



PIDILITE INDUSTRIES LIMITED

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TECHNICAL DATA SHEET

Fevicol X-Pres

Fevicol X-Pres is moisture – curing single component polyurethane adhesive, specially designed for wood to wood bonding applications and other wood to non wood applications used to make varieties of furniture. Fevicol X-Pres is D4 categories of adhesive having, an excellent boiling water resistance as well as normal water resistance.

It also provides high heat resistance. It is reinforced low foaming adhesive having excellent adhesion on numerous substrates.

PROPERTIES OF THE ADHESIVE

- Appearance : Pale yellow Liquid
- Viscosity @ 30 deg. C : 50 - 90 poise
- Open time : 8 to 9 minutes @ 30 deg. C.
- Handling time (Declamping time for wood to wood joint) : within 15 to 20 minutes especially in Teak and other soft wood..

FIELDS OF APPLICATION

Field of Application:-

Typical applications like Edge to Edge wood to wood joints and Different Joint applications like Tenon and Morist Joint, Tongue and Grove Joints etc. in making all types of wooden based furniture like Bed, Dining table, Chairs, Frames of window and Doors, Solid panel door, and wooden staircases where it gives an exceptionally high mechanical strength.

Other Applications:-

- Granite to Plywood / Wood and Marble to Plywood / Wood in Kitchen and other furniture applications
- Glass to Plywood / Wood to make glass frame and mirror fixing.
- Wood to Concrete in skirting application.

Characteristic and Advantage of the product:-

- Excellent weather resistance as it provided extremely high boiling water and normal water resistance
- Optimum heat resistance.
- Rapid setting adhesive that sets within 15 minutes of clamping and provided early initial handling strength which helps to de-clamp the assembly very fast and use the free clamp for next job.
- Improve the productivity as fast setting time of the glue , allows in doing subsequent job of sending, cutting etc.
- The glue lie is easily sandable and dark black Glue line is not visible post staining.
- 100% active ingredient. Does not contain water or solvent, hence recommend to use in single side.
- Higher strength and high coverage: Being a non water and non solvent based glue, it provides optimum strength in single side application and providing higher coverage which is almost 2.5 times higher than other two parts - Epoxy adhesive which is required to apply on double side in same wood to wood joint application.
- Wastage minimized: can be applied by nozzle at the required spot.

Application Technique for Wood to Wood Joint:-

- Applicator: - Plastic squeeze bottle. Spatula, Hand Roller

Application Process:-

- Surface to be bonded should be dry, clean, and free from oil or grease.
- Open the bottle lid by turning the yellow top anti-clockwise.
- Apply glue on one edge surface of the one wood substrate / panel /plank / joint in a thin layer by pressing the bottle downwards. Spread the glue uniformly on the edge with the help of spreader.
- Close the bottle lid after application by turning the top clockwise.
- Damped the edge surface of opposite / second wooden substrate / panel /plank / joint by spraying water or wiping with wet cloth.
- Bring the other edge of wood substrate close to it to assemble & clamp them firmly.
- Leave the assembly to set. For 15 minutes (in case of all teak woods and other soft woods) then de-clamp the substrates after 15 minutes and keep the assembly aside in free condition for another 35 to 45 minutes.
- A very strong bond will be obtained after above steps while allow to do subsequent job like sanding, cutting etc.
- **Clamping:-**
- For sufficient contact of adhesive to the substrate under curing condition, adequate pressure through mechanized clamp is necessary. The required pressure and pressing time is dependent up on the type of wood (Hard wood, Soft wood), Porosity of the substrate (Porous and Non Porous) and size (length and width) of the material.
- **Cleaning:-**
- Excess or ooze out hardened adhesive can be mechanically removed softly. Application tool and machine parts can also be clean mechanically.

PRODUCT GUIDELINES

STORAGE

Fevicol X-Pres can be stored for 6 months in its original packing (unopened container) Store in cool & dry place away from the sunlight in tightly closed condition. Opened containers should be used up as soon as possible

PRECAUTIONS

- The container should be capped immediately after use to avoid exposure to humidity.

PACKING

- In plastic bottles of 500 Gms.

Always consult the material safety data sheet before use of the product.

NOTE

The Product information & application details given by the company & its agents has been provided in good faith and meant to serve only as a general guideline during usage. Users are advised to carry out tests & take trials to ensure on the suitability of products meeting their requirement prior to full scale usage of our products. Since the correct identification of the problems, quality of other materials used and on-site workmanship are factors beyond our control, there are no expresses or implied guarantee/ warranty as to the results obtained. The company does not assume any liability or any consequential damage for unsatisfactory results, arising from the use of our products