



Multibond[®] MX90

PRODUCT DESCRIPTION

Multibond MX90 is a one-part, cross-linking PVA that was designed to increase productivity by virtually eliminating problems associated with hot press line shut downs, shift changes, thin glue spreads, and hot environments. It features a new-generation polymer that permits a dry glue line to be reactivated with the right combination of heat and pressure to form a Type II bond. Multibond MX-90 is formulated for excellent bleed through resistance.

PHYSICAL PROPERTIES

Chemical Family Description: Crosslinking polyvinyl acetate emulsion adhesive

Typical Viscosity (cps): 2,500-4,000 ^{4/60/83°F}

Appearance: Beige colored liquid

Per Gallon (Weight lbs.): 9.20

pH: 2.0-3.3

Weight Solids (%): 49.0-52.0

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. 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: Multibond MX90 features a new-generation polymer that permits a dry glue line to be reactivated with the right combination of heat and pressure to form a Type II bond. Open times of one hour or more are attained with Multibond MX90.

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.

Suggested Hot Press Cycle: The recommended press temperature is 230-250°F (110-122°C). Press time is dependent on a number of factors including press temperature and the distance to the deepest glue line. Most 3-ply veneering will require less than 2 minutes.



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PERFORMANCE PROPERTIES

Meets or exceeds the following industry standards:

- ANSI/HPVA 1994 Type II water resistance
- NWWDA Type II water resistance
- Humidity Cycling Test
- 180 °F Heat Age Test)

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 Technical Service for instructions.

This product can thicken with age or exposure to high temperatures. Agitation of the tote or drum is recommending before use under these conditions.

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 07/30/08.

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