



# Wood Adhesives

## TEMPO XYLOVIL PRESS

### Technical Data Sheet

Reviewed: 06.06.2015



#### DESCRIPTION

**TEMPO XYLOVIL PRESS** is a high quality PVAC dispersion wood adhesive formulated for bonding veneers with the use of cold press. It offers a rapid and high strength bonding as well as temperature and humidity resistance. Dries in a transparent and tough film. It is suitable for indoor applications.

#### ADVANTAGES

- Excellent bonding strength with the use of cold press
- Humidity and temperature resistance
- Dries transparent
- Prevents bleed - through on open grained and unbacked wood veneers
- Environmentally friendly

#### APPLICATIONS

Large scale bonding of veneers to MDF, chipboard, particleboard, plywood and solid wood.

#### INSTRUCTIONS FOR USE

1. All surfaces must be dry and clean from dust and grease and fit closely together.
2. Stir adhesive thoroughly before use.
3. Apply the adhesive with a brush, roller, spatula or mechanical spreader.
4. Apply an even film of adhesive to one surface only.
5. Do not allow the adhesive to "soak" on the surface for more than 15 minutes in order to avoid skin formation.
6. Assemble the two parts whilst adhesive is still wet and apply light pressure.
7. In the case of large surface areas the use of cold press is recommended. On small surfaces the use of clamps is recommended paying particular attention that the pressure is evenly applied over the entire surface.

It is advisable to perform a suitability test prior to full scale application.

#### REMARKS

- Do not use below 12°C and relative humidity >60%
- Ideal moisture content of the wood: 8 - 12%
- Significant irregularities reduce the contact surface and therefore will lead to unsatisfactory bonding results.

#### CLEANING

Clean excess adhesive and equipment immediately after use with water.

#### COVERAGE

125 – 250gr/m<sup>2</sup>

#### TECHNICAL CHARACTERISTICS

**Consistency:** Thick paste

**Colour:** White

**Dry film:** Transparent - crystalline

**Odour:** Slight, characteristic

**Solids:** 50 ± 1%

**Specific gravity:** 1000 - 1050kg/m<sup>3</sup> 25°C

**Viscosity:** 35000 - 55000 mpas 25°C BROOKFIELD

**Minimum Film Forming Temperature (MFFT):** +5°C

**PH:** 4-6

**Open time:** 15-20 minutes at temperature 18°C - 20°C

**Initial bonding:** 30 minutes 20°C

**Clamping time:**

Depends on the ambient temperature and humidity as well as that of the surfaces to be bonded. We suggest, indicatively, the following times for one side application and wood humidity 10%:

At 20°C: 15-30 minutes

At 50°C: 8-15 minutes

At 80°C: 3-8 minutes

**Final bonding:** Subsequent processing of the bonded parts is possible after 3-5 hours. Final strength is achieved after approximately 24 hours at 20°C.

**Application temperature:** 10°C - 35°C

#### STORAGE

Products should be stored in a dry and cool place at a temperature of 5°C -35°C, away from sources of ignition. Protect from humidity and direct sunlight.

#### SHELF LIFE

12 months from the production date in the above mentioned storage conditions. The product should remain in the original unopened packaging bearing the manufacturer's batch number.

#### PACKAGING

**Plastic containers:** 5kg and 32kg

PACKAGING	CODE	BARCODE
Plastic container 5Kg	70303	5204094011026
Plastic container 32Kg	70306	5204094011033

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#### HEALTH & SAFETY INFORMATION

**EUH208:** Contains Mixture of: 5-chloro-2-methyl-4-isothiazolin-3-one [EC no. 247-500-7] and 2-methyl-2H -isothiazol-3-one[EC no. 220-239-6] (3:1). May produce an allergic reaction **EUH210:** Safety data sheet available on request.

The directives contained in this technical data sheet are the result of our long experience from real life applications and the research testing of our research and development laboratory and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications, which are beyond our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. We are liable only for our products for being free from faults and of consistent quality. Users are responsible for complying with local legislation and for obtaining any required approvals or authorizations. The present edition of this technical datasheet automatically cancels any previous ones concerning the same product.



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