

Melamine Adhesive

Trade Essentials Melamine Adhesive is an emulsion adhesive for the bonding of synthetic laminated (non-porous) board to timber, Particleboard, Craftwood and other porous surfaces. It is an excellent adhesive for a variety of laminates including DAP, melamine and vinyl coated board. Melamine Adhesive dries to a clear glue line.



APPLICATIONS

Melamine Adhesive is widely used in cabinet making for assembly of laminated board with traditional fittings such as dowels, cams, staples and screws. It is a versatile adhesive that will also bond a variety of porous materials such as timber, particleboard, MDF board and Craftwood to non-porous substrates such as rigid foam, melamine surfaces and cultured marble.

PROPERTIES

Colour	White Liquid, dries clear
Solids	High (approx. 50%)
Viscosity	3,500 cps
Open Assembly Time	5 mins. maximum at 20°C
Closed Assembly Time	10 mins. maximum at 20°C
Clamp Time	4 hours minimum
ASW	945627 (5 litre) 945629 (20 litre)

DIRECTIONS

- Melamine Adhesive can be applied using a roller, spray, brush or squeeze bottle.
- Melamine Adhesive should be used as supplied. Dilution is not recommended.
- All surfaces to be bonded must be clean, dry and free from dust, oil, grease etc.
- Ambient and panel temperatures should be above 10°C.

- Adhesive should be applied as a thin, even coating to particleboard or MDF surface. Parts should be combined, while the adhesive is wet, using good even pressure (30 to 130 psi recommended) until the adhesive has set.
- With these joints it is also preferable to rub the bead of the glue into the end grain of the particleboard – commonly known as a rub joint. In the dowel application, the glue should be run on the laminated surface and inserted into the dowel holes. Optimum bond strength is obtained after 24 hours assembly.
- Parts should be clamped overnight.
- Excessive adhesive can be removed with a damp cloth while adhesive is still wet.

STORAGE

Keep containers sealed and away from direct sunlight. Recommended storage temperature is 5-30°C.

Melamine Adhesive is suitable for packing into tubes for ready-to-assemble furniture. Melamine Adhesive has a storage life of 12 months.

Material Safety Data Sheet is available on request.

LIMITATIONS

Melamine Adhesive should not be used when timber or ambient temperatures are below 10°C.

Melamine Adhesive is not suitable for load bearing applications. Melamine Adhesive is not recommended for bonding melamine to melamine.

Adhesive Selection Guide

Page 136

Safety & Usage Recommendations for PVA & Water Based Adhesives

Appendix 5 Safety & Usage
Page 166