



Multibond[®] SK-8

PRODUCT DESCRIPTION

Multibond SK8 is a one-part, highly water-resistant adhesive formulated specifically for the manufacture of skateboards in cold press operations. Multibond SK8 meets the water-resistance requirements usually attained only with two-part systems and its unique polymer forms a strong glue line that gives skateboards firmness and responsiveness. Being a one-part adhesive with a low chalking point, Multibond SK8 is easy to use and eliminates errors in handling and processing associated with two-part systems.

PHYSICAL PROPERTIES

Chemical Family Description: Crosslinking polyvinyl acetate emulsion adhesive

Typical Viscosity (cps): 1,900-8,000 ^{3/12/77F}

Appearance: Beige colored liquid

Suggested Minimum Use Temperature: 45 °F

Freeze/Thaw Stable: No

Per Gallon (Weight lbs.): 9.20

pH: 2.4- 3.5

Weight Solids (%): 48.7 – 52.3

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 delamination.

Tolerances: Gluing stock should be uniform in thickness.

Spread: Generally, 35-50 pounds of adhesive per 1,000 square feet of glue line is adequate.

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 pressure for high density hard woods is 175-250 psi.

Press Time: Press time is dependent on the gluing stock type, moisture content, and environmental conditions. Typical cold press times range from 30 to 60 minutes and should be verified under actual plant conditions.



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PERFORMANCE PROPERTIES

Has met or exceeded the following industry standards:

- | | | | | | |
|------------------------|---------------|---------------|---------------|--------------|----------------|
| ASTM D 4317 | Block Shear | 48 hours soak | Tension-75 °F | 2 Cycle Boil | Tension-160 °F |
| Type 1, Wet Use | 3679psi 57%wf | 312 psi | 448psi 86%wf | 318psi 81%wf | 439psi 94%wf |
- HPVA Type 1** on 3-ply Birch veneer

ASTM D-906: 593 psi - 66 % Wood Failure (Tested at Room Temperature)

WDMA TM-6 Type I

Room Temperature Speed of Set: .98 (Slow)

STORAGE AND HANDLING

Life: 3 Shelf 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.

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