

TECHNICAL DATA SHEET

WATER BASED PRODUCT: AP65DBL

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Product Description

AP65DBL is a low viscosity polyvinyl acetate (PVAc) based adhesive, developed for use on automatic dowelling machines using high pressure application pumps such as Koch, Morbidelli, Biessie and Nottmeyer. It conforms to EN204/205 standard group D2.

Technical Data

Colour:	White
Viscosity:	100-200 \pm 50 mPa.s (Brookfield @20°C, 20 rpm)
Solids content:	36 \pm 1%
pH:	4-5
TMF:	6°C

Conditions of use

Temperature of room, materials to be bonded and adhesive:	18-20°C
Humidity of wood:	8-12%

Application

AP65DBL is ready for use but should be stirred before filling the pressure tank of the dowelling machine.

The dowelling machines, and in particular the pressure of the glue pumps should be adjusted according to the manufactures recommendations.

Tests should be done to determine the correct pressure and application conditions.

Generally, the pressure of the glue tank should be in the region of 3 Bar (44 PSI) and a pressure transmission of 1:30 to 1:40.

After short interruptions in work the glue nozzles should be cleaned with a damp cloth to prevent blocking.

The viscosity of AP65DBL may change during the day due to ambient temperatures. In this case the machines should be adjusted accordingly, particularly the pressure of the pumps.

The pressing time is greatly influenced by the ambient conditions, types of wood, amount of adhesive spread and the structure of the materials to be bonded.

Dowels

Wooden dowels should be grooved and be of a good quality with a tolerance of \pm 0.2mm in diameter and \pm 1mm in length. Moisture content should be a maximum 10%.

Differences in size will cause prolonged setting times and reduce bond strength. If using plastic dowels tests should be carried out to determine suitability as they differ from wooden dowels which swell to develop initial strength.

Important:

As most requirements are unique, it is most important that trials are carried out in order that the user satisfies themselves that the adhesive is suitable. The information given on this sheet is for guidance only and does not represent a specification.

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Suggestions for use

Bonding must be carried out at temperatures above the minimum film forming temperature (TMF). We suggest this should be at least 5 – 8°C higher.

Avoid the addition of flour and other substances which could affect the adhesive performance.

During the hot season, the viscosity of the adhesive could increase, during time. If this is the case, 1-3% water should be enough to bring the viscosity to the original value.

Cleaning

Clean all working tools and equipment immediately after use with water.

Storage and Shelf Life

The adhesive should be stored in a cool, dry area at temperatures between 15°C and 25°C. Under these conditions the product has a shelf life of 12 months when stored in the original, unopened container.

DO NOT ALLOW THE PRODUCT TO FREEZE

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