



# TECHNICAL DATA SHEET

## PL<sup>®</sup> 610<sup>™</sup>

### Mirror Construction Adhesive

**Description:** LePage PL 610 Mirror Construction Adhesive is a high performance adhesive formulated especially for mounting mirrors. It can be used on most structurally sound interior surfaces such as wood, drywall, metal and painted surfaces. It is easy to apply and will provide a safe, strong and permanent bond for the installation of electro-copper plated mirrors.

**Available As:**

Item #	Size	Package
1664870	295 ml	Paper Cartridge

**Features & Benefits:**

- Strong, Durable Bond
- Safely Secures Mirrors
- Low VOC Formulation
- Will Not Flake or Become Brittle

**Recommended For:**

LePage PL 610 Mirror Construction Adhesive is designed for the permanent fastening of electro-copper plated mirrors to structurally sound interior wall surfaces.

**For Best Results:**

- Do not use for overhead applications
- This product is only to be used with a securely mounted permanent support system, such as "L" hangers or "J" channels, during and after cure
- Not recommended for mounting mirrors to wall-papered surfaces
- Can be used only on electro-copper plated mirrors

**Coverage:**

For a 295 ml cartridge:

- A 6 mm (1/4") bead extrudes approximately 9.3 m (31 ft)
- A 9.5 mm (3/8") bead extrudes approximately 4.1 m (13.6 ft)



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## Typical Uncured Physical Properties:

Color:	Tan	
Appearance:	Thick paste	
Base:	Synthetic Rubber and resins	Formaldehyde free
Solvent:	Acetone	
Odor:	Strong, solvent (use in well-ventilated area)	
Specific Gravity:	1.39	
Flash Point:	-17°C (1.4°F)	
Viscosity:	270,000 cps	
VOC Content:	0.25% by weight	CARB
	7.5 g/l	SCAQMD rule 1168
Shelf Life:	18 months from date of manufacture (unopened)	
Lot Code Explanation:	<b>YYDDD</b>	
Stamped on bottom plunger of cartridge	<b>YY=</b> Last two digits of year of manufacture <b>DDD=</b> Day of manufacture based on 365 days in a year Example: 14061 = 61 <sup>st</sup> day of 2014 = March 2, 2014	

## Typical Application Properties:

Application Temperature:	Apply and cure between -18°C (0°F) and 38°C (100°F) For best results, apply between 15°C (60°F) and 30°C (85°F)	
Open Time:	10 minutes*	@ 25°C (78°F) and 50% R.H.
Repositioning Time:	15 minutes*	@ 25°C (78°F) and 50% R.H.
Cure Time:	2 to 7 days*	@ 25°C (78°F) and 50% R.H.
	*Times are dependent on temperature, humidity, porosity of surface bonded and amount of adhesive used	

## Typical Cured Performance Properties:

Color:	Tan	
Cured Form:	Non-flammable solid	
Service Temperature:	-29°C (-20°F) to 66°C (150°F)	
Water Resistant:	Yes	
24 Hour Shear Strength:	0.41 N/mm <sup>2</sup> (60 psi)	ASTM C557
14 Day Shear Strength:	0.41 N/mm <sup>2</sup> (60 psi)	ASTM C557
Cyclic Exposure Shear:	0.41 N/mm <sup>2</sup> (60 psi)	ASTM C557
24 Hour Tensile Shear:	0.21 N/mm <sup>2</sup> (30 psi)	ASTM C557
14 Day Tensile Shear:	0.21 N/mm <sup>2</sup> (30 psi)	ASTM C557
Specifications:	Meets or exceeds ASTM C557	

## Directions:

**Tools Typically Required:** Utility knife, caulking gun and tool to puncture inner seal of cartridge

**Safety Precautions:** Interior applications require ventilation to the outside during application and cure. Wear gloves. Wash hands after use.

**Preparation:** The temperature of the adhesive, the surfaces and the working area must be between 4°C - 38°C (40°F - 100°F), however for best results, temperatures between 15°C - 30°C (60°F - 85°F) for 24 hours or longer are recommended before installation. Be very careful not to scratch or damage the back coating of the mirror. Ensure surfaces to be bonded are clean, dry, structurally sound and free of dust, grease, oil or other contaminants. Concrete surfaces must be painted to prevent caustic lime from attacking the mirror backing. Prime drywall and plaster surfaces. For painted surfaces, lightly sand with coarse sandpaper. Cut off tip of cartridge at 45° angle to give a 6 mm (1/4") diameter bead. Puncture seal inside of nozzle. Protect surrounding areas and floors from drips, squeeze outs etc. Install plastic holders or clips or support channel prior to the application of the adhesive.



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**Application:** Using a caulking gun, apply adhesive to back of mirror in 5 to 7.5 cm (2 to 3 inch) diameter spots approximately 12 mm (1/2 inch) thick for every square foot of mirror. Do not place the adhesive too close to the edge to prevent squeeze out. A support system, such as plastic holders or clips must be used to hold mirrors in place. Place mirror in position in supports and carefully press into place within 10 minutes of application. The adhesive should be compressed so that it is approximately 3 mm thick (1/8 inch). Do not attempt to remove or reposition the mirror once in place. Brace top of mirror to hold in place while the adhesive cures, usually 48 hours. Maximum bond strength is obtained when the original bond is preserved. Typically, PL® 610 will cure to 60% strength within 48 hours at normal room temperature. Total time required for curing depends upon temperature, humidity, porosity of substrate and amount of air that can reach the adhesive. For non porous surfaces longer curing time will be required. If sealing the edges wait a minimum of 7 days.

**Clean-up:** Clean tools and uncured adhesive residue immediately with mineral spirits or paint thinner in a well-ventilated area to the outdoors. Cured adhesive may be carefully cut away with a sharp-edged tool.

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**Storage & Disposal:**

NOT DAMAGED BY FREEZING. Store away from heat, flame and spark in a cool, well-ventilated place at room temperature 21° ± 3°C (70° ± 5°F). In cold weather, product should be kept at room temperature for at least 24 hours prior to use to improve extrusion. Use an approved hazardous waste facility for disposal.

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**Label Precautions:**

**DANGER. POISON. FLAMMABLE. CONTENTS MAY BE HARMFUL. CONTENTS MAY CATCH FIRE.** Do not get in eyes or on skin or clothing. Do not smoke. Do not breathe fumes. Do not swallow. Use only in a well ventilated area. Keep away from flames, such as a pilot light, and any object that sparks, such as an electric motor. Wear chemical resistant gloves. **KEEP OUT OF REACH OF CHILDREN. FIRST AID TREATMENT:** Contains acetone and methyl acetate. If swallowed, call Poison Control Centre or doctor immediately. If in eyes or on skin, rinse well with water. If breathed in, move person into fresh air.

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

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**Disclaimer:**

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