



# AV XL PLUS

## SINGLE PACK CROSSLINKING PVA

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### YOUR SMART ADVANTAGES

- Designed for use with RF Curing equipment
- Can be used in cold pressing and hot pressing applications
- A single pack product producing a clear glue line
- Water resistance exceeds DIN 68 602-D3
- Good creep resistance, exceeding the requirements for Resistance to Sustained Load of BS 4071
- Waterbased and non flammable

### DESCRIPTION

**AV XL Plus** is a medium to fast setting, medium solids, single pack, crosslinking PVA emulsion adhesive which develops excellent bond strength, high heat resistance and humidity resistance, without catalyst addition, when dried at normal or elevated temperatures. It produces a clear non staining glue line.

**AV XL Plus** is an excellent adhesive for cabinet and furniture assembly where high bond strengths, good water/humidity resistance and relatively short clamp times are required.

### PRODUCT CHARACTERISTICS

Type	Unfilled PVA
Solids	High
Viscosity	Medium
Open Assembly Time	8-10 mins @ 20°C
Closed Assembly Time	7-12 Mins @ 20°C (depending on timber density)
Product code	
5 Litre carton of 4	30840604
20 Litre	30840605
200 Litre	30840606

### USES

Edge gluing timber sections  
Solid timber veneers or plastic laminates to core substrates  
Finger jointing  
Panel to frame gluing  
RF curing applications  
Suitable for use on many soft and hard woods as well as timber products such as medium density fibreboard (MDF), particle board and plywood.

**Ensure adequate tests are conducted before using commercially. Mix thoroughly before use.**

### Precautions

Please note some timbers such as Blackwood and Beech may be susceptible to stain development and discolouration from adhesives, which are acidic in nature (low PH) such as

### AV XL Plus.

Use of adhesives in very cold conditions (below 10°C) may result in poor film formation with powdery glue line.

### SURFACE PREPARATION

Wood surfaces to be glued must be clean, dry, free of dust, oil, grease and all finishes.  
Joints should be close fitting.  
The work area, glue and substrate for bonding should be at least 15°C.  
The moisture content of the wood should be between 8% and 12%.

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## APPLICATION INSTRUCTIONS

1. Apply adhesive to one surface only at a coverage rate of 5 - 10m<sup>2</sup> per litre of glue according to the substrate characteristics and working conditions.
2. Bring the second surface into contact and clamp assembly firmly and evenly while adhesive is still wet.
3. Clamps may be removed after a minimum of 3 hours at 20°C, depending on the moisture content/density of the materials being bonded.
4. Assembled parts should be left 24 hours to allow for complete curing of the glue line before further processing.
5. Any squeeze out of the adhesive from the joint, can be removed with a clean damp cloth prior to setting or sanded off after complete cure. The method is chosen to suit the application.

**AV XL Plus** has a relatively short assembly time, so pressure needs to be applied to the joint assembly within the 'open' time. This will vary with the density, 'wet-out' characteristic, moisture content of the substrates, and the atmospheric conditions occurring when gluing. Low temperature, damp conditions will extend the clamp time required considerably.

It is recommended that trials be conducted to determine the clamp time for a particular species / substrate.

### Clamping Pressures

#### Softwood 50 PSI

#### Hardwoods 150 PSI

i.e. enough pressure to bring joints tightly together with some glue "squeeze out".

### Clamp Times

Apply at a coverage rate of 5 - 10m<sup>2</sup> per litre of glue according to the substrate characteristics and working conditions.

Temperatures	Low Density Timbers	High Density Timbers
20°C	90 minutes	180 minutes
30°C	60 minutes	90 minutes

Glue lines should show glue squeeze out on application of pressure. Where the minimum pressure period is used, "dead" stacking of the freshly bonded panels or timber assemblies for 24 hours prior to machining is recommended.

### RF Curing Application

**AV XL Plus** is suitable for use with RF Curing equipment. Trials should be conducted with the timber species and sections to be used in production to optimise curing conditions.

### Hot Pressing

**AV XL Plus** can be used in hot pressing applications, in panel and general assembly gluing. Temperatures and Press Time conditions will vary for the particular application, substrate conditions, etc

## CLEANING

Wipe excess glue from joints with clean wet cloth before glue sets. Clean up excess and equipment with water prior to setting.

## STORAGE AND SHELF LIFE

Store in a cool, dry place, out of direct sunlight. Storage areas must be well ventilated and comply with Local, State and Federal regulations. For maximum shelf life, store between 5° and 20°C.

Shelf life is up to 9 months when stored in original, unopened containers, under the above conditions. Do not allow product to freeze.

Ensure containers are well sealed when not in use. To prevent the adhesive from skinning during use, ensure open troughs or holding reservoirs where there is little circulation are covered.

**AV XL Plus** is acidic in solution so should be used with plastic equipment. Contact with metal containers or equipment, other than stainless steel, in storage or use is not good practice and may cause staining problems in the glue line.

Do not store directly on concrete.

## HEALTH & SAFETY

Please refer to the Material Safety Data Sheet which is available on request.

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## PRECAUTIONS IN USE

Complete details on each of the products mentioned are available on the product Safety Data Sheets. To ensure no harm is caused to persons using Bostik products, it is recommended that all concerned read the appropriate Safety Data Sheets. Visit [www.bostik.com/au](http://www.bostik.com/au) for copies.

**For emergency information contact the Poisons Information Centre, phone 131 126 or the Emergency Response Service, phone 1800 033 111.**

BOSTIK HOTLINE

Smart help 1800 898 551



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