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^2	approx. 4 minutes
-applied quantity 200 g/m^2	approx. 12 minutes

DANGEROUS GOODS CLASSIFICATION

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	100 - 150 g/m^2
• other	150 - 200 g/m^2

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pressure

• veneering	min. 0,2 N/mm^2
• other gluings	min. 0,5 N/mm^2

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.

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