



# TECHNICAL DATASHEET

# DANAFIX

## Doweling adhesive for furniture manufacturing

**Product:****D-coll 2150****Date of issue:** 05.09.2018  
(Replaces:-)**Company** DANA LIM A/S  
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Technical Service Ph.: 56 64 00 75**Prepared by:** Bo Brehmer**Product Description and Application:***D-coll 2150 is a low viscosity PVAc based adhesive, and therefore mainly used in automatic application for doweling.***Article Number:**

20 l bucket:.....	ZVF2150SP20
120 l drum.....	ZVF2150F120

**Physical / Chemical Properties:****Adhesive:****D-coll 2150**

Type:.....	Water based PVAc-dispersion
Colour:.....	White
Solid content [%]:.....	38%
Viscosity (Brookf. RVF, 20 rpm) [cP]:.....	480 - 520
Density [kg/ltr.]:.....	1.1
pH:.....	4 - 6
Shelf life:.....	Minimum 12 months in unopened packing if stored cool.

**Cured joint:**

Colour:.....	Matt transparent
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## Directions for use:

<b>Preparation:</b>	<i>Both surfaces must be clean, dry and well adjusted. Optimum results are obtained with newly worked wood.</i>
<b>Application:</b>	<i>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.</i>
<b>Wood moisture content:</b>	<i>8 - 14 %</i>
<b>Amount of glue:</b>	<i>150-200 g/m<sup>2</sup> depending on the surfaces and required open time.</i>
<b>Application temperature:</b>	<i>10 -70 °C</i>
<b>Open assembly time:</b> <i>20 °C, 50 % RH pine, 9 % moisture</i>	<i>Up to 8 min. Absorbent materials, less amount of glue, low moisture content in material and air and ventilation will influence the open time.</i>
<b>Pressure:</b>	<i>Soft wood as e.g. conifer wood 0,6-0,8 MPa (6-8 kp/cm<sup>2</sup>) Hard wood as e.g. deciduous wood 1,0-1,2 MPa (10-12 kp/cm<sup>2</sup>)</i>
<b>Pressure times, pine approx. 50 % RH, approx. 9 % moisture content of the wood</b>	<i>App. 5-10 min. at 20° C with a following resting period before further processing. 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.</i>
<b>Cleaning:</b>	<i>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).</i>
<b>Storage:</b>	<i>Adhesive should be stored cool (5-35 °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.*