



TECHNICAL DATASHEET

DANAFIX*Adhesive for varnished paper/cardboard***Products:**

DANAFIX 751-1000 DANAFIX 755
DANAFIX 751/2 DANAFIX 756
DANAFIX 753 DANAFIX 759
DANAFIX 754

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Product Description and Application:

The DANAFIX 750-serie is a range of adhesives, which has been developed for bonding coated, varnished and untreated paper and cardboard. Adhesives are transparent after dry and give strong and flexible joints.

DANAFIX 751/2, 753 and 754 are used for gluing varnished surfaces against paper and cardboard. The adhesives have a very fast bonding and strong wet tack. DANAFIX 751/2 and 758 are suitable for nozzle application. DANAFIX 754 is suitable for coating cylinder or roller.

DANAFIX 751-1000, 755, 756 and 759 are fast bonding adhesives used for gluing varnished surfaces against paper and cardboard. They are particular suitable for high speed machinery, where very fast bonding is preferred to reduce pressing time.

All components in the adhesives meet the demands in FDA section 21, CFR 175.105 or BGVV for use in the food industry.

Materials

	751-1000	751/2	753	754	755	756	759
Paper.....	●	●	●	●	●	●	●
Cardboard.....	●	●	●	●	●	●	●
Varnished surfaces.....	●	●	●	●	●	●	●
Metal foil.....	●	●	●	●	●	●	●
PVC.....	●	●	●	●	●	●	●
Textiles.....	●	●	●	●	●	●	●
Leather.....	●	●	●	●	●	●	●

Item no.

20 l bucket.....	-	-	2364	-	6210	-	2373
125 l drum.....	-	-	-	2407	-	6805	2375
1000 l container.....	2384	2390	2367	-	6212	-	-

Physical / Chemical Properties:

Adhesive:	751-1000	751/2	753	754	755	756	759
Type.....	Water based VAE copolymer dispersion						
Colour.....	White						
Solids content [%]:.....	58	49	46	61	52	50	53
Viscosity [cP]:.....	1.000	700	2.500	5.000	550	2.000	1.100
Density [kg/ltr]:.....	1,1						
pH:.....	4 – 5						
Shelf life:.....	Minimum 12 month in unopened packaging if stored cool.						

Cured 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 on one of the surfaces with brush, roller or nozzle in a thin layer. The two materials are put together while the adhesive is still wet.</i>
Open time:	<i>The applied amount of adhesive and the surfaces absorbency have great influence on the open time of the adhesive. If longer open time is needed – see DANAFIX 710-series or the DANAFIX 780-series.</i>
Drying time	<i>The adhesive is drying by water evaporation. Therefore temperature, the amount of adhesive and the surface absorbency are of great importance to the adhesive drying time. Shortly after application (1-5 sec) the adhesive has high enough wet tack to hold the materials assembled. Hereafter the objects may be stacked. Full hardening occurs after approximately ½ - 4 hours.</i>
Cleaning:	<i>Rolls, brushes, etc. are cleaned using hot water while the adhesive is still wet. Cured adhesive can be removed by soaking the objects in hot water, using ethanol or acetone.</i>
Storage:	<i>Cool (max. 25 °C) in tightly closed packaging. Must not be exposed to 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.

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.