



# TECHNICAL DATASHEET

Production of laminated wood for furniture

**DANAFIX**

**Product name:**

**DANAFIX 495**  
**DANAFIX 496**  
**DANAFIX 497**

**DANAFIX 498**  
**DANAFIX 499**

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## Product description and application:

The DANAFIX 490-series has been developed especially for industrial production of laminated wood for furniture. DANAFIX 495, 496 and 499 have very short pressing time, and can be used for most wood types. They are suitable for continuous production units with automatic application of adhesive, where a very short pressing time is required. DANAFIX 497 and 498 have been especially developed for manual application, as they have longer open assembly time and pressing time. DANAFIX 497 and 498 are used for soft woods.

### Application:

#### Application / assembling:

	495	496	497	498	499
Manual:.....	●	●	●	●	●
Automatic (UV-trace substance)	●	●			●

#### Press:

Cold press:.....	●	●	●	●	●
Warm press:.....	●	●	●	●	●
High frequency:.....	●	●	●	●	●

#### Types of wood:

Soft (ex. pine):.....	●	●	●	●	●
Hard (ex. beech, oak, teak):.....	●	●	●	●	●
MDF:.....	●	●	●	●	●
Chipboard:.....	●	●	●	●	●

#### Treatment:

Lye:.....	●	●	●	●	●
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#### Other application areas:

Dowel / Tenon joint – manuel:.....	●	●	●	●	●
Finger joint:.....	●	●	●	●	●
Edge bonding - wood/wood:.....	●	●	●	●	●
Surface bonding:.....	●	●	●	●	●

#### Article Numbers:

5 l bucket:.....	-	7132	6493	2023	-
20 l bucket:.....	6458	7136	6489	2026	6582
125 l drum:.....	-	7137	6496	2027	6576
1000 l container:.....	-	7139	6497	-	6580

## Physical / chemical properties:

### Adhesive:

	495	496	497	498	499
Type:.....	Water based PVAc-dispersion				
Color:.....	White				
Solid content:.....	56 %	56 %	47 %	48 %	57 %
Viscosity (Brookf. RVF, 20 rpm):.....	8500 cP	13000 cP	12000 cP	17000 cP	20000 cP
Specific gravity:.....	1.2 kg/ltr				
pH:.....	5-7	5-7	4-6	5-7	5-6
Shelf life:.....	Minimum 12 months in unopened packing if stored cool.				
Glue line:					
Color:.....	Mat transparent				
Temperature resistance:.....	app. -20°C to +70 °C (the adhesive is thermoplastic, and becomes soft at rising temperature)				

## 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. When bonding hard woods, two-sided application is recommended, as well as increasing assembly time and pressing time.

**Wood moisture content:** 7 - 10 %

**Amount of glue:** 100 - 200 g/m<sup>2</sup>

**Application temperature:**

495	496	497	498	499
15 - 80 °C	15 - 80 °C	15 - 80 °C	15 - 80 °C	15 - 60 °C

**Open assembly time:**

20 °C, 50 % RH  
pine, 9 % moisture

7-9 min.	4-6 min.	10-11 min.	5 - 7 min.	4 - 5 min.
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If assembly time is "closed", it can be increased 1 - 2 minutes. Assembly time is increased with two-sided application, hard wood, lower temperature and higher humidity of air and wood. Assembly time is reduced at higher temperatures and lower humidity of air and wood.

**Pressure:** Lamination pressure (side press): 8-10 kg/cm<sup>2</sup> (soft wood) and 13-15 kg/cm<sup>2</sup> (hard wood)  
Top pressure: 1-1.2 kg/cm<sup>2</sup>. In case of tensions in the wood a higher pressure should be applied.

**Pressure times, pine approx. 50 % RH, approx. 9 % moisture content of the wood (for lamella sizes 15 mm / 43 mm):**

20 °C	8 / 12 mins	8 / 12 mins	30 / 40 mins	15 / 20 mins	7 / 12 mins
40 °C	6 / 10 mins	6 / 10 mins	20 / 30 mins	10 / 15 mins	5 / 9 mins
60 °C	4 / 6 mins	4 / 6 mins	10 / 20 mins	5 / 10 mins	2,5 / 5 mins
80 °C	3 / 5 mins	3 / 5 mins	5 / 10 mins	3 / 5 mins	-

Pressure times should be increased for hard woods, two-sided application, higher humidity of the air and higher moisture content of the wood. Full strength is usually obtained after 24 hours.

**Cleaning:** Wet adhesive can be removed with water. Dried 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 stated times are meant as a guideline. Sufficient tests should be carried out to establish final working conditions.**

## Safety:

**Hazard symbols:** None

**Risk & 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

**In the 400-series Wood adhesives DANA LIM offers:**

400-series: Special adhesives

410-series: Adhesives for edge-bonding (Cold-Activating)

430-series: Moisture resistant D3-adhesives

440-series: Moisture resistant D4-adhesives

450-series: Urea-formaldehyde adhesives

460-series: Adhesives for dowel-, tenon and finger joints

470-series: Adhesives for foiling of PVC, metals etc.

480-series: Adhesives for lacquered wood

**490-series: Adhesives for production of laminated wood for furniture**

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.