



TECHNICAL DATASHEET

DANAFIX*Adhesive for coated paper/cardboard***Product:****DANAFIX 740****DANAFIX 744****DANAFIX 745****DANAFIX 746****DANAFIX 747****DANAFIX 749****Date of issue:** 28.08.2015

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Prepared by: Kristian K. Pedersen**Product Description and Application:**

DANAFIX 740-series has been developed for bonding difficult surfaces. All components in the adhesives meet the demands in FDA section 21, CFR 175.105 or BGVV for use in the food industry.

DANAFIX 740, 747 and 749 are adhesives which are used for bonding paper on materials as PE- and PP-foil. The adhesives are transparent when dry and give strong and flexible joints. DANAFIX 740 and 747 are easy to clean.

DANAFIX 744 and 745 are adhesives with short setting time. The adhesives are used for bonding paper against treated surfaces like PE-coated (<15 g/m²) or varnished.

DANAFIX 746 is an adhesive for bonding non-porous material against porous material. The adhesive has good adhesion to PVC-foil, aluminium-foil, leather, textiles or varnished surfaces.

Materials:

	740	744	745	746	747	749
Paper.....	●	●	●	●	●	●
Cardboard.....	●	●	●	●	●	●
Varnished surfaces.....	●	●	●	●	●	●
PE-coated surfaces.....	●	○	○	○	●	●
Waxed surfaces.....	●	●	●	●	●	●
Metal-foil.....	●	●	●	●	●	●
PE-, PP-foils.....	●				○	○
PVC.....	●	●	●	●	●	●
Textile.....	●	●	●	●	●	●
Leather.....	●	●	●	●	●	●

● : Recommended

○ : Test

Article numbers:

	740	744	745	746	747	749
20 kg bucket.....	8050	6909	7357	2248	-	-
1000 kg container.....	8052	6637	-	-	6177	7496

Physical / Chemical Properties:**Adhesive**

	740	744	745	746	747	749
Type:.....	Acrylic/ VAE	VAE				Acrylic/ VAE
Colour:.....	Beige	White				
Solid content [%]:.....	49-50%	57%	56%	56%	50%	60%
Viscosity [cP]:.....	3.500	5.400	3.000	10.600	1.700	7.000
Density [kg/ltr.]:.....	1,1					
pH:.....	4 - 6					
Shelf life:.....	Min. 12 months in unopened packaging if stored cool					

Glue joint:

Colour:.....	Transparent
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Directions for use:

Preparation:	<i>All surfaces must clean and dry, free from oil, grease, release agents, dust and loose particles.</i>
Dilution:	<i>The adhesive is delivered ready for use, but can if necessary be diluted with water.</i>
Application:	<i>The adhesive is applied onto one of the surfaces with brush, roller or nozzle in a thin layer. The two substrates are put together while the adhesive is still wet.</i>
Open time:	<i>The open time depends on temperature, humidity, applied amount of adhesive and the surface of the material.</i>
Cleaning:	<i>Adhesive can be removed with water. If the adhesive is dried use lukewarm water.</i>
Storage:	<i>Cool (max. 25 °C) in tightly closed packaging. 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:	<i>None</i>
Risk and Safety phrases:	<i>None</i>

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 700-series: Paper-, packaging- and newspaper adhesives offers:

700-series: Different special adhesives
710-series: Adhesives for paper with a long open time
730-series: Pressure sensitive adhesives
740-series: Gluing of difficult (ex. Waxed) surfaces
750-series: Gluing of lacquered surfaces
760-series: Bookbinder adhesives
770-series: Newspaper adhesives
780-series: Gluing of difficult surfaces (roller or nozzle application)
790-series: Gluing of untreated paper and cardboard

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.