



TECHNICAL DATASHEET

Production of laminated wood for furniture

DANAFIX

Product name:

DANAFIX 495
DANAFIX 496
DANAFIX 497

DANAFIX 498
DANAFIX 499

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Product description and application:

The DANAFIX 490-series has been developed especially for industrial production of laminated wood for furniture, where a D2 quality is desired, if a D3 quality is needed, please refer to the 430-series. All the glues can be used for cold-, warm- and high frequency pressing and can be treated with lye after curing. DANAFIX 495, 496 and 499 have a very short pressing time, and can be used for most wood types. They are developed for continuous production units with automatic application of adhesive, where a very short pressing time is wanted. DANAFIX 497 and 498 have been especially developed for manual application, as they have a longer open assembly time and pressure time. DANAFIX 497 and 498 is used for soft woods.

Application:

Application / assembling:

Manual:.....
Automatic (UV-trace substance)

	DANAFIX 495	DANAFIX 496	DANAFIX 497	DANAFIX 498	DANAFIX 499
Manual:.....	●	●	●	●	●
Automatic (UV-trace substance)	●	●			●

Press:

Cold press:.....
Warm press:.....
High frequency:.....

Cold press:.....	●	●	●	●	●
Warm press:.....	●	●	●	●	●
High frequency:.....	●	●	●	●	●

Types of wood:

Soft (ex. pine):.....
Hard (ex. beech, oak, teak):.....
MDF:.....
Chipboard:.....

Soft (ex. pine):.....	●	●	●	●	●
Hard (ex. beech, oak, teak):.....	●	●			●
MDF:.....	●	●			●
Chipboard:.....	●	●	●	●	●

Treatment:

Lye:.....

Lye:.....	●	●	●	●	●
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Other application areas:

Dowel / Tenon joint – manuel:.....
Fingerjoint:.....
Edge bonding - wood/wood:.....
Surface bonding:.....

Dowel / Tenon joint – manuel:.....	●	●	●	●	●
Fingerjoint:.....	●	●	●	●	●
Edge bonding - wood/wood:.....	●	●	●	●	●
Surface bonding:.....	●	●	●	●	●

Physical / chemical properties:

Adhesive:	DANAFIX 495	DANAFIX 496	DANAFIX 497	DANAFIX 498	DANAFIX 499
Type:.....	Waterbased PVAc-dispersion				
Color:.....	White				
Solids content:.....	49 %	51 %	47 %	48 %	57 %
Viscosity (Brookf. RVF, 20 rpm):.....	8.500 cP	13.000 cP	12.000 cP	17.000 cP	20.000 cP
Specific gravity:.....	1,1 kg/ltr				
pH:.....	5-7	5-7	5-6	5-7	5-6
Shelf life:.....	Minimum 12 month in unopened packing if stored cool.				
Cured joint:					
Color:.....	Matt transparent				
Water resistance (EN204/205):.....	D2				
Temperature resistance:.....	app. -20 °C to +70 °C (the adhesive is thermoplastic, and becomes soft at rising temperature)				

Directions for use:

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

Application: 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.

Wood moisture content: 8 - 14 %

Amount of glue: 100 - 200 g/m²

Application temperature:

DANAFIX 495	DANAFIX 496	DANAFIX 497	DANAFIX 498	DANAFIX 499
10 - 80 °C	10 - 80 °C	10 - 80 °C	10 - 80 °C	10 - 60 °C

Open assembly time:

20 °C, 50 % RH
pine, 9 % moisture

5 min.	5 min.	10 min.	6 - 8 min.	4 - 5 min.
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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: Lamination pressure (side press): 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.

Pressure times, pine approx. 50 % RH, approx. 9 % moisture content of the wood (for lamella sizes 15 mm / 43 mm):

20 °C	8 / 12 mins	8 / 12 mins	30 / 40 mins	15 / 20 mins	7 / 12 mins
40 °C	6 / 10 mins	6 / 10 mins	20 / 30 mins	10 / 15 mins	5 / 9 mins
60 °C	4 / 6 mins	4 / 6 mins	10 / 20 mins	5 / 10 mins	2,5 / 5 mins
80 °C	3 / 5 mins	3 / 5 mins	5 / 10 mins	3 / 5 mins	-

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 are usually obtained after 24 hours.

Cleaning: Wet uncured adhesive can be removed with water. Cured adhesive can only be removed by soaking in lukewarm water or with the use of organic solvents (ex. acetone).

Storage: Adhesive should be stored cool (max. 20 °C) in tightly closed packing. Must be 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 & 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

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.