



# Woodbond 1910

## PRODUCT DESCRIPTION

**Woodbond 1910** is a one-part adhesive which has met the requirements of the ASTM-D5572 Dry Use standard. Woodbond 1910 has been specifically formulated for finger jointing of interior stock; offering excellent handling properties, high heat resistance, and easy extrusion on most finger joint application systems.

## PHYSICAL PROPERTIES

**Chemical Family Description:** Polyvinyl acetate emulsion adhesive

**Appearance:** White colored liquid

**Freeze/Thaw Stable:** Yes

**Weight Per Gallon (lbs):** 9.20

**Typical Viscosity (cps):** 4400 - 6800

**Suggested Minimum Use Temperature:** 40 - 43 °F

**Weight Solids (%):** 42.0 - 45.0%

**pH:** 4.3 - 5.0

## APPLICATION GUIDELINES

The finger jointing of lumber is increasingly popular as a method of reducing wood waste and providing maximum wood utilization resulting in lower raw material costs. Structural and non-structural finger jointed products have gained wide acceptance throughout the wood industry. The preparation of these joints, as well as the adhesive, play a critical role in the quality of finger jointed products. Most failures of finger jointed lumber are caused by poorly machined and poorly fitted dry joints. The adhesive plays a role in finger joint back off, heat and water resistance. However, even the best adhesive available cannot make up for a poor fitting joint. The fit of the dry finger joint should be checked before gluing begins. The following tips may help you in reaching a properly fitting finger joint or trouble shooting finger jointing problems in your operation.

**Knives and Cutterhead:** Be sure to check overall knife stack for accuracy. Keep cutterheads in pairs and properly cleaned. Cutterheads should be sharpened as a set. Knife set should cut only .010" to .030" of wood. Knives should be sharpened after running approximately 30,000 board feet. (wood species may cause this to vary).

**Cutting Machine:** Make sure cutterhead spindle is set vertically with no wear or play in the bearings. Chain carrier lugs should be squared with the trim saws and cutterheads. Make sure trim saws are set true. Check bed rails for wear on a regular basis. Check hold down pressure to provide sufficient pressure to prevent movement of stock while cutting the joint.

**Joint Assembly:** Pressure should be held constant until joint is cured. End pressure should be set to provide 150-200 psi pressure for non-structural joints. Crowder wheels should be aligned to match fingers accurately.

**Adhesive Application:** Sufficient adhesive spread will provide a uniform coverage that should cover 1/2-2/3 the length of the finger on both sides in a thin continuous film. Make sure fingers aren't skipped and that the adhesive is applied to the whole joint, not just the tips of the fingers. Excess adhesive squeeze-out can cause arcing in a Radio Frequency tunnel. It also causes adhesive build-up and poor adhesive efficiency. Too much adhesive can cause a hydraulic effect resulting in finger joint back off.



## Woodbond 1910

### PERFORMANCE PROPERTIES

Meets or exceeds the following industry standards:

- ASTM D-5572 Dry Use

Adhesive	Exposure	Finger Joint Test Results*				Requirements			
		Strength (psi)		Wood failure%		Strength (psi)		Wood failure %	
		Avg.	Min.	Avg.	Min.	Avg.	Min.	Avg.	Min.
	Dry	4,426	N/A	99	90	2,000	N/A	60	30
Woodbond 1910	Three-Cycle Soak	2,802	N/A	79	30	1,000	N/A	30	15
	Elevated Temp.	2,666	N/A	85	40	1,000	N/A	N/A	N/A

\* Testing conducted on Taeda Pine.

Room Temperature Speed of Set: 1.37 (very fast)

### HANDLING AND STORAGE

**Shelf life:** Six months at 70 °F. Store in closed containers. To ensure uniformity of adhesive, stir before using.

#### 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 should determine the suitability of the product for a particular application before adopting it on a commercial scale.

All orders for Franklin products shall be subject to Franklin International, Inc.'s Standard Terms and Conditions of Sale which may be found at [http://www.franklini.com/Terms\\_and\\_Conditions.aspx](http://www.franklini.com/Terms_and_Conditions.aspx) ("Standard Terms"). Different or additional terms proposed by Customer are expressly rejected and shall not become part of the agreement between Customer and Franklin International, Inc. with respect to any order. Contact Franklin International, Inc. immediately if you cannot access our Standard Terms and we will provide you a copy upon request. Any sale of products by Franklin to Customer is expressly conditional upon Customer's consent to the Standard Terms, and Customer's acceptance of any performance by, or receipt of products from, Franklin International, Inc. shall constitute Customer's acceptance of the Standard Terms and Conditions of Sale.

©Copyright 2010. All rights reserved. Franklin International. Revised 04/14/10.