



# TECHNICAL DATA SHEET

2400 Boston Street | Suite 200 | Baltimore, MD | 21224

## DAP® WELDWOOD® 1145 High Heat Resistant High Solids Contact Adhesive

### PRODUCT DESCRIPTION

DAP WELDWOOD 1145 High Solids HHR Contact Adhesive is a sprayable contact adhesive specially developed to meet the reduced volatile and high coverage requirements of high volume plastic laminate fabricators. DAP® Weldwood 1145 High Solids HHR Contact adhesive has excellent application properties and forms a high strength, high heat resistant bond that is resistant to water.



PACKAGING	COLOR	UPC
1 Gallon	Natural	7079800252
5 Gallon	Natural	7079800250

### KEY FEATURES & BENEFITS

- Lower glue line costs
- High Solids
- Superior green strength

### PERFORMANCE CHARACTERISTICS

- Postformable
- Water resistant
- 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



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## 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.

## APPLICATION

The surfaces to be bonded must be clean, dry and free of all foreign material. Previously applied finishes should be removed and the parts must be pre-fitted before any adhesive is applied. The temperature of the adhesive, the surfaces being bonded, and the working area should be at or above 65°F.

Satisfactory spray results can be achieved with practically any conventional air spray equipment. Contact industrial spray gun manufacturers for their latest model recommendations and the proper pressure and spray settings.

### Surface Preparation:

Surfaces to be bonded must be clean and dry. Adhesive, air, and surface temperatures must be at least 65°F (18°C)

### Application:

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 5 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, reactive metals, soft plastics, 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).



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## TYPICAL PHYSICAL & CHEMICAL PROPERTIES

Adhesive Base:	Polychloroprene Synthetic Rubber
Solids:	23.5%
Flash Point:	Less than -20°F
Viscosity:	450 cps
Weight/Gal	6.8 lbs.
Coverage:	Approximately 360 sq. ft./gallon @ 2 dry grams per sq. ft. (single surface)
Appearance:	Natural
Shelf Life:	12 Months Minimum @ 70°F

## CLEAN UP & STORAGE

Clean excess wet adhesive from surfaces and tools with mineral spirits. Dried adhesive must be cut or scraped away. Clean hands with warm water and soap. DO NOT use solvents to remove product from skin. Store container in cool, dry place away from extreme heat or cold.

## SAFETY

See product label or Safety Data Sheet (SDS) for health and safety information. You can request an SDS sheet by calling 888-DAP-TIPS or by visiting our website at [dap.com](http://dap.com).

## WARRANTY

**LIMITED WARRANTY:** If product fails when used as directed within one year of purchase, DAP will provide replacement product or refund sales price: call 888-DAP-TIPS with your sales receipt and product container available, to arrange for warranty fulfillment. DAP is not liable for incidental or consequential damages.

## COMPANY IDENTIFICATION

**Manufacturer:** DAP Products Inc., 2400 Boston Street, Baltimore, Maryland 21224

**Usage Information:** Call **888-DAP-TIPS** or visit [dap.com](http://dap.com) & click on "Ask the Expert"

**Order Information:** 800-327-3339 or [orders@dap.com](mailto:orders@dap.com)

**Fax Number:** 410-558-1068

**Also, visit the DAP website at [dap.com](http://dap.com)**