



Assembly 161

PRODUCT DESCRIPTION

Assembly 161 is specifically designed for use with automatic doweling equipment. Its low viscosity (150 cps.) allows the appropriate flow through the narrow feed lines and injectors of European-made doweling machinery. Assembly 161 sets fast to reduce assembly time, offers excellent strength and provides a translucent glue line. It is formulated for use on solid woods, particleboard, MDF, plywood and other porous materials.

PHYSICAL PROPERTIES

Chemical Family Description: Polyvinyl acetate
emulsion adhesive

Typical Viscosity (cps): 160 - 270

Appearance: White colored liquid

Suggested Minimum Use Temperature: 44 °F

Freeze/Thaw Stable: No

Weight Per Gallon (lbs): 9.00

pH: 4.0 - 4.8

Weight Solids (%): 42.0 - 46.6

APPLICATION GUIDELINES

Moisture Content: Proper stock moisture content is important to successful dowel gluing. Adhesives generally set more slowly as moisture content of the wood increases. Dowel holes can also become out of round as the moisture content decreases. Recommended moisture content ranges are 6-8%.

Machining: Dowel holes should be cut accurately with sharp tools. Dull tools cause burnishing of the dowel hole and prevent glue penetration. The dowel hole should also be free of torn grain which will produce a high percent of surface wood failure but relatively little strength.

Part Fit: To obtain maximum strength, the dowel should fit snugly into the dowel hole. Too tight of fit will push the glue into the bottom of the hole. Conversely, too loose of fit will produce a heavy glue line, and ultimately, a weak joint. A small space between the bottom of the dowel and the bottom of the hole (1/16") will allow room for expansion of the dowel without producing stress cracks.

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.

Machine Settings: Consult with machine manufacturer's recommendation for details.



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PERFORMANCE PROPERTIES

Block Shear Strength:

	Psi	wood failure%
Room Temperature	2,711	32
150 °F Overnight	1,089	

Room Temperature Speed of Set: 1.01 (Moderately Fast)

STORAGE AND HANDLING

Shelf life: Three months at 70 °F. Store in closed containers. To ensure uniformity of adhesive, stir before using.

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

IMPORTANT NOTICE TO CUSTOMER:

The recommendations and data contained in this Product Data Sheet for use of this product are based on information Franklin believes to be reliable. They are offered in good faith without guarantee, as conditions and methods for use of our product by Customer and are beyond Franklin's control. Customer must determine the suitability of the product for a particular application before adopting it on a commercial scale.

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