



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

Chemical Family Description: Aliphatic resin emulsion adhesive **Typical Viscosity (cps):** 3,000-3,500

Appearance: Cream colored liquid

Suggested Minimum Use Temperature: 50 °F

Freeze/Thaw Stable: No

Per Gallon (Weight lbs.): 9.15

pH: 3.7-4.5

Weight Solids (%): 45.0-47.0

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, 35-50 pounds per 1,000 square feet of glue line (6-9 wet mils or 180-260 ft²/gal) is adequate. Conveyorized spreaders are commonly used in this application. 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 edge and face gluing of various wood densities are: low 100-150 psi; medium 125-175 psi; high 175-250 psi. Direct contact of gluing surfaces are important in assembly gluing as well.

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.



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PERFORMANCE PROPERTIES

Block Shear Strength:

	Psi	wood failure%
Room Temperature	3,600	77
150°F Overnight	1,600	10

Room Temperature Speed of Set: 1.37 (Very Fast)

STORAGE AND HANDLING

Shelf life: 12 months at 70° F. Store in closed containers.

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

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 07/30/08.

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