



Doorbond 200

PRODUCT DESCRIPTION

Doorbond 200 is a fast-setting, one component flush door adhesive. It is designed for hot or cold press manufacture of flush and architectural doors. The product has passed the 90 minute vertical fire test on Georgia Pacific mineral core with HPDL skin. Doorbond 200 has also been approved for use on Marshfield cores per report #3093107. Doorbond 200 produces a water and heat resistant bond on various rail, stile and skin substrates. These substrates include: wood, hardboard, MDF, particleboard and high pressure laminates. This product has been formulated to prevent bleed through under normal operating conditions.

Doorbond 200 complies with the VOC limits of California's South Coast Air Quality Management Districts Rule 1168. This makes it compliant with the adhesive requirements for both the United State's and Canada's Green Globes Program, the U.S. Green Building Council's LEED™ Program and the National Association of Homebuilders Green Building Guidelines.

PHYSICAL PROPERTIES

Chemical Family Description: Crosslinking polyvinyl acetate emulsion adhesive

Typical Viscosity (cps): 5,700 - 8,500 4/60/83 °F

Appearance: Cream

Suggested Minimum Use Temperature: 45 °F

pH: 2.7 - 3.5

Weight Per Gallon (lbs): 9.3

Weight Solids (%): 49.0 - 53.0

APPLICATION GUIDELINES

Moisture Content: Six to eight percent is the recommended moisture content of the gluing stock. High moisture content will slow down glue line cure and cause weaker than normal adhesive bonds. Additionally, panel shrinkage may occur resulting in stress cracks or end delamination.

Stock Preparation: Particle board, MDF and Mineral core will bond best if free from dust. Joints cut from rip saws should be free of saw marks. They should also be straight and square. Moulded or jointed stock should be free of knife marks. Glazed or burnished joints will prevent glue penetration and should be guarded against. When possible, glue joints should be prepared and glued the same day.

Spread: Generally, 35-50 pounds per 1,000 square feet of glue line (6-9 wet mils or 180-260 ft²/gal) is adequate. Conveyorized spreaders are commonly used in this application. The use of a wool felt sleeve on the spreader roll could aid in obtaining a desirable spread and reducing excess glue usage.

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 30-80 psi; solid core stock 100-150 psi; all veneer constructions 100-250 psi.

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



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APPLICATION GUIDELINES (Continued)

| | 160 | 170 | 180 | 190 | 200 | 210 | 220 | 230 | 240 | 250 | |
|----------------------------------|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| Distance to Deepest Glue Line | 1/32" | 1' 31" | 1' 25" | 1' 19" | 1' 14" | 1' 09" | 1' 05" | 1' 01" | 0' 57" | 0' 53" | 0' 50" |
| | 1/16" | 1' 53" | 1' 46" | 1' 39" | 1' 33" | 1' 27" | 1' 21" | 1' 16" | 1' 11" | 1' 07" | 1' 02" |
| | 3/32" | 2' 22" | 2' 13" | 2' 04" | 1' 56" | 1' 49" | 1' 42" | 1' 35" | 1' 29" | 1' 24" | 1' 18" |
| | 1/8" | 2' 58" | 2' 46" | 2' 36" | 2' 26" | 2' 16" | 2' 08" | 1' 59" | 1' 52" | 1' 45" | 1' 38" |
| | 5/32" | 3' 42" | 3' 28" | 3' 15" | 3' 02" | 2' 51" | 2' 40" | 2' 29" | 2' 20" | 2' 11" | 2' 03" |
| | 3/16" | 4' 38" | 4' 20" | 4' 03" | 3' 48" | 3' 33" | 3' 20" | 3' 07" | 2' 55" | 2' 44" | 2' 33" |
| | 7/32" | 5' 47" | 5' 25" | 5' 05" | 4' 45" | 4' 27" | 4' 10" | 3' 54" | 3' 39" | 3' 25" | 3' 12" |
| | 1/4" | 7' 15" | 6' 47" | 6' 21" | 5' 57" | 5' 34" | 5' 13" | 4' 53" | 4' 34" | 4' 17" | 4' 00" |

Temperatures above 200 °F are not recommended for High Pressure Laminates by their manufacturers.

PERFORMANCE PROPERTIES

Meets or exceeds the following industry standards:

- UBC 7-2 part 1 (1997), NFPA 252 (1999) and UL 10C (1998), for a 90 minute rating.
Report # 3073188 dated 4/1/2005 – 90 minute pilot scale vertical fire test conducted on Franklin International Doorbond 200 adhesive in a **Georgia Pacific** mineral core door with HPL skin.
- Approved **Marshfield** Door systems 90 minute door construction, wood veneer, HPL with or without cross band base on test #3093107-001 and IR scans.
- WDMA TM-6 Type 1 and Type 2
- California's South Coast Air Quality Management Districts Rule 1168
- HPVA Type 2
- SpecDIRECT listed as pre-certified on Georgia Pacific and Marshfield Cores – no fire certification testing necessary before use
www.intertek-etlsemko.com

STORAGE AND HANDLING

Shelf Life: Six months at 70 °F.

Store in closed containers and mix before use.

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. Discoloration and checking of wood veneer materials may occur with use of the product. These occurrences range in appearance, color and may also vary depending upon the species of wood veneer to which the product is applied. Such discoloration and checking may appear during or after the manufacturing process which utilizes the product. Environmental conditions in some manufacturing plants and end-use locations can contribute to discoloration and checking. Because such discoloration and checking are attributable to conditions beyond Franklin's control, Franklin cannot assume any responsibility or liability for any discoloration and/or checking problems that might occur.

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