



**KLEER CELLULAR PVC ADHESIVE
TWO PART 20-25 MINUTE CURE TIME**

DESCRIPTION: Kleer Cellular PVC Adhesive- Two Part 20-25 Minute Cure Time is a durable, two-component adhesive for Kleer cellular PVC applications with a work life at 75°F of 20-25 minutes after mixing. It is ideal for applications where a slower cure time is preferred. It can be used to fill nail holes and gaps up to 1/8" without the need for fasteners or biscuits. It is EPA VOC and CARB compliant.

FEATURES:

- Permanent unitizing structural adhesive
- Easy to apply: Slower dry time is ideal for larger applications
- Can be handled in 90-120 minutes
- Completely waterproof
- UV stable to resist yellowing and fading
- Color matched to Kleer Cellular PVC
- Paintable

PACKAGING:

50 ml two-part cartridge with BROWN label, 220 ml two-part cartridge with BROWN label

DIRECTIONS: Remove dust, dirt and contaminants prior to use. Group multiple joints to minimize the number of Quick Mixer tips required. Insert cartridge in applicator gun. If using a partial cartridge, mark the removable cap and save for resealing. Replace cap with Kleer Quick Mixer Tip. Fill tip and apply as needed. Press parts together and hold or clamp. Clean excess adhesive quickly with a putty knife or rubbing alcohol. Joints may be handled in 90-120 minutes. When finished, remove cartridge from gun, remove the Kleer Quick Mixer Tip, and wipe the cartridge 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 using aligning marks. Product should not be used below 32°F.

TECHNICAL DATA (Uncured Liquid)	
Viscosity	50,000 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	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	60%
Impact Resistance	20 ft lbs/in ² on Steel
Peel Strength	20-25 psi on Aluminum
Lap Shear Strength	2340 psi- as rec'd CRS 3390 psi- aluminum 3365 psi grit blasted steel

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.