



TECHNICAL DATA SHEET



100% Glue™

Description: LePage 100% Glue is a true all-purpose glue that is strong in and around the house for your repairing, crafting & building projects. It contains active ingredients for best bonding performance. This patented Flextec® technology was developed by LePage, the trusted leader in adhesives since 1876. LePage 100% Glue dries crystal clear, does not wrinkle paper and sets with no clamping. 100% Glue is also elastic, shock resistant, non shrinking and water resistant. It is suitable for gap filling and can be used indoors and outdoors.

Available As:

| Item # | Size | Package |
|---------|--------|-------------|
| 1752740 | 50 ml | Glue bottle |
| 1747644 | 100 ml | Glue bottle |

Features & Benefits:

- Transparent, Multi-Purpose Glue
- Strong In and Around the House
- 0% Solvent Added
- Strong & Flexible
- Water Resistant
- Temperature Resistance: -40°C to 50°C

Recommended For:

For DIY, repair and modeling work in and around the house. Compatible with many porous and non-porous materials such as aluminum¹, stainless steel, steel, copper¹, brass¹, bronze¹, concrete, tiles, ceramic, glass, mirror¹, wood, cork, chipboard, MDF, varnished surfaces¹, fiberglass reinforced polyester, unfinished leather, linen, paper, cardboard, rigid PVC, polycarbonate, sanded ABS, polystyrene foam (Styrofoam®) and natural stones. ¹ see limitations below

For Best Results:

- Not for use on polyethylene (PE), polypropylene (PP), polytetrafluoroethylene (PTFE) / Teflon®, ABS and rigid polystyrene
- Before application carry out tests to ensure the compatibility of LePage 100% Glue with non-ferrous metals such as aluminum, copper, bronze and brass as well as with different coatings such as paints, varnishes and powder coatings. Variations in composition may affect adhesion.
- LePage 100% Glue is only compatible with mirrors whose reflection and protective coating complies with DIN 1238 5.1 and DIN EN 1036. See application instructions.
- The cured product is water-resistant, but not suitable for water immersion

Coverage:

250 g/m² when applied to one surface only

Note: The required amount of adhesive depends on the substrate porosity and thickness of any gap



TECHNICAL DATA SHEET

Typical Uncured Physical Properties:

| | | |
|-----------------------------|---|------------------|
| Color: | Transparent and Colorless | |
| Appearance: | Liquid Gel | |
| Base: | Silane moisture-curing polymer | |
| Odor: | Minimal | |
| Specific Gravity: | 1.1 | |
| Flash Point: | 61°C (142°F) | |
| Viscosity: | 8,000 to 20,000 cps | |
| VOC Content: | 8.7% by weight | CARB |
| | 278.5 g/l | SCAQMD rule 1168 |
| Shelf Life: | 18 months from date of manufacture (unopened) | |
| Lot Code Explanation: | YYDDD | |
| Printed on bottom of bottle | YY= Last two digits of year of manufacture DDD= Day of manufacture based on 365 days in a year Example: 4061 = 61 st day of 2014 = March 2, 2014 | |

Typical Application Properties:

| | | |
|--------------------------|---|-------------------------|
| Application Temperature: | Apply between 5°C (41°F) and 40°C (104°F) | |
| Open Time: | 8 to 15 minutes* | At 23°C (73°F) & 50% RH |
| Repositioning Time: | 5 minutes* | At 23°C (73°F) & 50% RH |
| Clamp Time: | Minimum 30 minutes | |
| Cure Time: | 24 hours* | |
| | *Times are dependent on temperature, humidity, porosity of surface bonded and amount of adhesive used | |

Typical Cured Performance Properties:

| | | |
|-------------------------------|---|--|
| Color: | Clear and Colorless | |
| Cured Form: | Non-flammable, flexible solid | |
| Service Temperature: | -40°C (-40°F) to 80°C (176°F) -40°C (-40°F) to 50°C (122°F) | Short Term (Intermittent) Long Term (Continuous) |
| | Note: Exposures above 50°C (122°F) will cause some yellowing | |
| Water Resistant: | Yes | |
| Paint Compatibility: | Compatible with acrylic paints, polyurethane-based varnishes and alkyd resin varnishes. When using alkyd resin paints drying may be delayed. It is not compatible with one component polyurethane paints. | |
| Tensile Shear Strength: | | 7 day cure at 23°C (73°F) 1 square inch bond area |
| Pine to Pine: | 2.70 N/mm ² (392 psi) | |
| Maple to Maple: | 3.40 N/mm ² (493 psi) | |
| Maple to Aluminum: | 2.59 N/mm ² (375 psi) | |
| Aluminum to Aluminum: | 1.68 N/mm ² (243 psi) | |
| Cold rolled steel to itself: | 1.30 N/mm ² (189 psi) | |
| Maple to Stainless steel: | 3.39 N/mm ² (491 psi) | |
| Stainless steel to itself: | 3.42 N/mm ² (496 psi) | |
| Maple to PVC (hard): | 1.50 N/mm ² (218 psi) | |
| PVC to PVC (hard): | 0.75 N/mm ² (109 psi) | |
| Maple to polycarbonate: | 3.26 N/mm ² (473 psi) | |
| Maple to Acrylic (sanded): | 1.61 N/mm ² (234 psi) | |
| Maple to ABS: | 0.82 N/mm ² (119 psi) | |
| Maple to ABS (sanded): | 2.56 N/mm ² (371 psi) | |
| Maple to Fiberglass (sanded): | 3.10 N/mm ² (450 psi) | |
| Tensile Shear Strength: | | 7 day cure, 3 hr water immersion |
| Maple to Maple: | 3.25 N/mm ² (471 psi) | |
| Maple to Aluminum: | 2.55 N/mm ² (370 psi) | |



TECHNICAL DATA SHEET

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| Compression Shear Strength: | | 7 day cure |
| Maple to Maple: | 3.2 N/mm ² (466 psi) | |
| Peel Strength: | | 7 day cure |
| Canvas to Canvas: | 0.7 N/mm (4 lb/inch) | |
| Canvas to Pine: | 1.9 N/mm (11 lb/inch) | |
| Corduroy to Maple: | 1.0 N/mm (6 lb/inch) | |
| Felt to Pine: | 1.6 N/mm (9 lb/inch) | |
| Unfinished Leather to Pine: | 1.4 N/mm (8 lb/inch) | |

Directions:

Safety Precautions:

Wear gloves and wash hands after use.

Preparation:

Protect work area. Surfaces to be glued must be sound, clean, dry (see Application below) and free of grease, dust, old adhesive residue, paint and other contaminants such as plasticizers and mold release agents. Remove contaminants with alcohol or acetone (tests surfaces for compatibility before). For improved adhesion lightly sand very smooth or glossy surfaces and clean thoroughly. Pre-fit all materials before applying adhesive. When bonding two non-porous surfaces dampen surfaces lightly before applying adhesive. Mask off the adjacent areas before gluing with tape if necessary. To open, rotate cap counter-clockwise.

Application:

Apply a thin layer of adhesive to one surface. Bond parts immediately after applying the adhesive and hold or clamp parts together (before skin formation) for at least 30 minutes. For best results allow 24 hours cure before subjecting to stress. Unlike other adhesives high pressure during curing is not necessary. Very porous materials will require a thicker layer of adhesive and application to both surfaces may be required.

LePage 100% Glue cures by absorbing moisture into the bond line from the ambient air (air humidity or water vapor) or from the substrate. If both surfaces to be joined are non-porous (i.e. metal to metal or plastic to plastic) then they can only be glued by pre-wetting both surfaces with a damp cloth before applying the adhesive. Avoid wetness, pooling water or water drop formation. For large surface areas make sure that the moisture film does not dry off before applying the adhesive. Absorbent surfaces are normally water-permeable and do not require pre-wetting. However the curing process can be considerably accelerated for both absorbent and non-absorbent substrates if the surfaces are pre-wetted by wiping the areas to be glued with a damp cloth before applying the adhesive. The adhesive can be applied to damp surfaces. The adhesive will reach its maximum strength after it has fully cured and the substrates have fully dried.

After setting, the adhesive can be painted, especially with water based acrylic paint.

Mirror bonding: Be very careful not to scratch or damage the back coating of the mirror. Protect surrounding areas and floors from drips, squeeze outs etc. Apply the adhesive to the back of the mirror or the substrate in vertical beads approximately 3 mm (1/8 inch) wide and approximately 2.5 – 5 cm (1-2 inches) apart. Do not place the adhesive too close to the edge to prevent squeeze out (leave approximately 2.5 – 5 cm (1-2 inches) from the edges). Within 5-8 minutes place firmly up against the wall and tape in place until cured. Support the bottom of the mirror to prevent slippage until the adhesive cures. For mirrors larger than 0.09 m² (1 square foot), this product must be used with a permanent support system. Place mirror into support channels or hangers and press in place within 5-8 minutes. Tape or brace the top of the mirror until the adhesive has set at least 48 hours. For non-porous surfaces longer curing time will be required. Do not try to reposition the mirror once in place. If sealing the edges wait a minimum of 7 days. Curing time will depend on temperature, humidity, type of substrate and amount of air that can reach the adhesive.

Clean-up:

Clean tools and adhesive residue immediately after use with alcohol, acetone or cleaner's naphtha. Cured sealant may be carefully cut away with a sharp-edged tool. Cured adhesive cannot be removed from clothing and is not soluble in any solvent.

Storage & Disposal:

Store above freezing in a cool and dry place, at 5 to 35°C (41 to 95°F). Avoid direct sunlight. Close the tube tightly immediately after each use. Exposure to high humidity during storage will reduce shelf life. Exposure to high temperatures during storage (> 50°C, 122°F) will cause the product to yellow in the bottle.

To dispose of unwanted product, squeeze out remaining material, allow to dry and discard with domestic waste. Dispose of non-hardened product residues according to the applicable local regulations. Large product amounts must be disposed of separately. The empty packaging can be recycled.

Label Precautions:

Methanol is released during application and cure, which may affect the nervous system causing dizziness, headache or nausea. Do not swallow. Use only in a well-ventilated area. Do not get in eyes or on skin or clothing. Wear gloves when applying product. **KEEP OUT OF REACH OF CHILDREN. FIRST AID TREATMENT:** Contains trimethoxyvinylsilane. If swallowed, call Poison Control Centre or doctor immediately. If in eyes or on skin, rinse well with water. If breathed in, move person to fresh air.

Refer to Material Safety Data Sheet (MSDS) for further information.



TECHNICAL DATA SHEET

Disclaimer:

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Purchasers should test the products to determine acceptable quality and suitability for their own intended use. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.



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