

## TIMBATECH 05

### MEDIUM SETTING HIGH STRENGTH WOOD GLUE

#### DESCRIPTION

TimbaTech05 is a medium to fast setting high solids crosslinking PVA adhesive which develops exceptional bond strength with high heat and humidity resistance when dried at normal or elevated temperatures. It produces a clear non staining glue line.

#### FEATURES AND BENEFITS

TimbaTech05 is an excellent adhesive for general timber assembly and laminating where high bond strengths and good water/humidity resistance are required.

Can be used in cold or hot pressing applications, Designed for use with RF curing equipment

Water resistance exceeds Din 68 602-D3, Has good creep resistance

Water based and non flammable

#### APPLICATIONS

- Edge gluing timber sections for furniture/joinery work
- Face to Face Laminating, Cabinet and furniture assembly
- Solid timber assembly

#### SURFACE PREPARATION

Wood surface to be glued must be clean, dry, and free of dust, oils, grease and all finishes.

Substrates should be freshly machined to maximize the glues wetting out of the timber.

Joints should be close fitting.

The work area, glue and substrates for bonding should be a minimum of 15°C.

The moisture content of the wood should be between 8 to 12%.

#### APPLICATION INSTRUCTIONS

TimbaTech05 is used as supplied.

Ensure surfaces to be bonded are clean, dry and free from oil, dust and any other contaminations. Joints should be close fitting. Apply glue to one surface at a coverage rate to ensure wetting out of both surfaces to be joined. Press/clamp while adhesive is still wet.

Pressure needs to be applied to the joint assembly within the open time. This will vary with the density, wet-out characteristics, moisture content of the substrates to be bonded and the atmospheric conditions occurring when gluing.

Low temperature, damp conditions will extend the clamp time considerably.

#### ASSEMBLY CONDITIONS (at 25°C and 50% relative humidity)

Apply at a coverage rate of 5-10m square per litre of glue according to the substrate characteristics and working conditions

- Open assembly time 8 minutes at 20°C

- Closed assembly time 8 – 12 minutes (depending on timber density) at 20°C

Clamp Times (Minimum)

<b>Temperatures</b>	<b>Low Density Timbers</b>	<b>High Density Timbers</b>
20°C	90 minutes	180 minutes
30°C	60 minutes	90 minutes

Glue lines should show squeeze out on application pressure.

Where the minimum pressure period is used, `dead` stacking of the freshly bonded panel or timber assemblies for 24 hours prior to machining is recommended.

## PRECAUTIONS

Please note some timbers such as Blackwood and Beech may be susceptible to stain development and discoloration from adhesive, which are acidic in nature (low) PH such as [TimbaTech05](#).

Use of adhesive in very cold conditions may result in poor film formation with powdery glue line

Store adhesive off concrete floor and preferably in a warm environment during winter months

Trials are recommended to confirm suitability for intended use

## CLEAN UP

Wipe excess glue from joints with clean wet cloth before glue has set

## STORAGE AND HANDLING

Store in unopened sealed plastic containers in warehouse conditions and in a warm environment in winter months.

Do not store directly on concrete.

[TimbaTech05](#) is acidic in nature should be used with plastic equipment. Contact with metal containers or equipment other than stainless steel, in storage or use is not good practice and may cause staining problems in the glue line.

## STORAGE LIFE

Typically 12 months at 25°C, in the original, sealed plastic container. Once opened the shelf life is reduced depending upon the storage conditions

## RF CURING APPLICATION

[TimbaTech05](#) is suitable for use with RF curing equipment. Trials should be conducted with the timber species and sections to be used in production to optimise curing conditions

## HOT PRESSING

[TimbaTech05](#) can be used in hot pressing applications, in panel and general assembly gluing.

Temperatures and press time conditions will vary for the particular application, substrate conditions, etc. We would be pleased to assist with laboratory` trials to provide a basis for `production` facility trials

**HEALTH AND SAFETY**

Please refer to Material Safety Data Sheet available on our Website [www.timbatechsolutions.com](http://www.timbatechsolutions.com)

**OTHER TECHNICAL INFORMATION SPECIFIC TO THIS ADHESIVE**

Adequate tests should be carried out on any new or unfamiliar applications to ensure this product is suitable for the specific task.

Samples are available free of charge to assist this procedure.

Material Safety Data Sheet available on request.

*Disclaimer – The statements made herein are based on our experience gained to date. They are to be considered as information without obligation. Please test and establish for yourself our product's suitability for your particular purposes. No liability exceeding the value of our product can be derived from the foregoing statements. This also applies to the technical advisory service, which is rendered free of charge and without obligation*