6. If the two surfaces do not grab immediately when touched together, the open-time has been exceeded and another coat will be required.
7. Force drying is recommended to give consistently high performance bonds and to eliminate variations caused by temperature and humidity.
8. Drying time can be reduced substantially by heating the coated surfaces with hot air, infrared lamps or strip heaters.
9. Production requirements will determine the amount of heat necessary and therefore the number of lamps or strips and the length of the oven.
10. Exhaust fans are necessary to remove solvent odors.
11. Position the parts carefully because no adjustment is possible after the adhesive makes contact.
12. Apply equal pressure across the entire surface of the material. A minimum of 40 psi bond pressure is suggested for best results.

13. A pinch roller or rotary press is recommended. If not available, use a three inch rubber hand roller and apply pressure from the center toward edges to avoid air pockets and bubbles.

14. You may trim or rout immediately.

15. It is the sole responsibility of the installer to determine the suitability and compatibility of the adhesive for the end user's intended use.

**FOR MORE INFORMATION READ SAFETY DATA SHEET**

**KEEP OUT OF REACH OF CHILDREN.**

## CLEAN-UP:

Clean up adhesive residue with citrus-based cleaner or nonflammable solvent such as methylene chloride. When using solvents, always read and follow the manufacturer's precautions and directions for use.

## WARRANTY:

Powerhold offers a limited warranty for this product when used in accordance with printed specifications. A copy of the limited warranty can be obtained by calling technical service at 800-832-9023 or visiting [powerhold.com](http://powerhold.com).

## PACKAGING

- 1 Quart (0.95 L) Containers
- 1 Gallon (3.79 L) Containers
- 5 Gallon (18.93 L) Containers

## SHELF LIFE

12 months min. @ 70°F in un-opened container

## COVERAGE:

120-140 sq ft / gal





# 500

## TECHNICAL DATA:

BasePolymer:.....	Crumb Rubber Emulsion
Color:.....	Amber
Weight/gallon:.....	6.80 lbs.
VOC Content:.....	<1 gram per liter
pH:.....	7.25
Consistency:.....	Liquid
FlashPoint:.....	Less than 20°F (see caution)
Storage:.....	40°-95°F
Application Temperature:.....	60°-95°F
Traffic Restrictions:.....	Foot Traffic after 12 hours, Heavy Traffic after 24 for wet-set Foot Traffic after 4 hours, Heavy Traffic after 12 hours for dry-set
Open Time:.....	Up to 5-10 minutes depending on porosity and environmental conditions
Freeze/ThawStability:.....	5 cycles @ 20°F