

### PG-101<sup>®</sup> POLYURETHANE ADHESIVE

#### PRODUCT DESCRIPTION

PG-101 is a moisture-curing 1-component polyurethane containing pre-polymerized MDI, (Diphenylmethane-4, 4-Diisocyanate) and used for laminating and joining all species of wood and other materials.

PG-101 requires no mixing or additives to cause the adhesive to cure. Moisture (water) in the air and/or in the material to be bonded will cause PG-101 to cure. As it cures, it will foam and self-spread.

PG-101 contains no solvents. Although liquid, it has a 100% resin content. It will not evaporate and when curing produces no vapors other than trace amounts of CO<sub>2</sub>. We suggest that you wear disposable gloves or avoid contact with hands as it can cause allergic reactions with repeated contact over time.

When cured, PG-101 is resistant to solvents. One of the many advantages of this remarkably strong product is that the hardened adhesive does not become brittle and is non-thermoplastic, meaning it will not expand or contract in the glue joint. In addition, it will not clog sand paper or dull cutting tools. Cured PG-101 is 100% waterproof, pH neutral, and can be sanded, machined, painted or stained.

#### PRODUCT USE

It will bond ceramics, stone, plastics, metal, softwoods, hardwoods, teak and other exotic or challenging woods - without any special preparation or resin removal.

Prepare the surfaces to be joined in the usual manner, i.e., have clean, dust free and tight fitting joints.

- \* Spread PG-101 on one of the surfaces to be joined. PG-101 foams up as it cures and is self-spreading. Remember to wear disposable gloves. For Oak, Maple or other very hard or dense woods dampen the substrate with water and use plenty of clamping pressure. It's wise to do a test piece first.
- \* Clamp your work in the usual manner for 1 to 4 hours, depending on temperature and moisture content. The lower the temperature the longer the clamping time. When the squeeze-out or leftover adhesive is firm to the touch, the PG-101 is substantially cured and can be unclamped. Full strength is achieved in 24 hours under normal conditions.
- \* Remove your uncured squeeze-out with isopropyl (rubbing) alcohol, "Goof Off," or other common solvents or wait until it is somewhat or fully hardened and remove mechanically with a chisel, scraper, or sandpaper.

#### FEATURES OF PG-101

- \* 100% waterproof and solvent-free with a 100% solid content. Stainable and pH-neutral.
- \* Single-side application. Coverage is ½ fluid ounce per square foot. This is equal to 2 to 3 times the coverage of other adhesives. Wet adhesive will foam up in volume 3 to 4 times.
- \* Approximately 20 minutes open working time. Remains workable throughout the entire open time.
- \* Clamping time is 1 to 4 hours depending on temperature and moisture content. After clamping time, it achieves 90% strength, and full strength is achieved in 24 hours.
- \* Temperature range is 40° F to 130° F. Best results at 68° F to 130° F. Flash point is 375°F.
- \* 3-4 year shelf life unopened. 6 months to 1 year after opening and resealing (store upside down to prolong shelf life).
- \* Will not freeze even at -100° F. Keep unused adhesive well sealed and dry.
- \* Will bond wood with a moisture content up to 25%. Recommended moisture range is 8% to 20%.
- \* Leaves little or no glue line & non-thermoplastic. Will not expand or contract in the glue line after curing.
- \* Odorless with no out gassing other than CO<sub>2</sub>. Non-harmful to the environment after hardening.

Sizes available: 4oz. / 8oz. / 16oz.

For health and safety information concerning this product, please refer to the MSDS sheets for PG-101 Polyurethane Adhesive. MSDS sheets are available on our website at [www.systemthree.com](http://www.systemthree.com).

