



# TECHNICAL DATASHEET

# DANAFIX

## Wood adhesive

**Product:**  
**DANAFIX 407**

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**Company:** DANA LIM A/S, [www.danalim.dk](http://www.danalim.dk)  
Københavnsvej 220, DK-4600 Køge, Denmark

Phone.: +45 56 64 00 70, Fax: +45 56 64 00 90,  
Technical Service Phone.: +45 56 64 00 75

**Prepared by:** Kristian K. Pedersen

### Product description and application:

DANAFIX 407 is water based PVAc adhesive special developed for veneering. Furthermore, the adhesive is suitable for lamination and jointing purposes in cold and warm press. The application can be done automatically as well as manually. The adhesive is very fast setting and suitable for roller application.

#### Application:

	DANAFIX 407
<b>Field of application:</b>	
Furniture production:.....	●
<b>Dowel-, tenon- and finger joints:</b>	
Furniture:.....	●
Floor:.....	●
<b>Types of wood:</b>	
Soft (ex. pine):.....	●
Hard (ex. beech, oak, teak):.....	●
MDF:.....	●
Chipboard:.....	●
<b>Press:</b>	
Cold:.....	●
Warm:.....	●
<b>After treatment:</b>	
Cutting tools : .....	very low
<b>Article Numbers:</b>	
20 l bucket:.....	7181
600 l container:.....	7182
1000 l container:.....	7183

### Physical / chemical properties:

	DANAFIX 407
Type:.....	Water based PVAc-dispersion
Colour:.....	White
Solid content:.....	52 %
Viscosity (Brookfield, 20 rpm):.....	6800 mPa.s
Density:.....	1.1 kg/ltr
Shelf life, at cold storage:.....	Min. 12 months in closed packaging

## Directions for use:

- Preparation:** The surfaces for adhesive applying have to well adjusted, clean and dry. Optimum result is obtained with newly processed wood.
- Application:** *Joining:* For high strength demanding joints, the adhesive is applied on both the dowel (and 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/m<sup>2</sup>
- Application temperature:** 5- 90 °C
- Open assembly time:** App. 5 - 7 min.  
20 °C, 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:** *Veneering:* 5- 8 kg/cm<sup>2</sup>.  
*Lamination pressure (side pressure):* 8- 10 kg/cm<sup>2</sup> (soft wood) and 13- 15 kg/cm<sup>2</sup> (hard wood).  
*Top pressure:* 1- 1.2 kg/cm<sup>2</sup>. In case of tensions in the wood a higher pressure should be applied.
- Pressing times:** *Veneering:* 40- 120 sec. depending on pressing temperature and thickness of veneer.  
pine app. 9 % moisture, app. 50 % RH:  
*Pressing time should be increased for hard woods, two-sided application, high 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 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.

## Safety:

Hazard symbols: None  
Risk and safety phrases: None

For further information concerning safety, refer to Safety Data sheet.

## 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.