

Description

AV 180 is a unique one pack water based adhesive which has been designed to complement the high quality properties of MDF Board. **AV 180** has fast 'wet tack', is quick drying and has excellent machining and sanding properties. The bonds formed are very strong and heat resistant and the glue line will accept the stains and lacquers recommended for MDF Board.

Features

- Very High Bond Strength
- Non flammable.
- Clean Up with water
- Single Pack

Recommended Uses

- Assembly and joining of MDF board for furniture and cabinet making
- Laminating MDF Board for turning and shaping
- Bonding of Pine timber in furniture manufacture



Application Instructions

Ensure adequate tests are conducted before using commercially. Mix thoroughly before use.

Surface Preparation

Wood surfaces to be glued must be clean, dry, free of dust, oil, grease and all finishes.

Joints should be close fitting.

The work area, glue and substrate for bonding should be at least 15°C.

The moisture content of the wood should be between 8% and 12%.

Application Instructions

1. Apply adhesive to both surfaces at between 3-5m²/Litre of glue and clamp assembly firmly and evenly while adhesive is still wet.
2. Clamps may be removed after a minimum of 1 hour at 20°C, depending on the moisture content/density of the materials being bonded.
3. Assembled parts should be left 24 hours to allow for complete curing of the glue line before further processing.
4. Any squeeze out of the adhesive from the joint, can be removed with a clean damp cloth prior to setting or sanded off after complete cure. The method is chosen to suit the application.

It is recommended that trials be conducted to determine the clamp time for a particular species / substrate.

Clamping Pressures

MDF Board - Normal assembly pressures are sufficient for furniture manufacture.

Softwood 50 PSI

Hardwoods 150 PSI

i.e. enough pressure to bring joints tightly together with some glue "squeeze out".

Limitations

Do not use for structural or load bearing applications.

Properties

Type	Proprietary	Open Assembly Time	3 mins @20°C
Solids	Medium	Closed Assembly Time	10 mins @20°C
Viscosity	Medium	Clamp Time	30 – 60 mins @ 20°C depending on substrate (Dense –60mins)

Storage & Shelf Life

Store in a cool, dry place, out of direct sunlight. Storage areas must be well ventilated and comply with Local, State and Federal regulations. For maximum shelf life, store between 5° and 20°C.

Shelf life is up to 12 months when stored in original, unopened containers, under the above conditions.

Health & Safety

Please refer to the Material Safety Data Sheet which is available on request or can be downloaded from www.bostik.com.au

Clean-Up

Wipe excess glue from joints with clean wet cloth before glue sets. Clean up excess and equipment with water prior to setting.

VOC 33 g/Lt

voccertificates.australia@bostik.com

Product Details

Item Number	Size	Colour	Pack Quantity
910070	5 Litre		4
910071	20 Litre		

The representations and recommendations regarding the products are based on tests which we believe to be reliable. However, no guarantee of their accuracy can be made because of the great range of field conditions and variations encountered in raw materials, manufacturing equipment and methods. Thus, the products are sold with a limited warranty only, and on the condition that purchasers will make their own tests to determine the suitability of the product for their particular purposes. Under no circumstances will Bostik Australia Pty Ltd be liable to anyone except for replacement of the products or refund of the purchase price.

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BOSTIK AUSTRALIA PTY LTD**

Head Office Bostik Australia Pty Ltd, 51-71 High Street, Thomastown Vic 3074
A.B.N. 79 003 893 838
Phone: (03) 9279 9333 Fax: (03) 9261 4744
Phone Industrial: Toll free 1300 560 799



Quality
ISO 9001

SAI GLOBAL

Quality endorsed ISO9001 (Thomastown site)
TS16949 (Automotive).

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