

TIMBATECH 010

POSTFORMING FLAT PRESSING GRADE ADHESIVE

DESCRIPTION

TimbaTech010 is a high performance adhesive designed for bonding melamine laminate to particleboard. It is designed to replace solvent-based contact adhesive where large flat areas are bonded.

FEATURES AND BENEFITS

The high solids/fast dry characteristics of **TimbaTech010** enable rapid handling and through put. The grab of **TimbaTech010** is moderate. It will allow slight re alignment of the laminate if required. This is not possible with contact adhesive.

In areas, such as the edges, where other adhesive is to be applied and the laminate heat formed onto the board the **TimbaTech010** will re-flow. This eliminates cracks or ridges in the formed edge. The water resistance of

TimbaTech010 is superior to that of conventional PVA's. The use of advanced technology has enabled water resistance to be increased without using a non re-flowable crosslinking resin. The viscosity of **TimbaTech010** has been optimised to allow the correct balance of hold out, spreadability and penetration into the board.

APPLICATIONS

TimbaTech010 may be applied by brush or glue spreader as supplied. If applied by spray equipment up to 10% water may be added for satisfactory atomisation.

Coverage rates are effected greatly by the type of board used. If MDF board is used a starting point of 100-200 gram/m² is recommended. Particleboard and HMR board can be used with **TimbaTech010**.

Application can be single sided to achieve the longest closed assembly time. If dual sided application is used the

TimbaTech010 can be allowed to flash off for up to 5 minutes (@25°C) prior to bringing the two faces together. This technique will substantially shorten the cure time.

The use of heated rollers or a hot press will speed the dry. A schedule of 90-120 seconds at 70-90°C is a typical cure cycle for **TimbaTech010**.

This can be varied to suit through put requirements and ambient conditions however use of temperatures in excess of 100°C need to be checked to ensure there is no boiling of the water in the adhesive.

Clean up before the adhesive dries. This can be done effectively with a damp cloth.

SURFACE PREPARATION

Calibrate the board through a wide belt sander.

APPLICATIONS INSTRUCTIONS

TimbaTech010 can be used in static and flow through flat pressing applications.

Pressing times will vary depending on type of press, thickness and colour of the laminate.

Atmospheric conditions will also impact pressing times so tests should be carried out to establish press

temperatures and pressing time.

PROPERTIES

High Solids
Fast Dry
Re-flowable under heat
Good water resistance (superior to PVA)
Medium viscosity
Good Grab

PRECAUTIONS

Be careful not to blister the laminate by pressing too long or too hot.
Be mindful that dark coloured laminate absorbs heat more quickly than light coloured laminates.

CLEAN UP

Wipe excess glue from joints with clean wet cloth before glue has set.

STORAGE AND HANDLING

TimbaTech010 is stable for up to 12 months at 20°C unopened in sealed containers in warehouse conditions.

STORAGE LIFE

Typically 9 months at 25°C in the original sealed plastic container.

HEALTH AND SAFETY

Please refer to Material Safety Data Sheet available on our Website www.timbatechsolutions.com

OTHER TECHNICAL INFORMATION SPECIFIC TO THIS ADHESIVE

Adequate tests should be carried out on any new or unfamiliar applications to ensure this product is suitable for the specific task.

Samples are available free of charge to assist this procedure.

Material Safety Data Sheet available on request.

Disclaimer – The statements made herein are based on our experience gained to date. They are to be considered as information without obligation. Please test and establish for yourself our product's suitability for your particular purposes. No liability exceeding the value of our product can be derived from the foregoing statements. This also applies to the technical advisory service, which is rendered free of charge and without obligation