



**POLYVINE LIMITED**  
TECHNICAL INFORMATION

**FAST GRAB POLYTEN**  
Water Resistant high speed PVA Adhesive

**PRODUCT DESCRIPTION**

Polyten is the highest grade of assembly adhesive available.

The exceptionally high solids content ensure that it is the fastest strongest adhesive of its type.

Polyten is a wood adhesive designed for high-speed assembly work, doweling, finger jointing, door assembly, veneering with wood or high-pressure laminates.

Water resistant to D3 standard (BS EN 204)

Develops high bond strength.

Dries to transparent film.

Non flammable.

Suitable for Hot and Cold press.

Extended Storage Life.

Suitable for RF equipment.

Suitable for bonding wood, chipboard, block board, veneers decorative laminates and other similar substrates.

**SURFACE PREPARATION**

Joints should be smooth and well fitted.

The surfaces to be bonded must be close fitting and free from dirt, grease or any other contamination that may interfere with the adhesion.

Moisture content of timber should be 5 to 15 %.

Abrading the surface of the joint before assemble is recommended

**APPLICATION**

Apply the glue using a stiff brush to one surface only.

Assemble and clamp (pin or screw) the joint whilst glue is wet.

Keep the joint under pressure until set.

A damp cloth can be used to remove excess wet adhesive.

NOTE: - At temperatures below 10C (50F), a period of up to 2 or 3 days may be required before the glue sets. During cold weather, it is therefore essential that joints under pressure be kept in a warm place.

If bonded wood is to be turned on a lathe it is recommend that the bonded wood is seasoned for a minimum of one week before turning.

## **BONDING TIPS**

1 Ideally the moisture content of the substrates should be  $9\% \pm 2\%$  with no more than 3% difference between the two surfaces to be bonded, otherwise stresses are built into the joint, which may result in wood or joint fracture.

If the wood is too damp, the dilution effect will weaken the adhesive performance.

2. Although the workshop conditions may be above 10C, wood brought in from unheated storage conditions may well be below this temperature and should be allowed to warm to above 10C before attempting to bond it.

3. Some species of oak can be particularly dense resulting in difficulties in the adhesive penetrating the surface. In such instances, the surface should be removed by sanding to open the pores of the timber and double spreading may prove necessary to ensure both surfaces have sufficiently "wetted" out.

4. Some timbers, and particularly maple can be over prepared by planeing the timber; this leaves a "glassy" surface, which is detrimental to the bonding process.

5. Oily timbers, such as teak, present problems with the "oils" inhibiting a satisfactory bond. Degreasing is normally required; this can be achieved by wiping the surface with washing up liquid. Sanding can also remove surface grease, but if the adhesive is not applied shortly afterwards there are likely to be problems of case hardening where the oils have surfaced again.

## **Assembly and Pressing**

Assembly should be carried out as soon as possible within the open time (approx. 5 minutes dependent on temperature and humidity). Pressing should be carried out after assembly whilst adhesive is still wet. A press time of 15 to 25 minutes is recommended at 20°C. In heated press the minimum process time can be reduced to 3 to 5 minutes at 70% Pressure should be 30 to 100 PSI.

## **Coverage**

Normal adhesive coverage is estimated to be 5 to 7 square meters per kilo. The correct spread is indicated by a slight squeeze out on the glue line edge.

The lowest spreads will give the fastest setting time.

Clean Down with warm water, with a little detergent added is recommended.

Care should be taken to avoid drying out on equipment as water resistance makes cleaning difficult.

## **PACKAGING**

125ml, 250ml, 500ml, 1L, 5L.

## **STORAGE**

Store in unopened containers in a cool dry place away from direct sunlight.

## **HEALTH SAFETY AND THE ENVIROMENT**

Non-hazardous. Ensure good ventilation. Keep out of reach of children. Contact with eyes-wash immediately with warm water. Remove excess from tools and mixing vessels before washing in warm soapy water. Do not empty containers into drains or watercourses.

Further information may be obtained from:

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