



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

Chemical Family Description: Polyvinyl acetate emulsion adhesive

Typical Viscosity (cps): 3,000-4,400

Appearance: White colored liquid

Suggested Minimum Use Temperature: 59 °F

Freeze/Thaw Stable: No

Per Gallon (Weight lbs.): 9.30

pH: 3.9 - 5.0

Weight Solids (%): 58.5-62.0

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, 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.



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PERFORMANCE PROPERTIES

Block Shear Strength:

	Psi	wood failure%
Room Temperature	4,178	35
150°F Overnight	1,527	04

Room Temperature Speed of Set: 1.37 (Very Fast)

STORAGE AND HANDLING

Shelf life: 6 months at 70° F. Store in closed containers.

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 07/30/08.

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