



Technical Bulletin

2400 Boston Street, Suite 200, Baltimore, Maryland 21224

Phone: 410-675-2100 or 800-543-3840

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DAP® WELDWOOD® 0306/0307 High Heat Resistant Contact Cement

- **For a wide range of applications**
- **Ease of use**
- **Excellent end results**

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® 0306/0307 HHR Spray Contact Adhesive is a sprayable contact adhesive specially developed to meet the requirements of plastic laminate fabricators. 0306/0307 adhesive has excellent application properties and forms a high strength, high heat resistant 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, aluminum, mild steel, wood, wood veneer, particle board, plywood, Gypsum wallboard, galvanized steel, 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.

Performance Characteristics:

- Postformable
- Resists water and many household chemicals
- Up to 2 hours open time
- Over dried adhesive may be reactivated by applying another thin coat of adhesive
- Use as supplied, no thinning required
- Meets the performance requirements of Federal Spec. A-A-1936
- Available in both natural and red

Surface Preparation & Application:

Surface Preparation:

Surfaces to be bonded must be clean and dry, adhesive, and air temperature and surfaces should be at least 65°F (18°C).

Application:

- Fluid pressure should be 15 to 25 psi. Atomization air pressure should be 70 to 90 psi (80 to 100 psi for HVLP).
- Use a standard or hot spray system to apply an even coat to both surfaces. Direct spray perpendicular to the plane of the substrate from approximately 10 to 12 inches away. 80% coverage forms an effective bond. 100% coverage is recommended at the edges.
- Allow both coated surfaces to dry before bonding (approximately 2 to 3 minutes when hot sprayed and 5 to 10 minutes if conventional spray is used). When dry, the adhesive will adhere to but not transfer to kraft paper pressed onto the adhesive surface. Sufficient coverage is indicated by a glossy appearance. Two coats may be necessary for porous substrates.
- Index both pieces accurately. Contact adhesives bond instantly on contact and work cannot be shifted into place. Apply pressure with a pinch roller or rotary press. If not available, a 3 inch rubber hand roller may be used (working from center to edge). Roll in 2 directions at 90° angles to each other. Apply as much pressure as possible, being careful not to crush core materials

Note:

- Contact adhesive is not suitable for structural applications.
- May damage some plastics, test before use
- Do not use on copper, copper alloys, some vinyls or polystyrene foam.
- Let adhesive assemblies cure for at least 72 hours before exposing to direct sunlight or temperature over 150°F.
- Adhesive may gel if stored at low temperatures, but returns to normal viscosity at 70°F (21°C).

FOR BEST RESULTS

Satisfactory spray results can be achieved with practically any conventional air 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.

Physical & Chemical Characteristics:

| | |
|--------------------|---|
| Appearance: | 0306 - Natural, 0307 - Red |
| Base: | Polychloroprene Synthetic Rubber |
| Solids: | 19% |
| Viscosity: | 170 cps |
| Wt./Gal.: | 6.6 lbs. |
| Shelf Life: | 12 months minimum at 70°F |
| Coverage: | Approximately 237 sq. ft./gallon @ 2.5 dry gm./sq. ft. (single surface) |
| Flash Point: | Less than -20°F (see caution) |
| Postforming Grade: | Yes |
| Packaging: | |

| UPC | Color | Size |
|-------|---------|-----------|
| 00095 | Natural | 5 Gallon |
| 00097 | Red | 5 Gallon |
| 00098 | Red | 55 Gallon |
| 04051 | Natural | 55 Gallon |
| 04054 | Red | 55 Gallon |

MSDS No.: 30513

Clean Up:

Use Weldwood 0901 Solvent to clean up equipment and adhesive spills

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.