

Clifton STAR PVC Adhesive LA 4009 Gluing Instructions

Clifton STAR PVC Adhesive LA 4009 is designed to be mixed with Clifton STAR Accelerator ACC 4009. This two-part combination is an excellent glue for PVC- and urethane-coated materials. It gives high initial bond strength and quickly cures to a high-strength, heat-resistant final bond.

Recommended Safety Precautions:

- Work in a well-ventilated area (garage or shady area works well).
- Organic fume respirator
- Chemical resistant gloves (i.e. Nitrile gloves)
- Eye protection
- Extra lint-free rags for spills/cleanup

Environmental conditions:

- Ideal ambient temperature for gluing: 75°F and below 50% humidity.
- Maximum humidity: Do not try to mix and apply glue if the humidity exceeds 70%.

Items needed:

- Adhesive LA 4009 – Item # 38709.01
- Accelerator ACC 4009 – Item # 38712.01
- Methyl ethyl ketone (MEK) – Item # 38752.01
- Patch material
- Disposable 1" bristle brush
- Pro Roller – Item # 38757.01, or Roller Rasp – Item # 38756.01
- Mixing container with volumes marked in ounces and millimeters, Leaktite Multi-Mix 1-pint cups, or equivalent, look in paint and hardware stores or online.
- Hair dryer

Material preparation:

1. Cut the patch to extend at least 2" beyond all edges of the tear. Be sure to round the corners of the patch. Square-cornered patches are more likely to catch and peel than rounded patches.
2. Trace the area of the patch on the damaged surface with a pencil.
3. Swab the surfaces with a cloth dampened with MEK. If you can't get MEK, acetone can be substituted
4. Allow the materials to dry for a minimum of 5 minutes.
5. Mix the LA 4009 Adhesive with the ACC Accelerator (see the Accelerator Usage Guide for mixing instructions) and stir until uniform. The mixture has a pot life of 8 hours; keep container covered when not using.
6. Apply 2 thin coats of the mixture to the surfaces to be bonded, allowing 5-10 minutes drying time between coats.

7. Allow the second coat to dry completely, ~ 15 minutes. Now combine the two surfaces with one of the following methods

Solvent activation:

1. Swab both surfaces with a cloth dampened with MEK, to reactivate the adhesive.
2. Allow the solvent to evaporate, approximately 15-30 seconds. The surfaces should now be tacky; when touched with a knuckle they should feel sticky, but no adhesive comes off on the skin.
3. Carefully line up the patch and roll onto the boat, being careful to avoid trapping air underneath. Once the surfaces touch you will have difficulty repositioning the patch.
4. Roll the patch thoroughly in all directions to ensure a good bond.
5. If possible, let the patch cure for 24 hours before bringing the chamber to full pressure.

Heat activation:

1. If you can use a hair dryer this is an excellent option. It allows you to precisely position the patch. It's especially useful for doing an inside patch.
2. Lay the patch in place and use the hair dryer, on the high setting, to heat the area to about 120°F, or just "barely too hot to touch."
3. While keeping the hair dryer playing over the patch, thoroughly roll the area to ensure a good bond.
4. If possible, let the patch cure for 24 hours before bringing the chamber to full pressure.
5. It is not recommended for someone without experience to use a heat gun as it can easily get too hot for the material.

LA 4009 may also be used as a one part in an emergency, or where the heat and chemical resistance are not required. It can be reactivated with MEK or heat.