

PRODUCT DATA SHEET

DECCOBOND 112

Kwik Set Hardwood Glue

PRODUCT NAME: DECCOBOND 112

PRODUCT DESCRIPTION:

Deccobond 112 is a pre-catalysed emulsion adhesive for wood gluing operation for fast setting time, with very good bond strength and is water resistant. It cures on cold press, hot press, RF cure or thermal vacuum form. Deccobond 112 meets or exceeds the NWWDA I.S.1.6-87 for Type 1 wood flush door adhesive.

APPLICATION:

Deccobond 112 is designed for rapid setting on hardwood, wood joints for doors, cabinet doors, windows & staircase, finger joints, laminated timber & block gluing, wood assembly work, edge bonding of veneers and wood edge to plywood, particle boards, NDF, masonite, door lamination & construction and etc.

PHYSICAL PROPERTIES:

Appearance:	White emulsion
Solid:	52.5%
pH:	4.5 – 5.0
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:	1.1 g/L
LEED:	Compliant

PREPARATION:

Deccobond 112 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.

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

KEEP FROM FREEZING

For Industrial & Professional Use