



# Laminating 6W

## PRODUCT DESCRIPTION

**Laminating 6W** is a high-quality, polyvinyl acetate emulsion adhesive. It is specifically designed to reduce bleed-through of porous face veneers. Laminating 6W is an excellent choice for cold-press laminating fancy face veneers to particleboard, medium density fiberboard, or other core stock.

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

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

**Appearance:** Tan colored liquid

**Freeze/Thaw Stable<sup>2</sup>:** yes

**Specific Gravity:** 1.11

**Viscosity (cps):** 3,800-5,500

**Weight Solids (%):** 41-43

**pH:** 4.0-5.0

**Suggested Minimum Use Temperature<sup>3</sup>:** 6 °C

## APPLICATION GUIDELINES

**Tolerances:** Gluing stock should be uniform in thickness. Variation in thickness should not exceed  $\pm 0.15$  mm. Sanding to thickness should be performed using higher than 50 grit abrasives.

**Spread:** Generally, 140-245 g/m<sup>2</sup> of glue line is adequate. Lower adhesive spreads require better stock tolerances and shorter assembly times. Commonly, a mechanical glue spreader is used to apply a uniform spread to the gluing surfaces.

**Assembly Time:** Assembly time can vary greatly depending on the adhesive used, glue spread, porosity and moisture content of stock, environmental conditions, etc. A small bead of adhesive squeeze-out around the perimeter of the bottom panel in the stack is desirable. Generally accepted assembly times range from 15-20 minutes.

**Pressure:** Pressure is dependent upon the species or material to be glued. Direct contact of the gluing surfaces must be achieved to obtain maximum strength. Suggested pressures for various substrates are; high pressure laminates 2.1-5.6 Kg/cm<sup>2</sup>; solid core stock 7.0-10.5 Kg/cm<sup>2</sup>; all veneer constructions 7.0-17.6 Kg/cm<sup>2</sup>.

**Press Time:** Press time is dependent on the adhesive used, gluing stock type, moisture content of the stock and environmental conditions. Typical press times range from 30 minutes to two hours. Press times should be determined under plant conditions.

**Minimum Temperature:** Curing temperatures should be higher than the minimum use temperature of the adhesive, which is 6 °C. This includes the temperature of the stock to be glued, as well as the air and adhesive temperatures.



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### PERFORMANCE PROPERTIES

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

	lb/in <sup>2</sup>	wood failure%
25 °C	2,508	06
65 °C Overnight	656	00

Room Temperature Speed of Set<sup>5</sup>: 0.93 (Moderately Slow)

<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. The higher the value, the faster the speed of set.

### RELATED PRODUCTS

**Laminating 6W** is designed for increased bleed through protection on thin or porous veneers. **Laminating 25** has long been used in traditional laminating operations such as bonding High Pressure Laminate to Particleboard.

### STORAGE AND HANDLING

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.

#### Note:

Discoloration and checking of wood veneer products occurs occasionally. These occurrences are infrequent and range in appearance, color and may vary with the species of the veneer. Discoloration and checking may appear during or after the manufacturing process. Among other things, environmental conditions in some manufacturing plants and end-use locations can contribute to checking. If veneer discoloration or checking occurs, our representatives are prepared to visit and assist you in attempting to identify the causes and possible solutions. Because such discoloration and checking are attributable to conditions beyond our control, Franklin International can assume no responsibility or liability for any problems that might occur.

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