



# Assembly 65

## PRODUCT DESCRIPTION

**Assembly 65** is an extremely fast-setting, high quality polyvinyl acetate emulsion adhesive. Its exceptional gap filling properties and fast setting rate result from its extremely high percentage of pure polymer solids. It is also very versatile and is widely used for assembly applications and general cabinet room work. The viscosity range of Assembly 65 is similar to most general-purpose adhesives.

## PHYSICAL PROPERTIES <sup>1</sup>

**Chemical Family Description:** Polyvinyl acetate emulsion adhesive

**Appearance:** White colored liquid

**Freeze/Thaw Stable<sup>2</sup>:** No

**Specific Gravity:** 1.11

**Weight Solids (%):** 58.5-62.0

**pH:** 3.9-5.0

**Typical Viscosity (cps):** 3,000-4,200

**Suggested Minimum Use Temperature<sup>3</sup>:** 15°C

## APPLICATION GUIDELINES

**Moisture Content:** Proper stock moisture content is important to successful assembly gluing. Adhesives generally set more slowly as moisture content of the wood increases. Recommended moisture content ranges are 6-8% in most interior applications.

**Joint Preparation:** Joints should be cut accurately with sharp tools. Joints should fit snugly when assembled and clamped. Adhesives should not be expected to act as gap fillers. Conversely, too tight of a joint may cause the adhesive to be scraped away from the gluing surface. Dull cutting tools will cause glazed or burnished surfaces preventing adhesive penetration.

**Spread:** Adhesive is generally applied by brush, plastic squeeze bottles, automatic pumping system. It is important to get a uniform coating over the entire gluing surface.

**Assembly Time:** Assembly time can vary greatly depending on the adhesive used, glue spread, porosity and moisture content of the gluing stock, environmental conditions, etc. Generally accepted assembly times range from 2-10 minutes.

**Clamping:** A variety of clamps and clamping systems are available for assembly joints. Enough clamping pressure is recommended to provide a thin glue line along the entire surface of the joint. Direct contact of the gluing surfaces must be made to obtain maximum strength.

**Clamp Time:** Clamp time is dependent on the adhesive used, species and moisture content of the stock, environmental factors and glue line thickness. Clamp times can range from a few minutes to more than an hour depending on the above factors. Clamp times should be determined under plant conditions.

**Minimum Temperature:** Curing temperatures should be higher than the minimum use temperature of the adhesive. This includes the temperature of the stock to be glued as well as the air and adhesive temperatures.



## PERFORMANCE PROPERTIES

### Block Shear Strength<sup>1</sup>:

	lb/in <sup>2</sup>	wood failure%
25°C	4,178	35
65°C Overnight	1,527	04

**Room Temperature Speed of Set<sup>5</sup>:** 1.37 (Very Fast)

<sup>1</sup> All numerical values represent typical properties.

<sup>2</sup> If product has been frozen, contact Technical Service for instructions.

<sup>3</sup> Measured by Franklin's film formation test. Gluing conditions will affect minimum use temperature.

<sup>4</sup> Performed according to ASTM D-905 on hard maple.

<sup>5</sup> Measured by Franklin's torsion speed of set tester on hard maple @ 3 minutes clamp time.

## RELATED PRODUCTS

Franklin Adhesives has a complete line of assembly glues in a wide range of viscosities. Related assembly adhesives include: Assembly High Tack (3,250 cps), Woodbond 285 (4,100 cps), and Titebond 55-T (27,000). **Special Note:** Franklin offers many of our assembly glues with fluorescent dyes. Please contact us for additional information.

## HANDLING AND STORAGE

Store in tightly closed original container. Protect from freezing. Storing at temperatures above 25°C will reduce the maximum storage time. If thickening, separation or settling occurs, the adhesive should be thoroughly mixed and will then be ready to use again.

**Protect adhesive from freezing.** If product has been frozen, contact Franklin Customer Service for instructions.

**Important Notice to Purchaser:** Our recommendations, if any, for use of this product are based on tests believed to be reliable. The greatest care is exercised in the selection of our materials and in our manufacturing operations. However, we make no recommendation to use this product in any manner which conflicts with existing laws and/or patents and WE MAKE NO WARRANTIES, EXPRESS OR IMPLIED, REGARDING THIS PRODUCT OR ITS USE, INCLUDING MERCHANTABILITY AND FITNESS FOR PARTICULAR PURPOSE, THE MANUFACTURER IS NOT LIABLE FOR ANY CONSEQUENTIAL, INCIDENTAL OR SPECIAL DAMAGES OF ANY KIND. Revised 09/28/05

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