

# 303

## CLEAR MELAMINE GLUE

## Technical Data Sheet

ISSUED: December 2016

### DESCRIPTION

TAC ADHESIVES - 303 CLEAR MELAMINE GLUE is a high quality synthetic dispersion for bonding to melamine board surfaces. The CLEAR DRYING feature allows for EASIER CLEAN UP of excess adhesive on bonded surfaces. The adhesive has high bond strength and specific adhesion to melamine face and other difficult to bond surfaces.

### FIELDS OF APPLICATION

Typically used to bond end grain to melamine face in the manufacture of cabinets, cupboards and drawers.

### APPLICATION

Coverage rate, open time and press time are dependant on type of materials to be bonded as well as workshop conditions such as temperature and humidity.

Best results are obtained under the following conditions:

Workshop, material and glue temperature: 20°C

Wood moisture: 8 - 10%

Relative humidity: 60 - 70%

Apply adhesive evenly to one surface with a squeeze bottle, brush etc.

Coverage Rate: ~ 150 g/m<sup>2</sup>

Join surfaces before end of open time.

Open Time @ 20°C: ~ 3 minutes

Press or clamp until sufficient initial strength is obtained.

Press Time @ 20°C: 2 - 4 hours

Final Bond Strength: 24 - 48 hours

### SURFACE PREPARATION

Surfaces to be bonded should be clean and free from oil, dust and other foreign materials. Ensure surfaces fit together exactly to avoid extended drying times and reduced bond strength.

### CLEAN UP

Use warm soapy water to clean tools before adhesive dries.

### TECHNICAL DATA

Base: Synthetic Resin dispersion

Colour: White (DRIES CLEAR)

Viscosity: Thin cream

Solids: High

Pack Sizes: 5 and 20Litre

Best Before: 12 months

### STORAGE

Store under cover, out of direct sunlight in tightly closed original containers. Do not freeze.

### FIRST AID

If swallowed, DO NOT induce vomiting. Give a glass of water. If in eyes, hold eyes open, flood with water for at least 15 minutes and see a doctor. Refer to Safety Data Sheet for further information.

The information contained in this technical data sheet is based on our present knowledge and experience. They may be considered only as guidelines as many factors can affect processing and application. Users should determine the suitability of the product by means of their own tests for its intended application.

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