



TECHNICAL DATASHEET

DANAFIX**Wood adhesive for PVC foils****Product:**
D-coll 5020**Date of issue:** 13.09.2013
(Replaces: 28.12.2011)**Company** DANA LIM A/S
Københavnsvej 220, DK-4600 KøgePh.: 56 64 00 70, Fax.: 56 64 00 90, www.danalim.dk
Technical Service Ph.: 56 64 00 75**Prepared by:** Laboratory, Kristian K. Pedersen**Product Description and Application:**

D-coll 5020 is an adhesive for gluing of PVC foils on e.g. gypsum, chipboard and wood fibre boards. The adhesive is also suitable for lamination of textile on PVC e.g. in production of lampshade. The adhesive has good heat resistance and is suitable for industrial series production.

Article numbers:

20 kg bucket:.....	6050524
120 kg drum:.....	ZVF5020F120

Physical / Chemical Properties:**Adhesive:****5020**

Type:.....	Waterbased VAE copolymer
Colour:.....	White
Solis content [%]:.....	55
Viscosity (Brookf. RVF, 20 rpm) [cP]:.....	8.500
Density [kg/ltr.]:.....	1,1
pH:.....	5 – 7
Shelf life:.....	Minimum 12 month in unopened packing if stored cold.

Cured adhesive:

Colour:.....	Matt transparent
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Directions for use:

Preparation:	Both surfaces must be clean, dry and well adjusted. Optimum results are obtained with newly worked wood.
Application:	The adhesive is applied on one surface by roller, nozzle or brush in an even layer. Thin and even application gives fewer tendencies for wood chips to grow. Directly after the adhesive application are the top layer placed. After pressing in e.g. a roller press the boards are stacked.
Wood moisture content:	8 - 10 %.
Amount of glue:	50-100 g/m ² depending on the surfaces and required open time.
Open assembly time: 20 °C, 50 % RH pine, 9 % moisture	6-10 min. Absorbent materials, less amount of glue, low moisture content in material and air and ventilation will influence the open time.
Pressure times: pine approx. 50 % RH, approx. 9 % moisture content of the wood	App. 1 min at 20°C with a following resting period. Pressure times should be increased for hard woods, two-sided application, high humidity of the air and higher moisture content of the wood. Fully strength is obtained after 24 hr.
Cleaning:	Wet uncured adhesive can be removed with water. Cured adhesive can only be removed by soaking in lukewarm water or with the use of organic solvents (ex. acetone).
Storage:	Adhesive should be stored cool (max. 20 °C) in tightly closed packing. Must be protected from frost.

All information's are meant as a guideline. Sufficient test should be carried out to determine final working condition.

Safety:

Hazard Symbols: None
Risk and Safety phrases: None

For further information concerning safety, refer to safety Datasheet.

Further information:

DANA LIM offers a range of adhesives for professionals:

100-series: Upholstering adhesives
200-series: Flooring adhesives
300-series: Wall adhesives
400-series: Wood adhesives
500-series: Sealants & PU-foams
600-series: Building-additives, fillers etc.
700-series: Paper-, packaging- and newspaper adhesives
800-series: Hot melt
900-series: Cleaning-, release agents and hardeners.

The information and data contained in this data sheet are based on extensive laboratory testing and our practical experiences, and are meant for helping the user to find optimum working methods. As the conditions at the user are beyond our control, we make no warranties concerning the results, achieved by the products. The information's in this technical data sheet are typical values, intended as a guideline. They should not be regarded as product specifications. Please also refer to our standard sales conditions and terms of delivery.