

PRODUCT DATA SHEET

DECCOBOND 110

Carpenter's Glue

PRODUCT NAME: DECCOBOND 110

PRODUCT DESCRIPTION:

Deccobond 110 is a polymer based emulsion adhesive formulated for modern gluing operation where fast setting time with good bond strength is required.

APPLICATION:

Deccobond 110 is commonly referred to as Carpenter's Glue. It is designed for wood working, assembly, furniture construction, delicate fabrication work where speed is required in setting. It gives a setting time of 12 to 15 minutes at 20 degrees C, with a cure time of 24 hours. Deccobond 110 can also be used to glue paper, foam, cardboard, lamination, overlaying and for foam application where yellowish color is not a problem.

PHYSICAL PROPERTIES:

Appearance:	Yellowish emulsion
Solid:	53.5 – 55.5%
pH:	4.0 – 5.0
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 110 is supplied ready to use and do not require mixing

USAGE:

The wood surfaces to be glued must be prepared to ensure good bonding. It must be free from dust, grease or oil. If natural wood oil is present in some species of wood, clean it with alcohol rub or solvent and allow surface to dry before gluing takes place to ensure better bond. It is important and good practice to check wood moisture content.

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

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.

Sanding: 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 110 is stable. Stores well for at least 9 to 12 months at room temperature.

KEEP FROM FREEZING

For Industrial & Professional Use