

PRODUCT DATA

Date: July 2013

Information Sheet No.: TDS01421-01

RESIN 168

WATER BASED ADHESIVE

RESIN 168 is a ready for use, fast setting, high solids; freeze/thaw stable polyvinyl acetate based emulsion, which conforms to the requirements of BS4071.

RECOMMENDED USE

RESIN 168 is a general purpose adhesive suitable for wood to wood jointing by mortice & tenon, dowelled, plain or bevelled lap joints, etc. It is also suitable for bonding aluminium or PVC edge trims; wood veneers and decorated laminated plastics to wood, MDF or chipboard

RESIN 168 dries opaque and can be used on all hard and softwoods including oily teak. The resultant bond is generally stronger than the wood itself.

BONDING INSTRUCTIONS

Working conditions:

Minimum temperature for use	12°C
Ambient temperature (warehouse, wood, laminates, adhesive)	18 - 20°C
Humidity of wooden substrates	8 - 12%

Assembly time:

10 - 25 min

Pressure:

Wood on wood	2 - 5 bar (kgf/cm ²)
Laminates on wood	1 - 2 bar (kgf/cm ²)

Pressing time (minimum):

Wood on wood at 20°C	60 minutes
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Stabilisation:

Before machining	4 hours (minimum)
Complete setting of adhesive	at least 24 hours

SURFACE PREPARATION

- Substrates to be bonded should be perfectly clean, dry and free from dust and grease.
- Certain hard woods having a natural oil content should be wiped before bonding with a cloth moistened with a solvent such as cleaner 5.
- For laminations, surfaces should be homogeneous and flat.
- Assemblies should be precise in order to avoid thick adhesive lines (0.2 - 0.3mm max.).
- Wood should be allowed to condition for several days in the workshop atmosphere (15 - 20°C) before bonding. Its relative humidity should be approx. 10 - 20%.

APPLICATION

- For lamination apply an even coat of adhesive to one of the substrates by roller coater, brush or spatula.
- For assembly applications we recommend that both surfaces should be coated.
- When bonding dowels or tenons it is preferable to apply the adhesive to the hole or mortice, so that wet adhesive is carried into the socket when assembly takes place.
- Coating weight depends on substrate, porosity, open time and ambient temperature.

ASSEMBLY

See final page for disclaimer.

Bostik Limited, Ulverscroft Road, Leicester, LE4 6BW England. Tel: +44 (0)1785 272625 Fax: +44 (0)1785 272867

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- The parts to be bonded should be brought together immediately after application whilst the adhesive is still wet.
- The maximum open time depends on the substrate porosity, ambient temperature and coating weight. A guideline is given on page 1.

PRESSING

- After assembly pressure should be maintained during the adhesive's initial setting period, using conventional pressing methods such as presses, vices, jigs clamps or dead loads. Refer to the pressure values given on page 1.
- Pressing time depends on such variables as ambient temperature and humidity, coating weight, porosity of substrates and dimensions of assemblies. A test specimen will allow press times to be calculated.
- Pressing time can be reduced by heating one substrate to be bonded before pressing at room temperature. We recommend pre-heating of the surface (1 - 2 minutes at 80°C).
- Hot pressing should only be recommended for double sided flat lamination.

GENERAL PRECAUTIONS

- Do not add anything to the adhesive to modify its properties
- Provided contact with iron is avoided the adhesive should not cause staining.
- After each use close the container tightly to avoid skin formation.
- Coating equipment and tools can be cleaned with warm (35 - 40°C) water, before the adhesive has dried out.
- For health, safety and disposal please refer to the material safety data sheet.

TYPICAL CHARACTERISTICS

Physical Form:	Liquid
Colour:	White
Viscosity (Brookfield RVT, 20rpm, at 23°C):	Approx. 12000mPas
Specific Gravity:	Approx. 1.17

PACKAGING

For Current pack sizes please contact the Customer Service Department

STORAGE

Store in original packaging between 5 and 30°C.

Protect from frost.

After prolonged storage stir well before use.

SHELF LIFE

Under the above storage conditions, 12 months closed in its original packaging.

MATERIAL SAFETY DATA

For further information refer to the relevant Health and Safety Data Sheet.

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