

# Technical Bulletin

Revised: ~~5/6/195/6/1912/12/1812/6/18~~

## DAP® Weldwood® Landau Top & Trim Contact Adhesive 1145 HHR High Solids Contact Adhesive Spray Grade

- Lower glue line costs
- Less solvent
- Superior green strength

**Packaging:** 1 Gallon & 5 Gallon  
**Color:** (Natural [amber])  
**UPC Number:** < 7079800250 >, < 7079800252 >

### Company Identification:

**Manufacturer:** DAP Products 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 **dap.com**.

### Product Description:

DAP® Weldwood® Landau Top & Trim 1145 Contact Adhesive is a sprayable contact adhesive specially developed to meet the reduced volatile and high coverage requirements of high volume plastic laminate fabricators. 1145 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.

### Performances Characteristics:

- Postformable
- Resists water and many household chemicals
- Up to 2 hours open time



## 1145 High Solids HHR Spray Grade Contact Cement Revision 1

- Over dried adhesive may be reactivated by applying another thin coat of adhesive
- Use as supplied, no thinning required
- Available in both natural and red

### 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:

Fluid pressure should be 15 to 25 psi. Atomization air pressure should be 70 to 90 psi (80 to 110 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 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, 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).

### Typical Physical & Chemical Characteristics:

Appearance:	Natural or Red
Base:	Polychloroprene Synthetic Rubber
Solids:	23.5%
Viscosity:	450 cps
Wt./Gal.:	6.8 lbs.
Shelf Life:	6 months -at 70°F
Coverage:	Approximately 290 sq. ft./gallon @ 2.5 dry grams per sq. ft. (single surface)
Flash Point:	Less than -20°F

SDS No.: **00030528001**

### Clean Up & Storage:



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Use Toluene or Xylene to clean up equipment and adhesive spills. Store in cool, dry place.

### **Safety:**

See product label or Safety Data Sheet (SDS) for health and safety information. You can request an SDS sheet by calling 1-888-DAP-TIPS or by visiting our website at [dap.com](http://dap.com).

**LIMITED WARRANTY:** If product fails to perform, within one year of purchase, when used as directed, call 1 (888) DAP TIPS, with your sales receipt and product container available, for replacement product or sales price refund. Neither DAP Canada, DAP Products Inc. or their respective affiliates will be liable for incidental or consequential damages under any circumstances./

