



PB920-Plus High Pressure Laminate and Veneer Contact Adhesive

Technical Data

April 2018

Product Description A versatile, high performance industrial contact adhesive. This adhesive is water resistant and temperature resistant to above 200° F. Designed for bonding decorative laminates to particleboard, but may also be used on a variety of other substrates including veneers, fabrics, upholstery, foam, headliners, and mirrors, cork, tile, fiberglass and plastics.

Typical Physical Properties

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

PB920-Plus High Pressure Laminate and Veneer Contact Adhesive	
Base	Synthetic Elastomer
Solids Content (by wt.)	31%
Density (lbs/gal)	7.34
Viscosity (cps)	N/A
Colors	Clear or red
Volatile Organic Compounds (VOC)	<440 g/l
Hazardous Air Pollutants (HAPS) % wt (calculated)	<47%
CARB Compliant	No
SCAQMD 1168 Compliant	No
GREENGUARD Indoor Air Quality Certified®	No
LEED® Eligible	No
Spray Pattern	Web
Dry Time	2 - 5 minutes
Bonding Range	2 - 45 minutes
Shear Adhesion Failure Test – SAFT ⁽¹⁾	220°F (104°C)
Flammable Solvent	No, but product overall is flammable
Flammable Propellant	Yes

(1)SAFT Shear Adhesion Failure Test with birch plywood, 1 inch overlap, 100 grams used, temperature start at 90°F and ramped 10°F every 10 mn. until complete failure.

Key Features

- Fast tack, strong bonds
- Temperature resistance to above 200°F
- Water resistant
- Cost effective

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Directions for Use PB920-Plus High Pressure Laminate and Veneer Contact Adhesive is designed to be applied to the two surfaces about to be joined. Spray an even coat of adhesive to cover 80% to 100% of the surfaces. Do not wet the surface. Allow to dry 2 to 4 minutes and become tacky. For porous surfaces and crucial areas such as edge bonding, it is recommended to apply a second coat after the first has dried and become tacky. Place the coated surfaces together and apply a uniform pressure for strongest bond. Full adhesive strength can be reached in 24 hours. Please note that adhesive and substrates should be 60°F or higher for best results. Also insure that surfaces are dry and free from dirt.

Available Sizes

Container Size	Clear		Red	
	3M ID	UPC Number	3M ID	UPC Number
Large Cylinder – 37.5 lbs.	70-0075-0751-3	0-00-76308-86767-6	70-0075-0747-1	0-00-76308-86763-8
Intermediate Cylinder – 187.5 lbs.	-	-	70-0075-0748-9	0-00-76308-86764-5
Jumbo Cylinder – 375.5 lbs.	-	-	70-0075-0750-5	0-00-76308-86766-9

Cylinder Accessories

Accessories	Description	3M ID Number	UPC Number
Applicator	Cylinder Adhesive Applicator w/ 9501 tip	62-9880-9930-5	00-048011-61706-0
Hoses	Cylinder Adhesive 6' Hose	62-9880-0006-3	00-051115-25036-1
	Cylinder Adhesive 12' Hose	62-9880-0012-1	00-048011-61988-0
	Cylinder Adhesive 25' Hose	62-9880-0025-3	00-048011-61989-7
Tip	Cylinder Spray Adhesive 6501 Spray Tip	62-9880-6501-7	00-048011-61991-0

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Storage Conditions	Store product at 60°- 80° F (16°- 27°C) for maximum storage life. Higher temperatures reduce normal storage life. Lower temperatures may cause increased viscosity of a temporary nature. Rotate stock on a “first in-first out” basis.
Shelf Life	When stored at the recommended conditions in original, unopened container, this product has a shelf life of 15 months from date of shipment.
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