



Adhesin® 7709TG

TYPE OF ADHESIVE:	Water-based Vinyl Adhesive
FIELD OF APPLICATION:	Post Forming
BENEFITS:	Fast Setting Solvent Free Excellent Mileage Good uniform coverage Excellent for high-speed post forming applications Extremely low VOC content

TYPICAL TECHNICAL DATA:

Color:	Green	
Coverage:	265ft ² @ 6 wet mils	
Freeze/Thaw Stability:	Not Stable	Protect from freezing
pH:	5.0	
Recommended Deposition	6-7 wet mils	
Solids:	57%	
Viscosity:	2400 cps	
Weight/Gal:	9.07 lbs/gal	

APPLICATION:

A post-formable vinyl acetate adhesive designed for immediate bonding of HPL to particleboard, MDF, plywood and wood. Product can be sprayed or roll coated and processed by dead stacking, nip rolling and stacking, hot laminated and hot pressed. Excellent bond adhesion to a variety of substrates including, but not limited to decorative laminates, particleboard, and plywood. Provides good uniform coverage in hand and automatic spray applications

POSTFORMING

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminates.
2. The adhesive should be applied at a coating weight of 4.5 dry grams per sq. ft. or 3 mils on both the core and the HPL by spray application or roll coating, with 100% coverage on the post form radius and edges. The approximate atomization pressure at the gun should be 40 to 60 psi and the approximate fluid pressure should be 25 to 30 psi.
3. The HPL and core are to be dried by processing through a drying oven. The adhesive should appear to be approximately 50% clear and 50% opaque when exiting the drying oven. The post form radius and edges should be completely dry or clear.
4. The HPL and core should be indexed and pinch rolled with a temperature of each between 110^oF - 120^oF. Failure to pinch roll at the recommended temperatures may result in spotty or no bond.

5. The edges of the core to be post formed should not have any wet spots. The top can now be post formed through any commercially available flow through post former.

PANEL ASSEMBLY BY ROLL COATING

1. Substrates to be bonded should be clean and free from moisture, dirt, oil and other contaminants.
2. Adhesive film thickness should be set to a depth of 6 to 8 wet mils. With this application, the adhesive may be applied to one substrate.
3. Index the HPL to the particleboard or plywood core as the substrates exits the roll coater.
4. At this point, the panel can be:
 - a: dead stacked
 - b: pinch rolled and stacked for 30 minutes before processing
 - c: processed through a pinch roll/hot laminating system, allowing immediate processing after the panel has cooled
 - d: hot pressed for a period of 1 - 2 minutes at approximately 180°F - 200°F, allowing immediate processing after the panel has cooled

RECOMMENDED AUTOMATIC SPRAY EQUIPMENT

	Binks	DeVilbiss
Spray Gun	61, 95A, 610	AGX
Fluid Tip	66SS, 67SS, 68SS	E, D, AC
Fluid Needle	765, 767, 768	E, D, AC
Air Cap	66SD-3, 67PB, 68PB	770, 64HD, 62HD

Spray equipment must have stainless steel fittings, passages, fluid tips and needles. Fluid lines can be nylon lined or PVC. This material can be pumped with a double diaphragm pump or a piston pump.

HANDLING:

CLEAN UP: Use water when the adhesive is wet and solvent when the adhesive is dry.

DISPOSAL: Dry adhesive residue is usually not considered to be hazardous waste. Do not flush or pour wet adhesive into the sewer adhesive without authorization from local authorities. Thinning the adhesive is not recommended.

PRECAUTIONS:

Please refer to the Material Safety Data Sheet for further safety information.

PACKAGING:

- 5-gallon Pails
- 55-gallon Drums
- 330-gallon Totes

STORAGE CONDITIONS:

Keep Adhesive container closed tightly when not in use. Containers should be stored on pallets away from outside walls and off concrete floors. Closed, lined containers where temperature will not be less than 50°F and should not exceed 90°F. Product should not be stored in direct sunlight. Product should not be used after freezing.

Shelf Life: 1 year

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