



# Assembly 50

## PRODUCT DESCRIPTION

**Assembly 50** is a cost-effective, very fast-setting polyvinyl acetate emulsion adhesive. Its high percentage of pure polymer solids provides improved gap filling, and its low viscosity allows for easy spreading. Assembly 50 is well suited for doweling and general assembly work.

## PHYSICAL PROPERTIES

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

**Appearance:** White colored liquid

**Freeze/Thaw Stable:** Yes

**Specific Gravity:** 1.13

**Weight Solids (%):** 56-59

**pH:** 4.0-5.0

**Typical Viscosity (cps):** 3,000-4,300

**Suggested Minimum Use Temperature:** 8° 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.

**Spread:** Adhesive is generally applied by brush, plastic squeeze bottles, or 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:

	<b>Psi</b>	<b>wood failure%</b>
Room Temperature	3,953	34
150°F Overnight	1,108	01

**Room Temperature Speed of Set:** 1.37 (Very Fast)

## RELATED PRODUCTS

We have a complete line of assembly glues in a wide range of viscosities. Related assembly adhesives include: Assembly 8-5% (950 cps), Assembly 8 (1,500 cps), Assembly 70A (8,000 cps), Assembly T-2A (16,000 cps), and Assembly TX-Brown (40,000). For additional information, contact our technical support team.

## 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.

**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 08/19/05

©Copyright 2008. All rights reserved. Franklin International.