

# EVO-STIK 9517

## WATER BASED ADHESIVE

**EVO-STIK 9517** is a ready for use, fast setting; single part curing polyvinyl acetate based emulsion.

### RECOMMENDED USE

**EVO-STIK 9517** is a multipurpose, water resistant adhesive, which conforms to the D3 requirements of EN204, it may be further cross linked by the addition of **BOSTIKURE W** to achieve EN204 D4. It also meets the requirements of BS4071 Part 5 sustained load resistance.

**EVO-STIK 9517** is suitable for general assembly and lamination on particleboard and MDF.

### BONDING INSTRUCTIONS

#### Working conditions:

Minimum temperature for use	12°C
Ambient temperature (warehouse, wood, laminates, adhesive)	18 - 20°C
Humidity of wooden substrates	8 - 12%

#### Coating weight:

Flat lamination, paper (single face coverage)	20 - 70g/m <sup>2</sup>
Flat lamination, HPL, thick foils (single face coverage)	100 - 200g/m <sup>2</sup>
Assembly (single face coverage)	150 - 200g/m <sup>2</sup>

#### Assembly time:

4 - 8 min

#### Pressure:

Wood on wood	2 - 5 bar (kgf/cm <sup>2</sup> )
Laminates on wood	1 - 2 bar (kgf/cm <sup>2</sup> )

#### Pressing time (minimum):

Wood on wood at 20°C	10 - 15 min
Assemblies with one face preheated	2 - 3 min
Laminates on wood at 20°C	20 - 30 min
Laminates on wood at 80°C	3 - 4 min

#### Stabilisation:

Before machining	2 hours (minimum)
Complete setting of adhesive	at least 24 hours
D3 water resistance	at least 1 week

### SURFACE PREPARATION

- Substrates to be bonded should be perfectly clean, dry and free from dust and grease.
- For laminations, surfaces should be homogeneous and flat.
- Assemblies should be precise in order to avoid thick adhesive lines (0.2 - 0.3mm max.).
- Wood should be allowed to condition for several days in the workshop atmosphere (15 - 20°C) before bonding. Its relative humidity should be approx. 10 - 20%.

### APPLICATION

- For lamination apply an even coat of adhesive to one of the substrates by roller coater, brush or spatula.
- For assembly applications we recommend that both surfaces should be coated.
- Coating weight depends on substrate, porosity, open time and ambient temperature.

General features

Flat lamination

100 - 240 g/m<sup>2</sup>

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Panelling, edge jointing	200 - 350 g/m <sup>2</sup>
Other (motice/tenon, tongue/groove)	coat both sides

**ASSEMBLY**

- The parts to be bonded should be brought together immediately after application whilst the adhesive is still wet.
- The maximum open time depends on the substrate porosity, ambient temperature and coating weight. A guideline is given on page 1.

**PRESSING**

- After assembly pressure should be maintained during the adhesive's initial setting period, using conventional pressing methods such as presses, vices, jigs clamps or dead loads. Refer to the pressure values given on page 1. This is not necessary for finger joints.
- Pressing time depends on such variables as ambient temperature and humidity, coating weight, porosity of substrates and dimensions of assemblies. Reference values are given on page 1 but a test specimen will allow this to be calculated.
- Pressing time can be reduced by heating one substrate to be bonded before pressing at room temperature. We recommend pre-heating of the surface (1 - 2 minutes at 80°C).
- Hot pressing should only be recommended for double sided flat lamination.

**FOR ENHANCED WATER RESISTANCE (EN204-D4)**

- Add 5% **BOSTIKURE W** slowly whilst stirring, it should be mixed thoroughly using a mechanical stirrer for at least 10 minutes. It is important to completely disperse the hardener
- The chemical reaction between the hardener and the adhesive produces carbon dioxide therefore the container should never be tightly closed
- Pot life of adhesive mixture is dependent on ambient temperature, as the temperature increases the pot life decreases
- Viscosity does not increase significantly during pot life; the mixture may still be liquid after 24 hours but should not be used.
- Pot life of adhesive mixture at 20°C is approx. 8 hours

**GENERAL PRECAUTIONS**

- Do not add anything to the adhesive to modify its properties
- Provided contact with iron is avoided the adhesive should not cause staining.
- After each use close the container tightly to avoid skin formation.
- Coating equipment and tools can be cleaned with warm water, before the adhesive has dried out.
- For health, safety and disposal please refer to the material safety data sheet.

**TYPICAL CHARACTERISTICS**

Physical Form:	Viscous liquid
Colour:	White
Viscosity (Brookfield RVT, 20rpm, at 23°C):	Approx. 12000mPas
Specific Gravity:	Approx. 1.10

**PACKAGING**

Please refer to Customer Service Department for current package sizes.

**STORAGE**

Store in original packaging between 5 and 30°C. **Protect from frost.** After prolonged storage stir well before use.

**SHELF LIFE**

Under the above storage conditions, 12 months closed in its original packaging

**MATERIAL SAFETY DATA**

For further information refer to the relevant Health and Safety Data Sheet.

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