

MEKOL EKSPRES

adhesive for fast gluing of wood

DESCRIPTION MEKOL EKSPRES is dispersion PVAc adhesive for fast assembly and block gluing of wood requiring very strong joints, resistance to humidity and solvent resistance.

FIELDS OF APPLICATION The glue is used for:

- bonding of chairs and couches and upholstery furniture frames
- assembly bonding (joints such as dowel, mortise and tenon, panel and groove, dovetail, corner block, miter, cleat)
- block bonding of soft and hard wood
- where higher resistance of joints to humidity (places with periodically high relative air humidity) or solvents is required

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| CHARACTERISTICS | Base | PVAc dispersion |
| | Colour | beige (imitation oak) |
| | Setting time | fast |
| | Viscosity at 23°C (ISO 2555-Brookfield RVT, spindle 5/ 20 rpm) | 7 000 - 10 000 mPa s |
| | pH - value (ISO 1148) | approx. 4,6 |
| | Chalk point | approx. 5°C |
| | Open time at 20°C, 65% RH, beech wood with 10% moisture content: | |
| | -spread quantity 100 g/m ² | approx. 3 minutes |
| | -spread quantity 200 g/m ² | approx. 7 minutes |
| | Dangerous Goods Classification | none (according to Slovenian legislation) |

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 (sharp tool), dry, free from dust, grease or other dirtiness. Suitable for the usual equipment. Application methods:

- manually with squeeze bottle, paint brush, spatula or glue roller
- automatically with glue application devices (nozzles, plugged pipes, rollers)

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 (high burdened joints, joints with tenons).

The most convenient binding conditions are:

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| temperature of environment, wood and glue involved | 18 - 20°C |
| relative humidity | 60 - 70 % |
| moisture content of wood | 8 - 10 % |
| applied quantity | 150 - 200 g/m ² |
| | pressure |
| | 0,2 N/mm ² |
| | 0,5 N/mm |

- Soft wood
- Hard wood

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: |
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| block gluings (soft/hard wood) | at 20°C | 15 / 30 minutes |
| | at 50°C | 3 / 5 minutes |
| assembly bonding (dowels, tenors...) corpus | at 20°C | 3 - 6 minutes |
| | at 20°C | 10 – 12 minutes |

Higher moisture content of wood, higher quantities of glue applied and / or lower temperatures of gluing as recommended require prolongation of pressing times. Prolongation of pressing time will be advantageous for high burdened joints, too.

Do not process below +15°C!

Additional processing of the material should be after 12 hours.

CLEANING

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

PACKING

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| polyethylene vessels | 500 g net |
| polyethylene vessels | 5 kg net |
| polyethylene vessels | 15 kg net |

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 18 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.

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