

WX/10 PVA Technical Data Sheet 2008

1. PRODUCT SUMMARY

- Cadre WX/10 is a high quality one component adhesive conforming to the EN204/205 standard, group D3 and BS4071. The addition of Cadre OP/M hardener increases the water resistance of the glue line to conform to group D4 if required. Cadre WX/10 is characterised by a high creep resistance, high heat resistance and fast setting time. Cadre WX/10 is used for bonding window frames, stairs, doors, Radio Frequency gluing, bonding of laminated panels, carcass/assembly gluing and any other surface gluing of laminate material (High Pressure Laminates) onto different substrates.

2. STORAGE

- The product may be stored for up to 12 months in properly closed original containers, kept cool and dry (15 - 25°C). Protect against frost.

3. PACKAGING

- 1kg bottles, 5kg and 25kg cans. 150kg drums - all non-returnable. 1000kg FloTrip containers - returnable upon arrangement with our sales office. No liability is accepted for any loss or damage arising directly or indirectly from the use of the Company's products. Prospective users should therefore satisfy themselves by appropriate trials that the product to be used is suitable for the intended use. Purchase of this product is subject to the Terms & Conditions detailed in our Terms of Business - a copy is available on request).

4. SUGGESTION FOR USE

- Cadre WX/10 must be spread uniformly on the surfaces to be bonded, using a spatula, glue roller/spreader or any other suitable equipment. Machining of the wood and the bonding thereof, must be done, as much as is practical, on the same day. Some types of wood, such as IROKO for example, need to be bonded within a few hours. The surfaces to be bonded must be assembled before the maximum open time has expired, and pressed until sufficient bond strength is achieved. When bonding high-pressure laminates, take care that on the reverse side of the laminates, there are no anti-adhesive substances that can influence the bonding characteristics. Bonding must be carried out at temperatures above the minimum film forming temperature (TMF). We suggest this should be at least 5 - 8°C higher. Avoid the addition of flour and other substances that could affect the adhesive performance. During the hot season, the viscosity of the adhesive on the glue spreader could increase, during time. If this is the case, 1-3% water should be enough to bring the viscosity to the original value. Care must be taken with some species of wood with high contents of resin, tannin and other substances, which can cause discolouration. Clean all working tools and equipment immediately after use with water. With dried adhesive, cleaning will be more difficult, but may be improved using solvent such as toluene or MEK. For Health and Safety information and handling advice please refer to our Health & Safety sheet on this product. If any of the application conditions or bonding parameters is changed from those when the product was initially recommended to you, you should first check with our Technical Department for suitability

5. BASE

- Polyvinyl acetate (PVAc)

6. CHARACTERISTICS

- | | | |
|--|----|-----------------|
| - Solid content: | % | 50 +/- 1 |
| - Viscosity at 20°C and 20 RPM (Brookfield) mPas | | 14,000 +/- 1000 |
| - pH: | | 2.5 - 3 |
| - TMF | °C | 5 - 6 |
| - Colour | | White |

7. OPTIMAL CONDITIONS OF USE

- | | | |
|--|----|---------|
| - Temperature of room, materials to be bonded and adhesive | °C | 18 - 20 |
| - Humidity of Wood | % | 8 - 12 |

8. GLUE SPREAD

- | | | |
|---|------------------|-----------|
| - for wood lamination | g/m ² | 120 - 160 |
| - for flat surfaces | g/m ² | 100 - 150 |
| - for assembly | g/m ² | 100 - 200 |
| Open time (150g/m ² glue coat) | mins | 8 - 10 |

9. PRESSING TIME

- Decorative paper at 80 - 100°C secs 5
- High pressure laminate and veneering at 80 - 90°C secs 50-70
- High-pressure laminate and veneering at room temperature 18-20°C mins 20 - 40

b. solid wood

- at room temperature minutes> 20 - 25
- at 50 - 70°C minutes> 8 - 10
- by RF minutes> 2 - 3

The pressing time is greatly influenced by the ambient conditions, types of wood, amount of adhesive spread and the structure of the materials to be bonded.

For D4 Bonding - Glue mixture

- Cadre WX/10 PP 100
- OPM/Hardener PP 4 - 5
- Pot Life at 20°C Hours 8

