

AC3471

LATEX CONTACT CEMENT

PRODUCT DESCRIPTION

DURAPRO AC3471 is a water-based adhesive designed for bonding high pressure laminates panels (HPL), polyurethane foam, polystyrene foam and fabrics to wood, plywood or particle board. AC3471 has a long open-time, good contactability under low pressure, excellent green strength, high shear and peel strength, and superior hot creep resistance. Its flowability and high solids content allow to spread easier and to cover up to three times the surface area than a solvent based contact cement.

PRODUCT FEATURES

- Complies with new 2024 VOC limits
- Solvent free
- Low odor
- Heat resistant

PREPARATION

Stir well before using. Adhesive and materials must be at room temperature above 20°C. All surfaces to be glued must be clean and dry. Remove all paint, varnish, grease, oil, dust, sawdust and other foreign materials. Pre-fit parts before applying adhesive.

APPLICATION

Apply a uniform coat of glue to both surfaces using a soft brush, short nap roller or spray gun. Allow to dry 20 to 45 minutes or until the film turns from opaque to transparent gloss (dull spots require an additional coat). Porous surfaces such as trim strips may require two coats. If left to dry beyond 2 hours reactive adhesive by applying a second coat. When dry, place both surfaces in exact position and join them carefully. The bond is instant on contact and surfaces cannot be repositioned. Using a metal roller or a rubber mallet apply a firm pressure over entire area, working from the centre toward edges to eliminate any air pockets. Roll in two directions at 90° angles to each other. Adhesion strength will increase with aging, but edges can be cut for finishing immediately. Let cure at least three days before exposure to direct sunlight or high temperatures.

COVERAGE

8 - 9 m²/L (320 - 360 sq.ft./gallon) in surface area.
NOTE: Yields shown are based on theoretical calculations for comparison

purposes and may vary on particular conditions on the jobsite. Porous surfaces and substrates may require more adhesive than the typical coverage rate.

PHYSICAL PROPERTIES

Viscosity	1,500 – 2,000 cps (5/20 rpm/25°C)
Solids	49 – 51 %
Colour	Off White
Odour	Mild when wet No odor when dry
Specific Gravity	1.06
Open Time *	20 - 45 minutes
Cure Time *	72 hours
Heat resistance (after curing 15 days)	Up to 150°C
VOC calculated (SCAQMDR 1168)	< 80 g/L less water < 5 % per weight

*(depending on temperature and humidity)

CLEAN-UP

Clean hands and tools immediately after use with warm water. If adhesive has dried, use an adhesive cleaner or mineral spirits with a clean white cotton cloth.

STORAGE

Store indoor in a cool, dry location between 10°C and 35°C. Keep container closed when not in use. Protect from freezing. Product is freeze-thaw stable if frozen not lower than -10°C in transit.

SHELF LIFE

Shelf life is 18 months at room temperature in original unopened container.

DISPOSAL

Consult your municipality to dispose container and left-over in accordance with environmental regulations.

PACKAGING

Item code	Size	Units per case	Units per row	Units per pallet
AC3471-950	950 ml	6	72	432
AC3471-378	3.78 L	2	20	100
AC3471-015	15 L	1	16	48
AC3471-PD	205 L	1	4	4
AC3471-CGT	1000 L	1	1	1

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ENVIRONMENT

This product contains no added urea-formaldehyde. The use of this product may contribute in obtaining LEED credits. This product complies with new 2024 VOC limits (DORS/2021-268).

PRECAUTIONS

Keep out of reach of children. May cause slight eye and skin irritations. Avoid contact with eyes and skin. **FIRST AID TREATMENT:** If in eyes or on skin, rinse the affected areas with water. If swallowed, drink water and call a doctor. **For industrial user – Refer to Safety Data Sheet (SDS) for further information.**

Consumer product labeled for sale and for use in Canada.

LOT CODE

Lot code (batch number) is stamped on the lid or on the side panel of the container. Code consists of 6 digits: 2 letters and 4 numbers

1st letter = last number of the year of production corresponding to the sequential alphabetical order (excluding I and J) (starts over at A every decade) ;

2nd letter = indicates the month of production corresponding to the sequential alphanumeric order (excluding I and J) ;

4 numbers = sequential batch number starting by 0001 on the 1st day of production in the annual calendar year.

Example: LA0123

1st letter: L = 2020

2nd letter: A = January

4 digits = 0123 = 123th batch produce since January 1, 2020

WARRANTY

Surface conditions, product application, storage and transport are beyond the manufacturer's control; liability, if any, is limited to the replacement of product ONLY.

DISCLAIMER

Our personal is available to help purchasers obtain best results from our products, and recommendations are based on tests and information believed to be reliable. However, since we have no control over the conditions under which our products are transported to, stored, handled, or used by purchasers, all recommendations and sales are made on conditions that we will not be held liable for any damages resulting from their use. No representative of ours has any authority to waive or change this provision.

TECHNICAL SERVICES

Technical assistance is available by phone at 800-361-2340 or email at durapro@dural.ca

To acquire technical and safety literature, please visit our website at www.duraproadhesives.com .

MANUFACTURED BY

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ADDITIONAL GENERAL SPRAYING APPLICATION INFORMATION

TYPICAL FLUID PRESSURE: 5 - 20 psi

ATOMIZATION PRESSURE: 15 - 30 psi

DRY FILM THICKNESS: 2.5 to 3.5 grams/ft²

SPRAY EQUIPMENT: *(consult your equipment supplier for models available)*

- Binks: Hand gun: 95, 2001
Auto gun: M95
Fluid tip: 66SS
Air cap: 66SDSDJG, 66SD-3
- Devilbiss: Hand gun: JGA-510, MBC-510
Auto gun: AGX-550
Fluid tip: FF, FX
Air cap: 797, 7700

NOTES

- 1- Parts of equipment that are in contact with the wet adhesive must be stainless or of other corrosion-proof material.
- 2- Spray system oil and water traps must be functioning, drained regularly and are at least 25' from the air compressor.
- 3- User is responsible for testing and adjusting the equipment.
- 4- READ AND UNDERSTAND THE LABEL, THE TECHNICAL BULLETIN AND THE SAFETY DATA SHEET BEFORE USING THE PRODUCT.

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