



TECHNICAL DATASHEET

Dowel-, tenon- & finger jointing



Product: DANAFIX 461H/G Taplim DANAFIX 463 DANAFIX 464 DANAFIX 467	DANAFIX 468 DANAFIX 469	Date of issue: 24.08.2017 (Replaces: 11.07.2016) Company: DANA LIM A/S Københavnsvej 220, DK-4600 Køge Ph.: 56 64 00 70, Fax.: 56 64 00 90, www.danalim.dk Technical Service Ph.: 56 64 00 75 Prepared by: Bo Brehmer
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Product description and application:						
The DANAFIX 460-range has been developed for bonding of almost all types of joints in industrial production of wood and furniture.						
DANAFIX 461H/G Taplim is designed especially for tenon-joint application where a strong bonding is requested. A UV detector has been added.						
DANAFIX 463 is mainly used for easy manual joints ex. pine and chipboard, and is very suitable for gluing accessory to self-assemble furniture.						
DANAFIX 464 is an all-round quality for most joints with high adhesive strength and suitable for bigger surfaces.						
DANAFIX 467 is a low viscosity type, and therefore mainly used in automatic application for almost all types of joints.						
DANAFIX 468 gives a very flexible joint, and is especially developed for the assembly of stairs in strings. The adhesive also has an ideal rheology for using in nozzle and roller application.						
DANAFIX 469 is a high viscosity type suitable for more difficult jointing, ex. mounting of glass in wooden grooves (for cupboards etc).						
Application areas:	461H/G	463	464	467	468	469
Production of furniture:.....	●	●	●	●	●	●
Frame wood (D3):.....	Refer to DANAFIX 430- and 440-series					
Dowel jointing:						
Aut. application and driving:	●	●	●	●	●	
Manual jointing:.....	●	●	●	●	●	●
Tenon jointing / tongue & groove jointing:						
Automatic application:.....	●		●	●	●	
Manual jointing:.....	●	●	●	●	●	●
Finger jointing:						
.....	●	●	●	●	●	●
Types of wood:						
Soft (ex. pine):.....	●	●	●	●	●	●
Hard (ex. beech, oak, teak):	●			●	●	●
MDF:.....	●			●	●	●
Chipboard:.....	●	●	●	●	●	●
Treatment:						
Cutting tools (low wear):.....	●	●	●	●	●	●
Other application areas:						
Laminated wood – furniture:	●					●
Edge bonding - wood/wood:	●				●	●
Surface sizing - wood/paper	●		●		●	●
Item Numbers:						
20 l bucket WHITE:.....	6602	7283	-	6105	7083	6439
20 l bucket YELLOW:.....	6607	-	-	-	7184	-
125 l drum:.....	-	7286	2055	6137	7086	-
1000 l container:.....	-	7287	2100	-	-	-

Physical / chemical properties:

Adhesive:	461H/G	463	464	467	468	469
Type:.....	Water based PVAc-dispersion					
Color:.....	White / Yellow	White	White	White	White / Yellow	White
Solids content:.....	47 %	52 %	56 %	35 %	50 %	61 %
Viscosity (Brookf., 20 rpm):.....	9.000 cP	10.000 cP	26.000 cP	330 cP	13.500 cP	36.000 cP
Specific gravity:.....	1.1 kg/ltr	1,3 kg/ltr	1,1 kg/ltr	1,1 kg/ltr	1,1 kg/ltr	1,1 kg/ltr
pH:.....	4-5	6-7	5-7	4-5	4-5	5-6
Shelf life:.....	Minimum 12 months in unopened packing if stored cool.					

Dry glue line:

Color:.....	Transparent	white to yellowish	Transparent	white to yellowish
Temperature resistance:.....	App. -20 °C to +70 °C (the adhesive is thermoplastic, and becomes soft at rising temperatures)			

Direction for use:

Preparation: Both surfaces must be clean, dry and well adjusted. Optimum results are obtained with newly worked wood.

Application: *Jointing:* For high strength demanding joints, the adhesive is applied on 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. Extra dried and compressed dowels will expand when absorbing water from the adhesive and result in the highest strength.
Surface sizing: 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 % (dried dowels as low as 4 %).

Amount of glue: 100 - 200 g/m².

Application temperature: 15 - 70 °C

Open assembly time:	461H/G	463	464	467	468	469
20 °C, 50 % RH. Max(min. Pine approx. 9 % moisture)	5-9 min.	4-8 min.	3-11 min.	6-10 min.	5-8 min.	3-5 min.

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.

Pressure: Approx. 1 - 10 kg/cm². In case of tensions in the wood a higher pressure should be applied.

Pressing time:	461H/G	463	464	467	468	469
20 °C, 50 % RH Pine approx. 9 % moisture	4-10 min.	4-10 min.	4-10 min.	10-15 min.	7-13 min.	4-7 min.

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.

In most cases the construction of the joint will make actual pressing time redundant.

Cleaning: 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 (e.g. acetone).

Storage: Should be stored cool (max. 20 °C) in tightly closed packing. The products should generally be protected against freezing.

All stated times are meant as a guideline. Sufficient tests should be carried out to determine 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.