



POLYVINE LIMITED
TECHNICAL INFORMATION

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 immediatly 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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Date of issue: October 2009



SAFETY DATA SHEET

Polyten

Issued: 19/10/2006 Revision No: 1

1. IDENTIFICATION OF THE SUBSTANCE / PREPARATION AND OF THE COMPANY / UNDERTAKING

Product name: Polyten

Company name

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2. COMPOSITION / INFORMATION ON INGREDIENTS

INGREDIENT NAME:	EINECS	CAS No.:	CONTENT	SYMBOL	RISK:
Contains no dangerous substances according to 67/548/EEC			NC		Not classified.

The full text for all R-phrases are shown in section 16

COMPOSITION COMMENTS:

PVA based adhesive

3. HAZARDS IDENTIFICATION

Irritating to eyes and skin. May cause long-term adverse effects in the aquatic environment.

4. FIRST AID MEASURES (SYMPTOMS)

Skin contact: There may be mild irritation at the site of contact.

Eye contact: There may be irritation and redness.

Ingestion: There may be irritation of the throat.

Inhalation: There may be irritation of the throat with a feeling of tightness in the chest.

4. FIRST AID MEASURES (ACTION)

Skin contact: Wash immediately with plenty of soap and water.

Eye contact: Bathe the eye with running water for 15 minutes.

Ingestion: Wash out mouth with water.

Inhalation: Consult a doctor.

5. FIRE-FIGHTING MEASURES

This material is not combustible.

6. ACCIDENTAL RELEASE MEASURES

Personal precautions: Refer to section 8 of SDS for personal protection details.

Environmental precautions: Do not discharge into drains or rivers.

Clean-up procedures: Wash the spillage site with large amounts of water.

7. HANDLING AND STORAGE

Handling requirements: Use mechanical ventilation in case of handling, which causes formation of vapours.

Storage conditions: Store in cool, well-ventilated area.

8. EXPOSURE CONTROLS / PERSONAL PROTECTION

Respiratory protection:

No specific recommendation made, but respiratory protection must be used if the general level exceeds the Occupational Exposure Level (OEL).

Hand protection: Protective gloves.

Eye protection: Safety glasses. Ensure eye bath is to hand.

Skin protection: Protective clothing.

9. PHYSICAL AND CHEMICAL PROPERTIES

State: Liquid

Colour: White

Odour: Characteristic odour

Solubility in water: Yes

Melting point/range°C: N/A

Flash point°C: N/A

Autoflammability°C:N/A

pH: 6-7

10. STABILITY AND REACTIVITY

Stability: Stable under normal conditions.

Conditions to avoid: Heat.

Materials to avoid: Strong oxidising agents. Strong acids.

Haz. decomp. products: In combustion emits fumes.

11. TOXICOLOGICAL INFORMATION

Routes of exposure: Refer to section 4 of SDS for routes of exposure and corresponding symptoms.

12. ECOLOGICAL INFORMATION

Persistence and degradability: No data available.

Bioaccumulative potential: No data available.

Other adverse effects: No data available.

13. DISPOSAL CONSIDERATIONS

NB: The user's attention is drawn to the possible existence of regional or national regulations regarding disposal.

14. TRANSPORT INFORMATION ADR / RID

UN no: Shipping name: Not classified as dangerous in the meaning of transport regulations.

IMDG / IMO UN no: IATA / ICAO UN no:

15. REGULATORY INFORMATION

Hazard symbols: No significant hazard. **Note:** The regulatory information given above only indicates the principal regulations specifically applicable to the product described in the safety data sheet. The user's attention is drawn to the possible existence of additional provisions, which complete these regulations. Refer to all applicable national, international and local regulations or provisions.

16. OTHER INFORMATION

Legal disclaimer: The above information is believed to be correct but does not purport to be all-inclusive and shall be used only as a guide. This company shall not be held liable for any damage resulting from handling or from contact with the above product.