



*The Glue People*

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# Tradebond D136

## PVC Foil Adhesive

### General Description

Special adhesive for wrapping drawer frames with PVC foils and surface laminating with PVC foils and decorative paper.

### Uses

- Wrapping of drawer frames with PVC foils.
- Surface lamination of PVC furniture foils and decorative papers onto chipboard, work boards, plywood, fibreboards, plaster cardboards and fibrous gypsum boards.

### Advantages

- Easily measured, low consumption.
- Good flowing properties in four roller glue spreaders.
- May be pumped as well as gravity fed from containers placed at a high level.
- High green strength on surfaces as well as when wrapping drawers.
- Good green strength and high bonding on plywood and work boards.

### Application

#### Methods

- Four-roller glue spreaders
- Manual application devices (glue rollers) and toothed spatula can only be used to a limited extent for small surfaces.

#### Techniques

Foils, substrates and adhesive should be acclimatised to room temperature. Do not process below a room and material temperature of +15°C. The ideal moisture content of the wood is 8 - 10%. If using chipboard maintain an even surface layer. Processing should be carried out in a room which is free from dust and other contaminants. Brush substrates before applying the adhesive.

**Quantity** 100 – 120 g/m<sup>2</sup>

The quantity to be applied is dependant on the surface quality of the substrates. Because of the easy measuring of the adhesive, ensure that the minimum application quantity of 100g/m<sup>2</sup> is adhered to – especially when using application machines equipped with smooth rollers.

**Open time** Up to 5 minutes.

The open time is dependant on the absorption properties of the substrates, the room temperature and the quantity applied. The foil has to be fed continuously from the roll or pre-cut pieces must be manually applied within the time indicated. Subsequent corrections are possible.

#### Pressing

In general PVC and other foils are roller coated using rubber-coated roller press and afterwards are stacked one upon the other with the edges carefully aligned. The application of weights to the stack is recommended in order to ensure that the foils stick well at the edges. Subsequent work may be carried out after a stacking time of approximately 2 to 3 hours. Final adhesive strength can only be judged after 24 hours.

## Physical Data

<b>Physical state</b>	EVA Copolymer
<b>Specific weight</b>	1.4 g/cm <sup>3</sup> (approx)
<b>pH Value</b>	7 (approx)
<b>Colour</b>	Cream
<b>Viscosity @ 20°C</b>	15000 mPa.s (Brookfield RVT 20rpm)
<b>Consistency</b>	Medium viscosity
<b>Open time @ 20°C</b>	5 minutes (approx)
<b>Shelf life @ 20°C</b>	6 months (approx)

## General

**For safe handling information on this product, consult the material safety data sheets, (MSDS).**

### Packaging

- 25 Litres plastic drum
- 200 Litres drum
- IBC 1000Kg net

### Storage

**\*\*\*PROTECT FROM FROST\*\*\***

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For specific shelf-life information, contact Trade Grade Products at the above address.

### Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

### Important Notice

Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control.

It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheet, Tradebond D136.