9517

WATER BASED ADHESIVE

KEY FEATURES

- Conforms to D3 requirements of EN204
- Water resistant
- Multi-purpose

DESCRIPTION

9517 is a ready for use, fast setting; single part curing polyvinyl acetate based emulsion

RECOMMENDED USE

9517 is a multipurpose, water resistant adhesive, which conforms to the D3 requirements of EN204, it also meets the requirements of BS4071 Part 5 sustained load resistance.
9517 is suitable for general assembly and lamination on particleboard and MDF.

IMPORTANT

Before embarking on any work involving **9517** the safety data sheet should be carefully studied by those carrying out the work.

BONDING INSTRUCTIONS

Working conditions:	
Minimum Temperature for use	12°C
Ambient temperature (warehouse, wood, laminates, adhesive)	18 - 20°C
Humidity of wooden substrates	8 - 12%
Coating weight:	
Flat lamination, paper (single face coverage)	20 - 70g/m^2
Flat lamination, HPL, thick foils (single face coverage)	100-200g/m^2
Assembly (single face coverage)	150-200g/m^2
Assembly time:	4 - 8 min
Pressure:	
Wood on wood	2 - 5 bar (kgf/cm^2)
Laminates on wood	1 - 2 bar (kgf/cm^2)
Pressing time (minimum):	
Wood on wood at 20°C	10 - 15 min
Assemblies one face preheated	2 - 3 min
Laminates on wood at 20°C	20 - 30 min
Laminates on wood at 80°C	3 - 4 min
Stabilisation:	
Before machining	2 hours (minimum)
Complete setting of adhesive	at least 24 hours
D3 water resistance	at least 1 week

METHOD OF USE

SURFACE PREPARATION

- Substrates to be bonded should be perfectly clean, dry and free from dust and grease
- For laminations, surfaces should be homogeneous and flat
- Assemblies should be precise in order to avoid thick adhesive lines (0.2 - 0.3mm max.)
- Wood should be allowed to condition for several days in the workshop atmosphere (15 - 20°C) before bonding. Its relative humidity should be approx. 10 - 20%.

APPLICATION

- For lamination apply an even coat of adhesive to one of the substrates by roller coater, brush or spatula
- For assembly applications we recommend that both surfaces should be coated
- Coating weight depends on substrate, porosity, open time and ambient temperature.

General features

Flat lamination	100 - 240 g/m^2
Panelling, edge jointing	200 - 350 g/m^2
Other (e.g. mortice & tenon, tongue & groove)	coat both sides

ASSEMBLY

- The parts to be bonded should be brought together immediately after application whilst the adhesive is still wet
- The maximum open time depends on the substrate porosity, ambient temperature and coating weight. A guideline is given opposite.

PRESSING

- After assembly pressure should be maintained during the adhesive's initial setting period, using conventional pressing methods such as presses, vices, jigs, clamps or dead loads. Refer to values given opposite. This is not necessary for finger joints.
- Pressing time depends on such variables as ambient temperature and humidity, coating weight, porosity of substrates and dimensions of assemblies. Reference values are given opposite but a test specimen will allow this to be calculated.
- Pressing time can be reduced by heating one substrate to be bonded before pressing at room temperature. We recommend pre-heating of the surface (1 - 2 minutes at 80°C).

- Hot pressing should only be recommended for double sided flat lamination

GENERAL PRECAUTIONS

- Do not add anything to the adhesive to modify its properties
- Provided contact with iron is avoided the adhesive should not cause staining.
- After each use close the container tightly to avoid skin formation.
- Coating equipment and tools can be cleaned with warm water, before the adhesive has dried out.

TYPICAL CHARACTERISTICS	
Physical form	Viscous liquid
Colour	White
Viscosity Brookfield RVT 20rpm at 23°C **[mPa.s]**	Approx. 12000
Relative Density	Approx. 1.10

BSI STANDARDS

FM 01696
BS EN ISO 9001:2008

PACKAGING

Please refer to Customer Service Department for current pack sizes.

STORAGE

Store in original sealed containers between 5 – 30°C.
PROTECT FROM FROST
After prolonged storage stir well before use

SHELF LIFE

At least 12 months from date of manufacture, under the above conditions of storage.

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SMART HELP

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