



Since 1990

DECCOBOND 155

Hardwood Glue

DESCRIPTION:

DECCOBOND 155 is a single component pre-catalyzed emulsion adhesive formulated for fast setting, strong bond strength and is water resistant. Meets ANSI, Type I & II specifications.

APPLICATION:

DECCOBOND 155 is suitable for the following:

- a) Wood joints for doors, cabinet doors, windows & staircase
- b) Finger jointing
- c) Laminated timber & block gluing including spindle gluing.
- d) Wood assembly work
- e) Edge bonding of veneers and wood edge to plywood, particle boards, mdf, masonite & etc.

PREPARATION & USAGE:

DECCOBOND 155 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%

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:

0 to 10 mins

Closed assembly time:

0 to 25 mins.

Glue speed:

Approx. at 1.6 to 2.5 kg/10 sq m. for single glue line

DECCOBOND 155 emulsion develops high compressive strength at room temperature. It can develop a hardwood bond that yields 4800 psi tensile strength with 80% fiber tear on maple after 24 hours cure. This allows its use for demanding hardwood application.

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 155 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 155** 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 155 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)



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



PHYSICAL PROPERTIES			
Type	White emulsion	Viscosity	2,800 – 3,500 cps
Appearance	White	Odor	Mild to None
Solids	52.0 – 53.0 %	Flammability	Non-flammable
Specific Gravity	1.08	VOC	4.0 g/L



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

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