



Assembly High Tack

PRODUCT DESCRIPTION

Assembly High Tack is an extremely fast-setting, high-quality aliphatic resin emulsion adhesive. It dries very rapidly to give a short clamp time and has high solvent-resistance. Assembly High Tack is excellent for general assembly as well as edge and face gluing of hardwoods and softwoods.

PHYSICAL PROPERTIES ¹

Chemical Family Description: Aliphatic resin emulsion adhesive

Appearance: Cream colored liquid

Freeze/Thaw Stable²: No

Specific Gravity: 1.11

Typical Viscosity (cps): 3000-3500

Weight Solids (%): 45-47

pH: 4.0-4.5

Suggested Minimum Use Temperature³: 10°C

APPLICATION GUIDELINES

Moisture Content: Six to eight percent is the recommended moisture content for the gluing stock. High moisture content will dramatically increase the clamp time needed. Additionally, panel shrinkage may occur resulting in stress cracks or end joint delamination.

Stock Preparation: The preparation of the stock to be glued is extremely important. Joints cut from rip saws should be free of saw marks. They should also be straight and square. Moulded or jointed stock should be free of knife marks. Glazed or burnished joints will prevent adhesive penetration and should be guarded against. When possible, glue joints should be prepared and glued the same day.

Spread: Generally, 140-245 g/m² of glue line is adequate. Conveyorized spreaders are commonly used in edge-gluing applications. The use of a wool felt sleeve on the spreader roll can aid in obtaining a desirable spread and reducing excess glue usage.

Assembly Time: Assembly time can vary greatly depending on the quantity of adhesive used, glue spread, porosity and moisture content of the gluing stock, environmental conditions, etc. Generally accepted assembly times range from 2-10 minutes.

Pressure: Pressure is dependent upon the species or material to be glued and joint preparation. Direct contact of the gluing surfaces must be made to obtain maximum strength. Suggested pressures for various wood densities are: low 7.0-10.5 Kg/cm²; medium 8.8-12.3 Kg/cm²; high 12.3-17.6 Kg/cm². Clamps for edge gluing should be spaced 20-40 cm apart and 5 cm from the end of the panel to evenly distribute pressure along the entire length of the glue line.

Clamp Time: Clamp time is dependent on the species and moisture content of the stock, environmental factors and glue line thickness. Clamp times can range from a few minutes in some assembly gluing to more than an hour depending on the above factors. Clamp times should be determined under plant conditions.

Additional Conditioning. An overnight conditioning period is recommended prior to machining. A conditioning period of 3-4 days may be required to eliminate "sunken glue joints" caused by residual moisture in the glue line.



PERFORMANCE PROPERTIES

Block Shear Strength⁴:

	lb/in ²	wood failure%
25°C	3,600	77
65°C Overnight	1,600	10

Room Temperature Speed of Set⁵: 1.37 (Very Fast)

RELATED PRODUCTS

Assembly High Tack is a unique general-purpose adhesive that is suitable for a wide range of wood-to-wood interior applications. If another type of adhesive is needed for general assembly applications, Woodbond 285, Assembly 65, or Titebond 55T are also recommended. Please refer to our Assembly or ReactITE[®] products for additional information. For edge and face gluing, see our Titebond[®] products. If a water-resistance adhesive is desired, Multibond[®] EZ-1 should be considered. Special Note: Franklin offers many of our assembly glues with fluorescent dyes. Please contact us for additional information.

HANDLING AND STORAGE

Store in tightly closed original container. Protect from freezing. Storing at temperatures above 25°C will reduce the maximum storage time. If thickening, separation or settling occurs, the adhesive should be thoroughly mixed and will then be ready to use again.

Protect adhesive from freezing. If product has been frozen, contact Franklin Customer Service for instructions.

¹ All numerical values represent typical properties.

² If product has been frozen, contact Technical Service for instructions.

³ Measured by Franklin's film formation test. Gluing conditions will affect minimum use temperature.

⁴ Performed according to ASTM D-905 on hard maple.

⁵ Measured by Franklin's torsion speed of set tester on hard maple @ 3 minutes clamp time. The higher the value, the faster the speed of set.

Important Notice to Purchaser: Our recommendations, if any, for use of this product are based on tests believed to be reliable. The greatest care is exercised in the selection of our materials and in our manufacturing operations. However, we make no recommendation to use this product in any manner which conflicts with existing laws and/or patents and WE MAKE NO WARRANTIES, EXPRESS OR IMPLIED, REGARDING THIS PRODUCT OR ITS USE, INCLUDING MERCHANTABILITY AND FITNESS FOR PARTICULAR PURPOSE, THE MANUFACTURER IS NOT LIABLE FOR ANY CONSEQUENTIAL, INCIDENTAL OR SPECIAL DAMAGES OF ANY KIND. Revised 09/28/05

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