



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 PROPERTIES¹

Chemical Family Description: Polyvinyl acetate emulsion adhesive

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

Appearance: Tan colored liquid

Suggested Minimum Use Temperature³: 43 °F

Freeze/Thaw Stable²: Yes

Per Gallon (Weight lbs.): 9.25

pH: 4.0 - 5.0

Weight Solids (%): 41.0 - 43.0

APPLICATION GUIDELINES

Tolerances: Gluing stock should be uniform in thickness. Variation in thickness should not exceed ± 0.005 inches. Sanding to thickness should be performed using higher than 50 grit abrasives.

Spread: Generally, 35-50 pounds per 1,000 square feet of glue line (6-9 wet mils or 180-260 ft²/gal) 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. Longer assembly times are possible with Laminating 74 in many cases.

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 press times range from 30-45 minutes. Many customers are able to trim the panels immediately after pressing. Times should be determined under actual plant conditions.

Minimum Temperature: Curing temperatures should be higher than the minimum use temperature of the adhesive, which is 45 °F. 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 Strength¹:

	Psi	wood failure%
Room Temperature	2,508	06
150 °F Overnight	656	00

Room Temperature Speed of Set: 0.93 (Moderately Slow)

¹ All numerical values represent typical properties.

² If product has been frozen, contact Technical Service for instructions.

³ Measured by Franklin's film formation test. Gluing conditions will affect minimum use temperature.

⁴ Performed according to ASTM D-905 on hard maple.

⁵ 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.

STORAGE AND HANDLING

Shelf Life: 6 months at 70 °F. To ensure uniformity of adhesive, stir before using.

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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