

Technical Information leaflet

Assembly times for Prefere 4720 separate application - Guidelines

Factors influencing the assembly time

The below mentioned data are in combination with our Prefere 4720 and based on both laboratory tests and information gained from various customer trials. The mentioned temperatures refer to the glue line temperatures. The glue line temperatures are determined mainly by the temperature of the wood, of the air and of the glue mix temperature.

Of course, the above indicated assembly times can be influenced by several parameters, which can vary from factory to factory. Parameters that can lead to shorter assembly times can be:

- Higher lamellar temperature
- Lower moisture content in the wood
- Lower relative humidity in the air
- Higher air speed or draft
- Open assembly time
- Rougher surface planing
- No cooling of the glue
- Bad coverage of the hardener by the glue
- Lower glue spread
- Too high dosing of hardener*

Recommendations

Keep the air moisture levels up (moisturizers especially in the area of the gluing and pressing activities). Avoid bad planning quality. Rough surface by bad planning will cause easier penetration of the glue mix into the wood and thereby quicker dry-out.

Prevent draft or higher air speed in the factory.

Increase the amount of applied glue and hardener for those beams that needs longer assembly times (switch of the glue reduction system and apply between 450-500 gr/m²).

Open assembly time should be as short as possible. Long open assembly time will shorten the closed assembly time.

Assembly times for separate application

20°C		Maximum closed assembly time in minutes		
		30 pbw	50 pbw	100 pbw
Prefere 5020	250g/m ²	90	60	40
Prefere 5020	350g/m ²	110	90	60

25°C		Maximum closed assembly time in minutes		
		30 pbw	50 pbw	100pbw
Prefere 5020	350g/m2	95	70	45
Prefere 5020	450g/m2	105	80	55

30°C		Maximum closed assembly time in minutes		
		30 pbw	50 pbw	100 pbw
Prefere 5020	350g/m2	75	50	35
Prefere 5020	450g/m2	85	60	40

* Too long assembly time can be detected by shiny and hard glue lines due to pre-cure or drying out. The difference between pre-cure and drying out can again be detected by the following method: Rub a wet finger on the glue line (before pressing!). If the adhesive reverts to a sticky form, it is most probably drying out.

Pre-cure is most influenced by the amount of hardener and the temperature.

Drying out is most influenced by the air humidity, wood moisture content and glue spread.

Replaces edition April 2008.

RB/ EMØ 18.03.2010