

# Dispersion contact adhesive

# DKK 392

## Fields of application

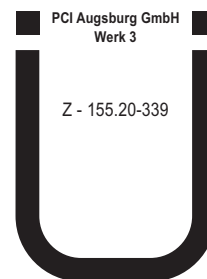
- Dispersion contact adhesive for the interior.
- For treads and risers.
- For repair of floorings.
- For contact gluing of
  - baseboards made of soft PVC or natural rubber
  - nosing of stairs and concave baseboards made of PVC, linoleum and natural rubber
  - textile floorings (tufted, woven and nonwoven)
  - floorings made of design PVC, PVC and CV
- linoleum floorings
- natural rubber floorings
- cork floorings.
- For contact gluing of rebound walls and suitable textile floorings on walls and ceilings.
- Suitable for
  - underfloor heating
  - exposure to chair castors in accordance with DIN EN 12 529
  - cleaning by wet shampooing and spray extraction.

## Features and benefits

- Very low emissions, GEV-EMICODE EC 1.
- Awarded the environmental label "Blauer Engel" due to low emissions (RAL UZ 113).
- Solvent free to TRGS 610; Giscode D 1.
- Fields of application similar to neoprene contact adhesives containing solvents.
- High initial bond and adhesive strength.
- Adhesive can be applied to coverings/baseboards the day before the application.
- Very good workability with roller and paint brush.

## Packaging size

- 6 kg plastic pail stock no. 4363/9
- 0.35 kg cartridge (one box contains 12 cartridges) stock no. 4365/3



Emissionsgeprüftes Bauprodukt  
nach DIBt-Grundsätzen



## Technical data

### Material

Material base	modified polychloroprene dispersion, mineral fillers, additives, preservative agents
Components	single component
Consistency	creamy
Colour	light beige
Shelf life	min. 9 months; store dry, no storage under +5°C and permanently not over +30°C

### Application

Consumption	approx. 250 to 400 g/m <sup>2</sup> in total for both adhesive sides, depending on substrate structure, backing and application method
Ambient, substrate and material temperature	min. +10°C to approx. +25 °C
Application method	contact method; two-sided application to substrate and backing with large-pored foam roller or paint brush
Evaporation time*	approx. 20 to 40 minutes depending on substrate structure, backing and application method and/or quantity of adhesive applied
Installation time (contact glueing)*	approx. 2 hours after application of adhesive; when applying the adhesive the day before: approx. 60 minutes
Able to bear weight	immediately
Heat-seal seams after*	12 hours at the earliest
Final adhesive strength after*	approx. 48 hours

\* At +23°C and 50% relative humidity and depending on the applied quantity and absorbency of the substrate. Higher temperatures reduce, lower temperatures increase the times given. Higher humidity increases the times given.

## Suitable substrates

- Absorbent and non-absorbent, level and/or smooth floors.
- PCI fairing coats.

## Preparation of substrate

- The requirements in accordance with the German standard DIN 18 365 apply.
- The substrate must be ready to take further coverings, clean, dry, level, crack free, structurally sound and able to bear weight. Remove old coats and other residues which could impair adhesion. The substrate must also be free from any sand layer.
- Rough-grind substrate if necessary, thoroughly vacuum-clean with a high-speed industrial vacuum-cleaner, and - in normal cases - prime and smooth with the suitable PCI products. Mastic asphalt substrates must generally be primed and smoothed.
- The contact surfaces must be practically level. Rough-grind and clean smooth, impermeable contact surfaces (e.g. coatings, metal, plastic, old use surfaces), remove grease if necessary.

## Application procedure of PCI DKK 392

- Using a large-pored roller, apply a thin layer of PCI DKK 392 to both the material to be glued and the substrate. We recommend to use a paint brush for baseboards, edges and corners and areas which are difficult to access. Use a roller grid to evenly spread the adhesive on the roller or spread the adhesive e.g. on a particle board.
  - Allow both adhesive layers to evaporate until almost tack free. It is also possible to apply the adhesive to the back of the flooring/profile the day before the application. Allow the other "adhesive side" (substrate) to evaporate only as long as it takes to be "finger dry".
  - Install flooring/profile within the installation time and firmly press it down or use a roller on the floor.
- Caution: later adjustment is not possible! Repeat this process after approx. 10 to 20 minutes especially around the seams.
- Be sure that the back of the flooring and/or profile as well as the substrate is entirely covered with PCI DKK 392.
  - **Follow the special installation instructions issued by the flooring manufacturers.**

## Please note

- The dryer the adhesive film (considering the evaporation and installation times!) the higher the initial adhesive strength!
- Dispersion-based contact adhesives dry more slowly than contact adhesives containing solvents. Low ambient and material temperatures, high relative humidity and very thick adhesive layers increase the evaporation time more considerably than solvent-containing contact adhesives. It is possible to "counteract" by e.g. frequent ventilation, use of a blow dryer and thin adhesive layers.
- Adhesive residues can be removed with tension-free, lukewarm water to prevent possible visible staining (adhesive turns dark) at a later stage. Adhesive residues which are slightly dry can be removed from most smooth surfaces by "rubbing".
- Clean tools with water immediately after use.
- When taking short breaks, immerse roller or paint brush in the adhesive pail as far down as necessary to prevent the tools from drying out. As an alternative, the tools can be tightly wrapped in foil to avoid drying out.

## Information on the safe use

Product contains:

1,2-benzisothiazol-3(2H)-one.

May cause an allergic reaction.

Keep out of reach of children. Provide for proper ventilation during and after processing. When using, do not eat,

drink or smoke. In case of contact with eyes or skin immediately rinse with lots of water. If the eye irritation does not ease off within a few minutes get medical advice.

Giscode D1

*For further information: see PCI Material Safety Data Sheet.*

## Disposal of product residues

Do not empty product/residues of material into drains, bodies of water or ground. Cured material residues can be disposed of as construction or industrial

waste. Non-cured material residues with or without packaging must be disposed of in accordance with the local waste disposal regulations.

## Disposal of emptied PCI sales packaging

PCI participates in an area-wide waste disposal system for sales packaging completely emptied. DSD – Duales System Deutschland (Dual System Germany, contract number 1357509) is

our partner for waste disposal. PCI sales packaging completely emptied can be disposed of via DSD in accordance with the symbol printed on the packaging.

## Services for architects and designers

Consultations at the workplace, supplementary information, testing certificates and sample descriptions can

be requested from professional advisors and at the company headquarters.



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zertifiziertes Qualitäts-  
managementsystem

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