



Laminating 50

LAMINATING 50 is a vinyl acetate copolymer adhesive designed to bond HPL to particleboard and fiberboard. It can be used in a variety of ways including continuous heated-panel laminating systems, pinch roll and dead stack or limited lay-up time cold-press operations. The adhesive has high green strength and tensile strength.

PHYSICAL PROPERTIES

Chemical family description: Vinyl acetate copolymer

Appearance: Pink-colored

Typical viscosity (cps): 2350 - 3550 cps (4/60/73°F)

Weight solids (%): 52.0 - 54.0%

pH: 4.0 - 5.5

Specific gravity: 1.09 **Weight pounds per gallon:** 9.07

Suggested minimum use temperature: 41.7°F/ 5.4°C



KEY PRODUCT FEATURES

- Excellent in heated nip roll and dead stack operations
- Can be cold pressed
- Can be applied by spraying
- Great green strength and tensile strength

APPLICATION GUIDELINES

Spread: Generally, 22 - 29 pounds of adhesive per 1,000 square feet or 10–13 grams per square foot of glue line is adequate. Verify adequate glue coverage by monitoring for squeeze out along the glue line once the panels are under pressure. A Web-based spread calculator can be found at www.franklinadhesivesandpolymers.com.

Assembly time: The assembly time is influenced by many factors some of which include glue spread, moisture content of the stock, porosity of the stock, environmental conditions and adhesive choice. Assembly times of five to ten minutes are approximate. It is desirable to see a bead of adhesive squeeze out around the perimeter of the bottom panel of the stack.

Press/ clamp time: Press times are dependent on the adhesive used, gluing stock type, moisture content of the stock, and environmental conditions. Press times can range from 30 to 60 minutes. It is recommended that optimum press times be determined in actual plant conditions recognizing that seasonal changes may lead to variable requirements.

Machining/ post process conditioning: After the minimum clamping time period, the panel will develop enough handling strength and can be removed and stacked or machined out of the press. In twenty-four hours full cure is achieved.

Minimum use temperature: Curing temperatures should be higher than the minimum use temperature of the adhesive. This includes the temperature of the stock to be glued as well as the air and adhesive temperatures. If the temperatures are below the minimum use temperatures you will see a white, chalky appearance of the glueline. These bonds are usually weak.

Clean-up: For easy removal of adhesive from equipment, clean up while it is still wet with warm water (this includes the glue roller and pans). For dried glue, steam and or hot water are the most effective. Using glue release agents on equipment will also allow for easier clean up.

STORAGE AND HANDLING

Shelf life: Best if used within twelve months of date of manufacture. Mix before use. Product is not freeze thaw stable. Frozen product will have a separated and or lumpy appearance.

For additional questions, Franklin's technical service team is available at 1.800.877.4583. **24/7** technical service is available online at www.franklinadhesivesandpolymers.com.

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