



DECCOBOND 103

Heat Lamination Glue

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.

PREPARATION & USAGE:

DECCOBOND 103 is supplied ready to use and do not require mixing. Surfaces to be glued must be clean and free from dust, grease or oils. If natural wood oil is present in some species of wood, clean it with alcohol rub or with solvent and allow the surface to dry before gluing takes place to ensure better bonding.

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

CLEAN UP:

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 of 20° C. Do not store next to heaters or very high temperatures of 65° C or more. **DECCOBOND 103** is packed in plastic or polyethylene containers. Do not store in unlined metal containers as there will be reactions between the adhesive and the unlined container resulting in dark stains and contaminants. **KEEP FROM FREEZING.**

LEED Credit:

DECCOBOND 103 may contribute to LEED certification projects based on the following categories.

LEED CREDIT

LEED (Version 3.0)	LEED Point
Regional Materials (MR Credit 5.0)	2
Low-Emitting Materials (IEQ Credit 4.1)	1

VOC Compliant:

SCAQMD Rule #1168 (South Coast Air Quality Management District)



PHYSICAL PROPERTIES

Type	White emulsion	Viscosity	4,000 – 4,500 cps
Appearance	White	Odor	Mild to None
Solids	51 %	Flammability	Non-flammable
Specific Gravity	1.12	VOC	2.0 g/L

PACKING INFORMATION

Size	Pail/Pallet
5 gallon pail	36
55 gallon drum	-
275 gallon tote	-



TENCO WESTECH POLYMERS INC.
160-6333 Graybar Road, Richmond, B.C.
Canada V6W 0C4 t 604-276-8538