

AQUENCE FD 1054Known As: Dorus FD 1054
August 2015**Description:**

AQUENCE FD 1054 is a formulated synthetic adhesive for wrapping PVC foils onto profiled wooden panels. Excellent spraying properties with fast drying characteristics ideal for membrane pressing. Once applied boards can be stacked without blocking and can be pressed within 30 minutes. Low telegraphing is observed when using this product.

Typical Properties:

Appearance:	White.
Odour:	Low
Viscosity:	Approx. 1200 cP at 23°C
Solids:	Approx. 41%
pH:	Approx. 8.0

Directions for Use:

AQUENCE FD 1054 is best applied using air spray equipment (HVLP or conventional), preferably of stainless steel and incorporating inline filters. Particular care is required when spraying edges or curved surfaces to ensure sufficient coat weight is applied.

AQUENCE FD 1054 can be used as a one part adhesive. If additional heat resistance is required then a 5% addition of AQUENCE CATALYST 6920 may be added and thoroughly mixed using a mechanical stirrer (minimum 5 minutes @ approx. 500rpm). Once the adhesive and catalyst are mixed the adhesive should be applied within 4 hours (under normal conditions the pot life of the mix is <8 hours).

Mixing ratios

Aquence FD 1054	Aquence Catalyst 6920
1 litre	50 ml
2 litres	100 ml
5 litres	250 ml
10 litres	500 ml
20 litres	1 litre

When the adhesive has been sprayed onto the board it is best to reactivate within 4 hours to achieve maximum bond strength. Adhesive may be reactivated up to 8 hours after spraying but longer press times and/or higher press temperature may be required.

The following table outlines ideal application conditions

Substrate Temperature (°C)		15 - 20
Wood Moisture Content (%)		8 - 12
Adhesive coating weight (gsm)	Flat Surface	60 – 90
	Contoured surface and edges	80 – 130
Press Pressure (kg/cm ²)		Up to 18
Minimum Press temperature (°C)		75
Press time @ 80°C (minutes)		0.5 - 5

Supplementary Products:

Previously called Dorus FD 1054.
Catalyst – Aquence Catalyst 6920

Clean Up:

With water whilst wet.

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Storage and Handling:

Please read the Material Safety Data Sheet for this product BEFORE use.

Product should be stored between 5°C and 30°C on a wooden pallet and kept from freezing. Rotate stock using oldest material first. Keep stock covered to prevent drying out and contamination. Do not mix with other adhesives. Supplied ready for use but can be diluted with water if required.

Please ensure that products classed as a dangerous good are stored in compliance with the applicable regulations.

Shelf Life:

Best used within 6 months from date of manufacture when stored under the above conditions in the original unopened containers.

Last Updated: 08-07-2015

DISCLAIMER

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