



Wood Bond E.X.P

technical
data

9th September 2003

Description

Robex Wood Bond E.X.P is a moisture curing single part polyurethane adhesive specifically designed for bonding wood to wood extremely quickly. Wood Bond E.X.P can also be used to bond many types of plastic foams and other insulating materials to a wide range of both flexible and rigid building boards and may also be used in the manufacturing of cold stores, caravans, mobile homes, offices, insulated building units, etc.

Preparation

Surfaces to be bonded must be clean and free from grease, dust and other contaminants.

A test panel should always be prepared when new materials are to be used to establish the adhesives compatibility.

Application

Wood Bond E.X.P can be applied by trowel, notched scraper or poly bottle to one surface only of each glue line. The amount required will vary according to the porosity/smoothness of the substrates and means of application but will normally be in the range of 80-140 grams per m².

The panel is then assembled as soon as possible and placed under pressure within 5 minutes.

The pressure required will depend a great deal on the nature of the substrates but is usually in the range of 0.5 to 0.9 bar.

Pressure should be maintained until the adhesive is sufficiently cured to permit handling of the bonded item. Full cure of the adhesive is not obtained for 24 hours and handling within this period should be kept to a minimum.

The open and cure cycle to permit handling will vary according to:-

1. Temperature
2. Weight of adhesive applied
3. Method of working
4. Substrates

and should always be determined by experiment.

Processing Guide

| | | | |
|----------------|----|----|----|
| Temperature °c | 15 | 20 | 25 |
| Open time mins | 10 | 6 | 3 |
| Cure time mins | 30 | 20 | 10 |

Product Data

| | |
|--------------|----------------------------------|
| Base: | Polyurethane |
| Solids: | 100% |
| Viscosity: | 4000 +/- 500 cps @ 25°C |
| Colour: | Brown |
| Tack Life: | N/A |
| Coverage: | Up to 12.50m ² per kg |
| Flash Point: | Above 150°C |

Shelf Life

3 months once opened.

Storage and Handling

Robex Wood Bond E.X.P is a moisture sensitive adhesive and left in contact with the open atmosphere will eventually gel. For this reason Wood Bond E.X.P is protected with a blanket of Nitrogen in the container prior to dispatch which forms a dry inert layer on top of the adhesive.

Cleaning

Use Robex All Purpose Cleaner.

Notes

The above figures do not constitute a specification. They represent typical values for this product.

No liability is accepted for any injury, loss or damage arising directly or indirectly from the use of the Company's products or from the use of information given in our data sheets, since the customer's use of the product is necessarily out of our control. The information given is intended to serve as a guide only. Customers should satisfy themselves by appropriate trials that the products are suitable for their intended use.

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