

## Multibond SK-8

**Multibond SK-8** is the first one-part crosslinking polyvinyl acetate emulsion that meets ANSI/HPVA HP-1-2000 Type 1 and ASTM D-4317 Type 1 Wet Use. It is widely used for cold press lamination by skateboard manufacturers due to its superior performance. It can also be hot pressed and used in applications that are radio frequency cured. It has a low minimum use temperature and a long assembly time.



### PHYSICAL PROPERTIES

**Chemical family description:** Crosslinking polyvinyl acetate emulsion adhesive

**Appearance:** Beige colored liquid

**Typical viscosity (cps):** 2000 - 4500 (3/12/75 °F)

**Weight solids (%):** 47.5 – 52.5%

**pH:** 2.4 - 3.5

**Specific gravity:** 1.10      **Weight pounds per gallon:** 9.26

**Suggested minimum use temperature:** 45 °F / 7 °C

### KEY PRODUCT FEATURES

- Highest water-resistance of any one-component PVA
- Low minimum use temperature
- Moderately slow setting
- Used by some of the top skateboard brands in the industry

### PERFORMANCE PROPERTIES

- Exceeds requirements for ANSI/HPVA HP-1-2000 Type 1
- Exceeds requirements for ASTM D-4317 Type 1 Wet Use
- 175.105 FDA Compliant

Like all adhesives, proper gluing practices are needed to achieve stated performance.

#### ASTM D-906 (3 ply birch)

Tested after seven days conditioning at 25 °C or 77 °F

Temperature	Strength (psi)	Wood failure (%)
77 °F/25 °C	593	66

\* 3 ply rotary cut birch Franklin Laboratory results.

#### ANSI/HPVA HP-1-2000

Exposure	Test results				Requirements			
	Strength (psi) Average	Strength (psi) Minimum	Wood failure (%) Average	Wood failure (%) Minimum	Strength (psi) Average	Strength (psi) Minimum	Wood failure (%) Average	Wood failure (%) Minimum
Dry	540	NA	76	10	>350	NA	15	10
Cyclic-boil	315	NA	65	20	250-350	NA	30	10

\*TECO Report #03-188 10/16/2003 3ply rotary cut birch

## ASTM D-4317 Type I Wet Use

Exposure	Test results				Requirements			
	Strength (psi) Average	Strength (psi) Minimum	Wood failure (%) Average	Wood failure (%) Minimum	Strength (psi) Average	Strength (psi) Minimum	Wood failure (%) Average	Wood failure (%) Minimum
<b>Block shear (compression) dry at 75°F/24°C</b>	4329	NA	44	NA	2800	NA	NA	NA
<b>Plywood (tension) dry at 75°F/24°C</b>	448	NA	86	NA	400	NA	NA	NA
<b>Plywood (tension) dry at 160°F/71.1°C</b>	439	NA	94	NA	250	NA	NA	NA
<b>Two-cycle boil</b>	322	NA	68	20	250-350	NA	30	10
<b>48 hour soak</b>	262	NA	NA	NA	250	NA	NA	NA

\*Franklin laboratory results. Block shears on maple and tension tests on 3-ply rotary cut birch.

## 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. 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. Gluing stock should be uniform in thickness. Variation in thickness should not exceed  $\pm 0.005$  inches/0.12 mm. Sanding to thickness should be performed using higher than 50 grit abrasives. When possible, glue joints should be prepared and glued the same day.

**Spread:** Generally, 35-50 pounds of adhesive per 1,000 square feet or 170-250 grams per square meter of glue line is adequate. Verify adequate glue coverage by monitoring for squeeze out along the glue line once the panels are under pressure. A Web-based spread calculator can be found at [www.franklinadhesivesandpolymers.com](http://www.franklinadhesivesandpolymers.com)

**Pressure:** Pressure is dependent upon the species or material to be glued and joint preparation. Direct contact of the gluing surfaces is required to obtain maximum strength. The use of a compressometer will aid in accurately measuring the amount of pressure being applied to the gluing area. Suggested clamp locations for various wood densities are eight to fifteen inches (20-38 cm) apart and two inches (five cm) from the end of the panel to evenly distribute pressure along the entire length of the glue line. A Web-based pressure calculator can be found at [www.franklinadhesivesandpolymers.com](http://www.franklinadhesivesandpolymers.com).

### Recommended clamping pressures:

Species	Clamping pressure	Example
Low density wood species	100-150 psi or 7-10 kg/cm <sup>2</sup>	Pine, Poplar
Medium density species	125-175 psi or 9-13 kg/cm <sup>2</sup>	Rubberwood, Cherry
High density species	175-250 psi or 13-18 kg/cm <sup>2</sup>	Oak, Maple

**Assembly time:** The assembly time is influenced by many factors some of which include glue spread, moisture content of the stock, porosity of the stock, environmental conditions and adhesive choice. Assembly times of 5-10 minutes are approximate. It is desirable to see a bead of adhesive squeeze out around the perimeter of the bottom panel of the stack.

At 70°F and 50% relative humidity, approximately 6 wet mils:

Open Assembly Time – 5 minutes

Total Assembly Time – 15 minutes

**Press/ clamp time:** Press times are dependent on the adhesive used, gluing stock type, moisture content of the stock, and environmental conditions. Press times can range from a minimum press time of 30 minutes to greater than two hours. Shorter times are required under ideal conditions when using soft wood species at moisture content slightly less than eight to ten percent and factory temperatures of 68 degrees Fahrenheit/ twenty degrees Celsius. Longer press times will be required for higher density species, higher moisture contents and colder factory temperatures. It is recommended that optimum press times be determined in actual plant conditions recognizing that seasonal changes may lead to variable requirements.

**Machining/ Post Process Conditioning:** After the minimum clamping time period, the panel will develop enough handling strength and can be removed and stacked out of the press. Twenty four hours of cure is recommended before further machining. Three or four days may be required to eliminate sunken joints caused by residual moisture in the glue line.

**Minimum Use Temperature:** Curing temperatures should be higher than the minimum use temperature of the adhesive. This includes the temperature of the stock to be glued as well as the air and adhesive temperatures. If the temperatures are below the minimum use temperatures you will see a white, chalky appearance of the glue line. These bonds are usually weak.

**RF cure time:** Radio frequency cure times will vary from machine to machine. Machine manufacturers suggest that machines will cure between 75 and 100 square inches of glue line per minute per kilowatt. Glue joints should feel warm immediately after the cure cycle. Cure times should be determined through plant trials.

**Hot Press time:** Press time is dependent on the adhesive used, gluing stock type, moisture content of the stock and environmental conditions. This hot press schedule is provided as a recommended starting point. In plant testing is recommended especially for temperatures and substrate thicknesses beyond this chart.

		Platen Temperature °F									
		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"

**Clean-up:** For easy removal of adhesive from equipment, clean up while it is still wet with warm water (this includes the glue roller and pans). For dried glue, steam and or hot water are the most effective. Using glue release agents on equipment will also allow for easier clean up.

## STORAGE AND HANDLING

**Shelf life:** Best if used within twelve months of date of manufacture. Product increases in viscosity with age and temperature but can be mixed to bring it back to manageable viscosity for application. The performance is not affected. Product is freeze-thaw stable, but may need to be mixed prior to use.

For additional questions, Franklin's technical service team is available at 1.800.877.4583. **24/7** technical service is available online at [www.franklinadhesivesandpolymers.com](http://www.franklinadhesivesandpolymers.com).

### IMPORTANT NOTICE TO CUSTOMER:

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