

# **MEKOL 1001**

## glue for assembly gluing

**DESCRIPTION** MEKOL 1001 is dispersion glue for gluing of low density wood.

FIELDS OF APPLICATION

 surface gluing of high pressure laminates, polystyrene on wooden substrates and other porous materials

- veneering,

- surface gluing of particleboard to particleboard, fiberboard to fiberboard

- assembly bonding (manual doweling)

corestock composing

- block gluing of low density wood

**CHARACTERISTICS** 

Base: PVAC dispersion

Color: white, dry film transparent

Setting time: medium

Viscosity at 23°C

(ISO 2555-Brookfield RVT, spindle **5/20** rpm): 9000 – 12 000 mPa s pH - value (ISO 976): approx. 6,6
Chalk point approx. +5,0°C
Open time at 20°C, 65% RH, beech wood with 10% moisture content:

-applied quantity 100 g/m<sup>2</sup> approx. 4 minutes -applied quantity 200 g/m<sup>2</sup> approx. 12 minutes

DANGEROUS GOODS
CLASSIFICATION

**DANGEROUS GOODS** The product is not classified as dangerous.

#### **APPLICATION**

After longer storing period good stirring of the adhesive is recommended.

The surfaces to be bonded must be straight, smooth, dry, free from dust, grease or other dirtiness.

Application methods:

- manually with paint brush, spatula or glue roller

- automatically with glue application devices (rollers, nozzles)

Single-sided application of the glue in thin layer, uniformly around the whole gluing surface is usually sufficient. Two-sided application is recommended to obtain a higher bond strength. Thus the open time is prolonged, too.

Too much glue applied - specially by veneering in hot presses, could cause penetration of the glue through veneer.

The glued surfaces must be joined together during the open time. By veneering, the pressure must be applied before the open time is finished.

## The most convenient binding conditions are:

temperature of environment, wood and glue involved	18 - 20°C
relative humidity	50 - 60 %
moisture content of wood	8 - 10 %

applied quantity

• veneering
 • other
 100 - 150 g/m²
 150 - 200 g/m²

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pressure

veneering min. 0,2 N/mm²
 other gluings min. 0,5 N/mm²

#### The pressure time:

depends on temperature of gluing (environment, wood, glue), humidity and type of wood, pressure, and spread quantity. Considering the most convenient conditions mentioned, the pressing times should be at least:

		at least:
veneering (thickness 0,6 to 0,8 mm)	at 20°C	25 - 30 minutes
	at 50°C	8 - 12 minutes
surface bonding (HPL boards, two chipboards,)	at 20°C	30 minutes
(HPL boards)	at 50°C	10 minutes
edge bonding and block gluing of soft wood	at 20°C	30 minutes
	at 50°C	8 minutes

Higher moisture content of wood, higher quantities of glue applied and / or lower temperatures of gluing as recommended require prolongation of pressing times.

### Do not process below +15°C!

Additional processing of the material should be after 24 hours.

CLEANING	Machines and equipment can be cleaned with water before the glue is dried.

PACKING	polyethylene vessels	1,0 kg net
	polyethylene vessels	5,0 kg net
	polyethylene vessels	30 kg net

other packing units according to agreement

**STORAGE** The adhesive should be stored in properly sealed containers, at temperature between +5°C

and +25°C.

Protect against frost!

Properly stored adhesive could be used at least 12 months.

After longer storing period good stirring of the adhesive before use is recommended.

The information provided herein, especially recommendations for the usage and application of our products, is based on our knowledge, results of laboratory tests and practical experience gained to date.

We guarantee a constant quality of our products under our technical specifications. Technical advice of our application department is available without obligation. This does not release the buyer from testing our products in his own responsibility with respect to their suitability for intended application and application process. Such an evaluation should be repeated if materials are changed in any way or bought from a different source.

We do not accept any liability with regard to above information or with regard to any verbal recommendation since different materials used in conjunction with our products as well as varying working conditions are beyond our control.

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