

PRODUCT DATA SHEET

DECCOBOND 10

White Glue

PRODUCT NAME: DECCOBOND 10 – White Glue

PRODUCT DESCRIPTION:

Deccobond 10 is a polymer based emulsion adhesive formulated for modern gluing operation where fast setting time with good bond strength is required.

APPLICATION:

Deccobond 10 is suitable for wood work such as laminating, overlaying, edge gluing, assembly gluing, finger joining, panel and frame work, solid lumber and other wood work.

Deccobond 10 can be used to glue paper, fabric, foam to wood or foam to cardboard and other porous materials. It is suitable for both rigid and flexible foam where drying time is at least 15 to 20 minutes with setting time of at least one hour or more.

PHYSICAL PROPERTIES:

Appearance:	White emulsion
Solid:	54.5%
pH:	4 - 5
Odor:	Mild, None when dry
Viscosity:	2,800 – 3,800 cps (Brookfield RVF Spindle 4, 20rpm at 26° C)
Specific Gravity:	1.112
Flammability:	Non flammable
VOC:	1.1 g/L
LEED:	Compliant



PREPARATION:

Deccobond 10 is supplied ready to use and do not require mixing

USAGE:

The wood surfaces to be glued must be prepared to ensure good bonding. Surfaces to be glued must be cleaned and free from dust. Grease or oil, if present on the wood must be removed and surface cleaned with solvent or thinners. In case of resinous wood species, clean with alcohol rub or solvent and allow the surfaces to dry before gluing takes place. This will enhance the bonding strength.

It is important to check wood moisture content of the wood.

Minimum moisture content:	5%
Maximum moisture content:	15%
Ideal moisture content:	7 to 10%

Spread rate:	1.7 to 2.5 kg per 10sq.meter, with single glue line recommended. Allow sufficient spread to ensure a definite squeeze out when joint is pressed. Spread is dependent on nature of the surface and type of wood.
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:	As short as possible
Closed assembly time:	10 to 15 min. at 20 kg/100sq m. to 25kg/ 100 sq.m.
Pressure:	For good bonding and to ensure good surface contact, the following is recommended.

Smooth surface:	40 - 80 psi
Medium surface:	60 – 120 psi
Rough surface:	100 – 150 psi

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

Pressing time: Pressing time and pressure varies with species of wood, moisture content of wood, room temperature, relative humidity, surface preparation & etc. As a guide, the following re recommended:

8 degree C	30 to 35 min
15 degree C	15 to 20 min
20 degree C	10 to 15 min

Sanding: It is best to determine time from actual usage and conditions. In some species of softwood, it can be reduced to 10 to 12 min. at 25 degrees C. It is best to allow squeeze out to dry and harden and then sand to reduce gumming of sandpaper. Alternatively, remove squeeze out with adhesive spreader and allow to dry before sanding.

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

KEEP FROM FREEZING:

For Industrial & Professional Use

PACKING:

1-gal Bottle (4-Bottle/Case)

