



**KLEER CELLULAR PVC ADHESIVE  
TWO PART LAMINATING ADHESIVE**

**DESCRIPTION:** Kleer Cellular PVC Laminating Adhesive is a two-component low viscosity, solvent free, structural adhesive formulated for laminating un-milled Kleer cellular PVC an open time at 75°F of 10-15 minutes after mixing. Its lower viscosity provides enhanced “flow-out” requiring less clamping pressure to achieve a thin, void-free bond. It provides excellent adhesion able to withstand thermal cycling and shock loading between dissimilar materials.

**FEATURES:**

- Permanent unitizing structural adhesive
- Easy to apply with thin bonds
- Moderate dry time can be handled in 45 minutes, machined in 1 hour
- Completely waterproof
- UV stable to resist yellowing and fading
- Color matched to Kleer Cellular PVC
- Paintable

**PACKAGING:**

220 ml two-part cartridge with GRAY label

**DIRECTIONS:** DO NOT REMOVE THE SKIN ON THE FACE OF THE KLEER CELLULAR PVC PRIOR TO LAMINATING. Clean PVC pieces prior to use. Insert cartridge in applicator gun. Remove cap, replace with Kleer Quick Mixer Tip and apply beads across the short ends of the pieces being laminated. Apply a continuous bead down the center of the two parts being laminated forming an “I” shape with the adhesive. The wider the part, the larger the center bead should be. Slide the surfaces of the parts being laminated over each other to help facilitate flow out on all four sides. When flow out on all four sides is achieved, clamp for 60-90 minutes. Remove cartridge from gun, remove Kleer Quick Mixer Tip, wipe cartridge tip with a clean cloth making sure not to mix adhesive and catalyst. Strike the end of the cartridge on a hard surface so plungers back up slightly. Seal with original cap. Once dried, excess adhesive can be removed with a chisel, router or saw. Product should not be used below 32°F.

TECHNICAL DATA (Uncured Liquid)	
Viscosity	30,000 cPs mixed
Specific Gravity	1.01 (20/20°C)
Color	White to match Kleer cellular PVC Products
Flashpoint	51°F
Toxicity	Moderate, refer to MSDS
Solvents	None
Mix Ratio	1:1
Fillers	Yes
Clean Up Solvent	Alcohol, MEK, Acetone
Shelf Life	12 months when stored in unopened original container between 55°-75°F

TECHNICAL DATA (Cured Solid- 0.030” typical film thickness)	
Shore D Hardness	75
Thermal Service Range	-65°F to 260°F
Chemical Resistance	Excellent
Elongation	30%
Impact Resistance	20 ft lbs/in <sup>2</sup> on Steel
Peel Strength	20-25 psi on Aluminum
Lap Shear Strength	3390 psi- aluminum

**PRECAUTIONS:**

**FLAMMABLE LIQUID.** Do not use near fire or flame. Do not smoke near product.

- Use in well ventilated area.
- Harmful if swallowed.
- May cause eye and skin irritation.
- Keep out of reach of children.

Manufactured for Kleer Lumber, Inc by Extreme Adhesives, Inc. Raymond, NH.