

Planarit 106

Planarit 106 is a self-curing, ready-made powder glue for tapeless veneer splicing

Chemical characterization

Ready-made urea-formaldehyde condensation product in powder form

Produkt specification

Appearance light-beige powder

Planarit 106 contains natural products. A slight amount of inhomogeneity and colour variations are normal and do not affect use.

Moisture content $\leq 2,0 \%$
(Mettler HC 103)

Viscosity of the solution 2000 – 4500 mPas
(Physica MC 1, ISO 3219/A, 20°C)
*at date of production

Solution ratio 100 GT powder to 50 GT water
(specified in parts by weight)

Gel times (guide values) for dissolved Planarit 106

Temperature [°C]	20	30	40	100
Gel time	3 h	1 h	20 min	25 Sek.

Form of delivery

Powder in 25 kg bags

Formulation

The glue is mixed in ratio

100 parts by weight glue powder
50 parts by weight water (20°C)

The glue powder is first mixed in two thirds of the water used to dissolve it, so there are no lumps. When the remaining water has been added, the glue solution is ready for use.

Tapeless veneer splicing

For thin veneers the glue solution should be slightly thinner and for thick veneers slightly thicker.

Examples of formulations (quantities expressed in parts by weight)

Formulation No.	1	2
Planarit 106	100	100
Water approx.	50	49
Ammonia, 25% soln.	-	1
Pot-life in h		
at 20°C approx.	2 h 30 min	5 h
at 30°C approx.	45 min	1 h 30 min

The use time of the glue approach on the current machine is reduced as a result of the increase in temperature and the evaporation of the water.

Processing conditions

The heating temperatures are 140 – 250°C

The throughput rate is dependent on the heating temperature and veneer thickness.

Throughput rate for 1,5 mm thick veneers:

at 180°C approx. 15 – 18 m/min

at 200°C approx. 18 – 21 m/min

at 250°C approx. 21 – 25 m/min

Wood moisture content: 6 – 10 %

Veneer edge banding

In discontinuous working systems, the above-mentioned approaches can be used.

In continuous working systems, the following approach has proved successful:

Examples of formulation (quantities expressed in parts by weight)

Planarit 106	100 GT
Water	30 GT

Storage

Maximum processing time at 20°C: 12 months

Maximum processing time at 30°C: 4 months

Planarit 106 must be well sealed and stored cool (if possible below 20 ° C). Above all, the product must be protected against moisture, even against atmospheric moisture, otherwise it will clump together and become insoluble after some time. After each removal, the containers should be closed well again.

Frost does not harm Planarit 106.

If the powder with the required amount of water can no longer be used homogeneously, the glue is no longer usable.

Any use or warranty of Planatol is excluded if used after the expiry of the stated processing period.

Cleaning

Clean application equipment with water before the Planarit 106 solution is dried.

For Your Attention:

The indicated specification values are valid for the products at the time of delivery ex works Rohrdorf/Herford. In case of doubt Planatol storage samples will be examined as sole reference. Planatol only guarantees the compliance with the specification values as indicated on the data sheet. Furthermore assurances, also orally given, are not guaranteed.

A self-test respectively a test of the adhesive regarding the purpose of application through the client is compulsory, especially testing the production conditions/substrates at the customer's site is obligatory. Recommendations given by Planatol are based on experiences and are without any obligation.

Indications made on this data sheet present no warranty of characteristic in the sense of the current Federal Supreme Court jurisdiction and are therefore not binding. Please always get in touch self-reliant with the responsible Planatol employee to receive the updated version of this data sheet or for further information concerning suitability regarding the FDA, BfR or EU guidelines.

For information regarding product safety please refer to the material safety data sheet.