



TECHNICAL DATASHEET

Special PVAc Adhesive

DANAFIX**Product:****DANAFIX 491****Date of issue:** 13.06.2018
(Replaces: new)**Company:** DANA LIM A/S, www.danalim.dk
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Technical Service Phone: +45 56 64 00 75**Prepared by:** Bo Brehmer**Product description and application:**

DANAFIX 491 is a special designed adhesive for the door production process where the low viscosity and long open time are required.

Application:

	DANAFIX 491
Manual:	•
Automatic:	•
Dowel-, tenon- and finger joints:	
Furniture:	•
Types of wood:	
Soft (ex. pine):	•
Hard (ex. beech, oak, teak):	•
MDF:	•
Chipboard:	•
Press:	
Cold:	•
Warm:	•
High frequency:	•
After treatment:	
Cutting tools:	Very low
Article Numbers:	
20 l bucket:	-
125 l drum:	-
1000 l container:	649110

Physical / chemical properties:

Adhesive:	DANAFIX 491
Type:	Water based PVAc-dispersion
Colour:	White
Solids content, approx.:	46%
Viscosity (Brookf. RVF, 20 rpm, 20°C): ..	1500 - 1800 mPa.s
Specific gravity:	App. 1.1 kg/ltr
pH:	4 - 6
Shelf life:	12 months in unopened package at 20°C
Glue joint:	
Colour:	Mat transparent
Temperature resistance	-20°C to 70°C

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.
Moisture content of wood:	7 - 10 % (joints for indoor application)
Amount of glue:	100 - 200 g/m ² , depending on application.
Minimum film forming temperature:	15 - 80 °C
Assembly time:	10 -12 minutes, pine, 20 °C, 50 % RH 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.
Closed assembly time:	Up to 15 min.
Pressure:	Side pressure: 8 – 10 kg/cm ² (soft wood) and 13 – 15 kg/cm ² (hard wood). Top pressure: 1 – 1.2 kg/cm ² . Tensions in the wood might require higher pressure.
Pressing time, pine app. 9% moisture, app. 50 % RH :	Min. 10 min. Pressing time should be increased for hard woods, two-sided application, higher humidity of the air and higher moisture content of the wood. Pressing times can be reduced by eg. pre-heating of the wood. Full strength is usually obtained after 24 hours.
Cleaning:	Wet adhesive can be removed with water. Dry adhesive can only be removed mechanically.
Storage:	Store in a cool place (5°C - 35 °C) and in a tightly closed package. Protect from freezing.
All stated times are meant as a guideline. Sufficient tests should be carried out to establish final working conditions.	

Safety:

Hazard symbols: None
Risk and safety phrases: None

For further information regarding to 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.