



Multibond[®] 3215

PRODUCT DESCRIPTION

Multibond 3215 is a pre-catalyzed, crosslinking polyvinyl acetate emulsion adhesive. It is recommended for hot and cold pressing of veneers and high-pressure laminates to various cores as well as edge and face gluing in high frequency (RF) operations. Multibond 3215 is specifically formulated to offer releasability from equipment and to provide easy clean-up characteristics without sacrificing performance. It also offers excellent bleed-through resistance with porous veneers, as well as extended open times.

PHYSICAL PROPERTIES

Chemical Family Description: Crosslinking polyvinyl acetate emulsion adhesive

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

Appearance: Cream colored liquid

Suggested Minimum Use Temperature: 60°F

Freeze/Thaw Stable: Yes

Per Gallon (Weight lbs.): 9.10

pH: 2.5-3.5

Weight Solids (%): 48.5-51.0

APPLICATION GUIDELINES

Moisture Content: Six to eight percent is the recommended moisture content for the gluing stock. High moisture content will dramatically increase the clamp time needed. Additionally, panel shrinkage may occur resulting in stress cracks or end joint delamination

Stock Preparation: The preparation of the stock to be glued is extremely important. 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 adhesive penetration and should be guarded against. When possible, glue joints should be prepared and glued the same day.

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. Bowing of staves used in edge gluing should be kept to a minimum, typically less than 1/16" end to end.

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 can aid in obtaining a desirable spread and reducing excess glue usage.

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 time is 5-10 minutes.

Pressure: Pressure is dependent upon the species or material to be glued and joint preparation. Direct contact of the gluing surfaces must be made to obtain maximum strength. Suggested pressures for various wood densities are: low 100-150 psi; medium 125-175 psi; high 175-250 psi. Clamps for edge gluing should be spaced 8-12 inches apart and 2 inches from the end of the panel to evenly distribute pressure along the entire length of the glue line.



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APPLICATION GUIDELINES (Continued)

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 two hours and should be determined under plant conditions. RF press times should be determined by in-plant testing on each machine. Hot press cure times can be estimated with this hot press schedule and verified with in-plant trials.

	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:

- ANSI/HPMA 1994 Type II water resistance

Block Shear Strength:	Psi	wood failure%
Room Temperature	3,550	38
150°F Overnight	1,625	04

Room Temperature Speed of Set: 0.90 (Moderately Slow)

STORAGE AND HANDLING

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

Note:

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

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 08/06/08.

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