

Product:
DANAFIX 406 - Modified

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Product description and application:

DANAFIX 406 is water based PVAc adhesive special developed for gluing of ammonia treated oak and is especially suitable for hard woods. The adhesive can be used for the most veneering, lamination and jointing purposes in cold, warm and high frequency press and the application can be automatic or manual. The adhesive has a short setting time and is suitable for roller application.

Application:
Field of application:
DANAFIX 406

Furniture production:.....	<input checked="" type="checkbox"/>
Wood floor production:.....	<input checked="" type="checkbox"/>

Dowel-, tenon- og finger joints:

Furnitures:.....	<input checked="" type="checkbox"/>
Floors:.....	<input checked="" type="checkbox"/>

Types of wood:

Soft (ex. pine):.....	<input checked="" type="checkbox"/>
Hårde (ex. beech, oak, teak):.....	<input checked="" type="checkbox"/>
Ammonia treated oak:.....	<input checked="" type="checkbox"/>
MDF:.....	<input checked="" type="checkbox"/>
Chipboarde:.....	<input checked="" type="checkbox"/>

Press:

Cold:.....	<input checked="" type="checkbox"/>
Warm:.....	<input checked="" type="checkbox"/>
High frequency:.....	<input checked="" type="checkbox"/>

Subsequent processing:

Cutting tools (minimal wear):.....	<input checked="" type="checkbox"/>
Liming:.....	<input checked="" type="checkbox"/>

Article Number:

1000 l container:.....	7218
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Physical / chemical properties:
DANAFIX 406

Type:.....	Water based PVAc-dispersion
Colour:.....	Yellow
Solid contend:.....	44 %
Viscosity (Brookfield, 20 rpm):.....	1300 cP
Density:.....	1.1 kg/ltr
Shelf life, at cold storage:.....	Min. 6 months in unopened package

Directions for use:

Preparation: The surfaces for adhesive applying have to be well adjusted, clean and dry. Optimum result is obtained with newly processed wood.

Application: Joints: For high strength demanding joints, the adhesive is applied on both the dowel (or tongue), in the hole and the whole bonding surface. For less demanding joints, the adhesive can be applied only in the hole.

Surface bonding: 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: 8- 14 %

Adhesive consumption: 100- 200 g/m²

Application temperature: 5- 90 °C

Open assembly time, 20 °C, 6- 9 min

50 % RF pine:

If assembly time is "closed" the time 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.

Pressure: Lamination pressure (side pressure): 8- 10 kg/cm² (soft wood) and 13- 15 kg/cm² (hard wood).
Top pressure: 1- 1.2 kg/cm². In case of tensions in the wood a higher pressure should be applied.

Pressing times, pine app. 9
% moisture, app. 50 % RH:

	Lamella thickness 15 mm	Lamella thickness 43 mm
20 °C	4 mins	9 mins
40 °C	3 mins	6 mins
60 °C	2.5 mins	4.5 mins
90 °C	2 mins	4 mins

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 ex. pre-heating of the wood. Full strength is usually obtained after 24 hours.

Cleaning: Wet uncured adhesive can be removed with water.

Storage: Should be stored cold (max. 20 °C) in tightly closed package. Protected from frost.

All stated times are meant as a guideline. Sufficient tests should be carried out to establish final working conditions.

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.