



Advantage XB-9325 LFF

Advantage XB-9325 LFF is a cross-linking emulsion that once catalyzed with Catalyst M-200-L, Catalyst M-172L, Catalyst M 318LY or Catalyst M-188-L provides excellent water resistance for use as a wood adhesive. It is designed for cold weather finger jointing but is also excellent for other cold set applications as well as for hot pressing and radio-frequency (RF) curing.

PHYSICAL PROPERTIES

Chemical family description: Crosslinking PVAc

Appearance: Color - Wet White

- Dry Translucent/Cream

Typical viscosity (cps): 2000-2500 (LV #3/12/25°C)

Weight solids (%): ~50.0

pH: 5.2-5.5

Weight pounds per gallon: 9.2

Suggested minimum use temperature:

M-172-L, M-200-L, M 318LY 40°F

M-188-L 35°F

PERFORMANCE PROPERTIES

- Meets requirements for HPVA HP-1-2004 - Type 1
- Meets requirements for ASTM D-5751-95 (2005) - Wet Use
- Meets requirements for ASTM D-5572-95 - Wet Use
- Meets requirements for ASTM D 4317-98 (2004) - Type 1
- Meets requirements for WDMA TM-6-2007 - Type 1
- Meets requirements for WWSA 101.97 revised Aug. 1998 - Interior studs and white speck

Catalyzed Pot Life, @70°F (mix ratio 100 parts XB-9325 LFF to 5 parts Hardener):

M-172-L, 318LY 24 Hrs.

M-200-L 8 Hrs.

M-188-L 4 Hrs.

Like all adhesives, proper gluing practices are needed to achieve stated performance.

APPLICATION GUIDELINES

Moisture content: Six to eight percent is the recommended moisture content for the gluing stock. High moisture content will dramatically increase the clamp time needed. Panel shrinkage may occur resulting in stress cracks or end-joint delamination.

Stock preparation: The preparation of the stock to be glued is extremely important. Joints cut from rip saws should be free of saw marks. They should also be straight and square. Molded or jointed stock should be free of knife marks. Glazed or burnished joints will prevent adhesive penetration and should be guarded against. Gluing stock should be uniform in thickness. Variation in thickness should not exceed ± 0.005 inches/0.12 mm. Sanding to thickness should be performed using higher than 50 grit abrasives. When possible, glue joints should be prepared and glued the same day.

Spread: Generally, 35-50 pounds of adhesive per 1,000 square feet or 170-250 grams per square meter of glue line is adequate. Verify adequate glue coverage by monitoring for squeeze out along the glue line once the panels are under pressure. A Web-based spread calculator can be found at

www.franklinadhesivesandpolymers.com

Pressure: Pressure is dependent upon the species or material to be glued and joint preparation. Direct contact of the gluing surfaces is required to obtain maximum strength. The use of a compressometer will aid in accurately measuring the amount of pressure being applied to the gluing area. Suggested clamp locations for various wood densities are eight to fifteen inches (20-38 cm) apart and two inches (five cm) from the end of the panel to evenly distribute pressure along the entire length of the glue line. A Web-based pressure calculator can be found at www.franklinadhesivesandpolymers.com

Recommended clamping pressures:

<i>Species</i>	<i>Clamping pressure</i>	<i>Example</i>
<i>Low density wood species</i>	<i>100-150 psi or 7-10 kg/cm²</i>	<i>Pine, Poplar</i>
<i>Medium density species</i>	<i>125-175 psi or 9-13 kg/cm²</i>	<i>Rubberwood, Cherry</i>
<i>High density species</i>	<i>175-250 psi or 13-18 kg/cm²</i>	<i>Oak, Maple</i>

Assembly time: The assembly time is influenced by many factors some of which include glue spread, moisture content of the stock, porosity of the stock, environmental conditions and adhesive choice. Assembly times of five to ten minutes are approximate. It is desirable to see a bead of adhesive squeeze out around the perimeter of the bottom panel of the stack.

Press/ clamp time: Press times are dependent on the adhesive used, gluing stock type, moisture content of the stock and environmental conditions. Press times can range from a minimum press time of 30 minutes to greater than two hours. Shorter times are required under ideal conditions when using soft wood species at moisture content slightly less than eight to ten percent and factory temperatures of 68 degrees Fahrenheit/ 20 degrees Celsius. Longer press times will be required for higher density species, higher moisture contents and colder factory temperatures. It is recommended that optimum press times be determined in actual plant conditions recognizing that seasonal changes may lead to variable requirements.

Machining/ post process conditioning: After the minimum clamping time period, the panel will develop enough handling strength and can be removed and stacked out of the press. Twenty-four hours of cure is recommended before further machining. Three or four days may be required to eliminate sunken joints caused by residual moisture in the glue line.

Minimum use temperature: Curing temperatures should be higher than the minimum use temperature of the adhesive. This includes the temperature of the stock to be glued as well as the air and adhesive temperatures. If the temperatures are below the minimum use temperatures you will see a white, chalky appearance of the glue line. These bonds are usually weak.

Finger joint cutter-heads: Knife stack/set - be sure to check overall knife stack for accuracy. Keep cutterheads in pairs and properly cleaned. Cutter-heads should be sharpened as a set. Knife set should cut only 0.25 mm or 0.010 inches to 0.75 mm or 0.030 inches of wood.

Finger joint assembly: End pressure should be set to provide 14.0 kg/cm² - 35.0 kg/cm² or 200 - 500 psi pressure for non-structural joints. Crowder wheels should be aligned to match fingers accurately.

Finger joint adhesive application: Sufficient adhesive spread will provide a uniform coverage that should cover one-half to two-thirds the length of the finger on both sides in a thin continuous film. Make sure fingers aren't skipped and that the adhesive is applied to the whole joint, not just the tips of the fingers. Too much adhesive can cause a hydraulic effect.

RF cure time: Radio frequency cure times will vary from machine to machine. Machine manufacturers suggest that machines will cure between 75 and 100 square inches of glue line per minute per kilowatt. Glue joints should feel warm immediately after the cure cycle. Cure times should be determined through plant trials.

Press time: Press time is dependent on the adhesive used, gluing stock type, moisture content of the stock and environmental conditions. This hot press schedule is provided as a recommended starting point. In plant testing is recommended especially for temperatures and substrate thicknesses beyond this chart.

Platen Temperature °F

	160	170	180	190	200	210	220	230	240	250
Distance to Deepest Glue Line										
1/32"	1' 31"	1' 25"	1' 19"	1' 14"	1' 09"	1' 05"	1' 01"	0' 57"	0' 53"	0' 50"
1/16"	1' 53"	1' 46"	1' 39"	1' 33"	1' 27"	1' 21"	1' 16"	1' 11"	1' 07"	1' 02"
3/32"	2' 22"	2' 13"	2' 04"	1' 56"	1' 49"	1' 42"	1' 35"	1' 29"	1' 24"	1' 18"
1/8"	2' 58"	2' 46"	2' 36"	2' 26"	2' 16"	2' 08"	1' 59"	1' 52"	1' 45"	1' 38"
5/32"	3' 42"	3' 28"	3' 15"	3' 02"	2' 51"	2' 40"	2' 29"	2' 20"	2' 11"	2' 03"
3/16"	4' 38"	4' 20"	4' 03"	3' 48"	3' 33"	3' 20"	3' 07"	2' 55"	2' 44"	2' 33"
7/32"	5' 47"	5' 25"	5' 05"	4' 45"	4' 27"	4' 10"	3' 54"	3' 39"	3' 25"	3' 12"
1/4"	7' 15"	6' 47"	6' 21"	5' 57"	5' 34"	5' 13"	4' 53"	4' 34"	4' 17"	4' 00"

Clean-up: For easy removal of adhesive from equipment, clean up while it is still wet with warm water (this includes the glue roller and pans). For dried glue, steam and or hot water are the most effective. Using glue release agents on equipment will also allow for easier clean up.

STORAGE AND HANDLING

Storage Vessel, piping & ancillary equipment: Franklin recommends a polyethylene or cross-linked polyethylene storage tank (other options can be considered); schedule 80 CPVC pipe and fittings; and a plastic transfer pump. For those bulk tanks already in place that do not meet the ideal specifications, the tank must be 304 SS at minimum and applying a 2-part epoxy of Franklin's specification to the interior welds of the storage vessel is necessary. Other options may be considered. New SS tanks being constructed should be welded with traceable SS welding rod and passivated. Carbon Steel tanks are not recommended. Agitation and recirculation of the glue is always recommended. Please contact Franklin's technical service team at the number below for additional input.

Shelf life: Emulsion is best if used within three months of date of manufacture.

Hardeners are best if used within twelve months of date of manufacture.

Mix before use for best results. Product is freeze-thaw stable, but may need to be mixed prior to use.

For additional questions, Franklin's technical service team is available at 1.800.877.4583. 24/7 technical service is available online at www.franklinadhesivesandpolymers.com

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