



# TECHNICAL DATASHEET

# DANAFIX

## Foiling with PVC foils

**Product:**  
**D-coll 5680**

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### Product Description and Application:

D-coll 5680 is a water based VAE dispersion adhesive excellent for gluing of wood, PVC foils, textiles, metal and foamed plastic.

The adhesive has especially good adherence to non-polar surfaces, fast setting, and provides a very strong bonding, therefore it is suitable for edge bonding.

D-coll 5680 is also suitable for the upholstery industry, foil on metal, textile on metal, textile on wood, carpet tile on various materials, wall covering, etc. however we recommend you to test the product before starting production.

The adhesive has high heat resistance and low water resistance.

All the raw materials in D-coll 5680 comply with the requirement for XIV "polymer dispersions" according to "the Federal Institute Health Protection of Consumers and Veterinary Medicine BGVV" of 1st October 1998.

**Article number:**

20 kg bucket: .....

### Physical / Chemical Properties:

<b>Lim:</b>	<b>5680</b>
Type:.....	Waterbased VAE copolymer
Colour:.....	White
Solid content [%]:.....	60
Viscosity (Brookf. RVF, 20 rpm) [cP]:.....	6000 - 8000
Vægtfylde [kg/ltr.]:.....	1,1
pH:.....	4 - 6
Shelf life:.....	Minimum 12 months in unopened package if stored cold.

**Glue joints:**

Colour:.....

## Directions for use:

<b>Preparation:</b>	<i>All surfaces must clean and dry, free from oil, grease, release agents, dust and loose particles.</i>
<b>Application:</b>	<i>The adhesive is applied on one surface by roller, nozzle or brush in an even layer. Directly after the adhesive application are the top layer placed. After pressing in e.g. a roller press the boards are stacked.</i>
<b>Amount of glue:</b>	<i>100-200 g/m<sup>2</sup> depending on the surfaces and required open time.</i>
<b>Pressing time:</b>	<i>App. 2 min at 20 °C.</i>
<b>Open assembly time:</b>	<i>5-12 min.</i>
<b>Pressure:</b>	<i>0,2-0,6 MPa (2-6 kp/cm<sup>2</sup>)</i>  <i>Absorbent materials, less amount of glue, low moisture content in material and air and ventilation will influence the open time.</i>
<b>Cleaning:</b>	<i>Wet adhesive can be removed with water. Dry adhesive can only be removed by soaking in lukewarm water or with the use of organic solvents (ex. acetone).</i>
<b>Storage:</b>	<i>Adhesive should be stored cool (max. 20 °C) in tightly closed packing. Must be protected from frost.</i>

**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.*