



Since 1990

DECCOBOND 100

White Glue

DESCRIPTION:

DECCOBOND 100 is a polymer based emulsion adhesive formulated for modern gluing operation where fast setting time with good bond strength is required.

APPLICATION:

DECCOBOND 100 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 100** 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.

PREPARATION & USAGE:

DECCOBOND 100 is supplied ready to use and do not require mixing. 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 stave 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.

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 100 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 100** 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 100 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	2,800 – 3,800 cps
Appearance	White	Odor	Mild to None
Solids	53.5–55.5 %	Flammability	Non-flammable
Specific Gravity	1.112	VOC	1.1 g/L

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



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