

VN110

CROSS-LINKED PVA GLUE

Technical Data Sheet

TECHNICAL INFORMATION

VN110 is a one part cross-linking PVA which has been designed for veneering and HPL laminating. The bond complies with the requirements of BS EN204, Class D3, producing bonds which are resistant to immersion in cold water for a number of days. When dry, VN110 produces a hard translucent film, with good high temperature creep resistance.

This wood adhesive may be used for assembly work, dowelling, finger jointing, door assembly, edge lipping (with Radio Frequency Drying), veneering with wood or high pressure laminate, etc. It can be applied by roller, hand pressure gun, squeeze bottle or brush.

TYPICAL PROPERTIES

Solid content (3 h @ 120°C)	50%
Viscosity @ 20°C	110 Poise
pH	3.0
Storage life @ 10-25°C	12 months (protect from freezing)
Diluent	Water

GLUE PROCEDURES

- 1 Timber Moisture Content:** Timber moisture content can be between 5% and 15% but, as with all PVA adhesives, the lower the moisture content the faster the glue will set.
- 2 Glue Spread:** 100-125 g/m² (2-2.5 lb/100 ft²) single glue line. The correct spread is indicated by a slight squeeze-out at the glue line edge.
- 3 Closed Assembly Time:** Maximum 25 minutes. Assembly times should be minimised at low moisture content, high air temperatures and low spread rates.
- 4 All PVA adhesives set by loss of water from the glue line.** The rate at which moisture is lost and hence the rate at which it sets is determined by the wood moisture content, the spread rate and ambient conditions of humidity and temperature. As a guide, a strong, handleable bond should have formed within 30 minutes at room temperature (20°C).
- 5 The adhesive can be used for both hot and cold pressing applications,** with either veneer or laminate as a surface cover. It will yield a handleable bond after 30 seconds pressing at a platen temperature of 90°C through either veneer or High Pressure Laminate.

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- Pressure:** 350-1200 kN/m² (3.5-12.0 kgf/cm², 50-175 lbf/in²) on the joint. This assists in achieving good contact between the surfaces and thin glue lines, which give the fastest setting time.
- Seasoning:** At least two weeks should elapse for full water resistance to develop. Bonded joints should be stored at a temperature of at least 15°C.

RADIO FREQUENCY HEATING

This grade is ideal for use with RF equipment.

CLEAN DOWN

Warm water, with a little detergent added is recommended. Care should be taken to avoid drying out on equipment as the water resistance makes cleaning difficult.

HEALTH AND SAFETY

Please read the relevant Material Safety Data Sheet CAREFULLY.

The above figures are typical of this product and should not be taken as an agreed specification.

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