

**PRODUCT DATA SHEET**

# DECCOBOND 103

## Heat Lamination Glue

**PRODUCT NAME:** DECCOBOND 103 – Heat Lamination Glue

**PRODUCT DESCRIPTION:**

Deccobond 103 is a polymer based emulsion adhesive formulated for lamination, fast setting, good bond strength and free from any solvents. It cures on cold press, hot press, RF cure or thermal vacuum form.

**APPLICATION:**

Deccobond 103 is designed for laminating and overlaying of arborite, veneers or melamine laminates onto fibreboards, medium density boards, solid lumber or any wood work. Deccobond 103 can also be used to glue paper, fabric and wood

**PHYSICAL PROPERTIES:**

Appearance:	Off white emulsion
Solid:	51.0%
pH:	4.5 – 5.5
Odor:	Mild, None when dry
Viscosity:	4,000 – 4,500 cps (Brookfield RVF Spindle 4, 20rpm at 26° C)
Specific Gravity:	1.12
Flammability:	Non flammable
VOC:	2.0 g/L
LEED:	Compliant

**LEED Compliant**  
Water-based Tech



**PREPARATION:**

Deccobond 103 is supplied ready to use and do not require mixing

**USAGE:**

Surfaces to be glued must be clean and free from dust, grease or oils. If oil is present, it must be removed with solvent or thinner.

Assembly time: The assembly time varies and is dependent on the species of wood and moisture content. It is also affected by the room temperature, relative humidity, glue spread, etc. and can be determined by regular use.

Open assembly time:	10 - 15 degree C	25 to 35 min
	15 - 20 degree C	20 to 25 min
	20 - 25 degree C	15 to 20 min

Maximum assembly time can best be determined by a particular application and actual conditions.

Pressure: For maximum effects on lamination and overlaying, the following pressures are recommended.

Smooth surface:	30 - 60 psi
Medium surface:	60 - 90 psi
Rough surface:	90 - 120 psi

Excessive pressure on smooth surfaces may starve glue lines. Similarly, high pressure on hard wood may also starve glue lines if insufficient spread is provided.

**CLEANING:**

Brushes, rollers, glue guns & spreaders can be easily cleaned with water & sponge. Warm water cleans better. To prevent damage, keep application equipment in water after use for easier cleaning.

**STORAGE**

Deccobond 103 is stable. Stores well for at least 9 to 12 months at room temperature.

**KEEP FROM FREEZING:**

For Industrial & Professional Use

**PACKING:**

Pail, Drum, Tote

