



PIDILITE INDUSTRIES LIMITED

Marketing Division: P.B. No. 17411, Andheri (East), Mumbai 400 059 (India)

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TECHNICAL DATA SHEET

FEVICOL MEMBRANE PRESS ADHESIVE LC

Fevicol Membrane Press LC is a water based adhesive for wrapping of PVC foils by the Vacuum or Membrane Press method. It can be used either alone or in combination of hardener. The heat resistance and water resistance can be enhanced by addition of 5% hardener.

ADHESIVE PROPERTIES

Base:-	: Specially modified co-polymer emulsion
Colour: -	: Milky white
Solids :-	: 48 - 52 %
pH :-	: 4 - 6
Viscosity: -	: 5 - 15 Poise @30°C
Sealing temperature the glue line:-	: 60-70 °C
Air-pressure of gun:	: 2 - 4 bar (28 to 58 psi)
Nozzle diameter:	: 1.5-2 mm
Drying time: -	: approx 30-40 minutes depending on temperature, humidity and applied quantity.

FIELDS OF APPLICATION : For bonding PVC foil to MDF and particle board in membrane press machine.

APPLICATION METHODS :

- First weigh desired quantity of resin in small container and add 5 % of hardener in it.
- Stir the Material before use and add Universal Tinter if colored shade is required to identify the spray pattern and its intensity.
- Filter the solution using small metal based sieve having narrow mesh size.
- Surfaces to be bonded should be clean, dry and free from oil, dust and grease.
- The working temperature of the glue and work piece should be over 15°C

- Pour the mixture in the clean spray gun with clean nozzle of 1.5 to 2 mm & close the lid tightly. Start compressor & adjust the pressure to 2 to 4 bar
- Spray the mixture from the distance of about 8 to 10 inches on MDF, & let it dry for about 20 to 30 minutes, till the surface becomes tack dry.
- For flat surface one coat is sufficient. For open pores inner and edges double coat is required after complete drying of first coat.
- Pre-glued pieces should be sealed within 24 hrs for optimum bonding.
- Curing time is 24 hrs and complete cure will be obtained after 7days.

PRODUCT ADVANTAGES:

- Water based product having low VOC, can consider as a Green product.
- Low Viscosity water based product, No need to add any thinner (which is required in solvent based system).
- Longer Pot Life: - 3 to 4 Hrs at 30 Deg C after addition of 5 % hardener.
- Due to special chemical formulation, this two component system gives excellent heat resistance and water resistance compared to solvent based adhesive.
- Easy Cleaning: - After the application, spray gun should be clean using normal water to avoid blockage of nozzle. No need to use any solvent, thinner etc.
- Higher coverage i.e. 6 to 7 Doors production with 1 Lts. in comparison to 4 to 5 doors in Solvent based system.

PRODUCT COMPLIANCE

GREEN BUILDING NORM: (LOW VOC)

PRODUCT GUIDELINES

STORAGE : Glue should be stored in closed original container above 5°C and below 40° C. Always close the lid of the container after taking out required quantity of glue.

SHELF LIFE : Six months from the date of manufacturing in sealed original container under proper storage conditions

SAFETY and HANDLING : Resin is non-toxic, non-flammable. Should be applied in well-ventilated area. Flush skin with soap and water. Seek medical help if necessary.

PACKING : 32 kg .

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.
