



# RYSTIX SALES C.C.

Suppliers of Rystix resins & Timbacare sealers & coatings

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## PRODUCT INFORMATION SHEET

### RYSTIX CLEARBOND P.F. 531-W PVA RESIN

**General Properties:** Clearbond PF-531-W is a high quality general purpose white coloured copolymer emulsion for bonding a variety of soft and semi-hard woods.  
Dries to give a clear glueline and has good water resistance after curing for 7 days. Clearbond performs best when used in dry conditions with ambient temperatures above 15<sup>0</sup> C and preferably in the range 20-30<sup>0</sup> C.  
When used in accordance with the correct recommendations the product conforms to the European Standard EN204 / Class D2 and SANS 10183-2000 Class D3.

**Packing and storage:** Clearbond is supplied in 100kg plastic-lined metal drums and 25kg plastic buckets and should be stored under mild temperature conditions.  
Under these conditions storage life is 6-9 months from date of manufacture.  
Containers must be kept closed at all times when not in use.

**Timber Preparation:** Best results are obtained if all timber is freshly planed, dry and free from dirt or dust. Planer skips, wedging and polished surfaces should be avoided.  
The moisture content of all timber should be controlled within the range 7-15%. Preferably it should be between 8-12%.  
In excessively cold conditions timber should be stored under cover before use and where possible timber temperature should be in the range 20-25<sup>0</sup> C.

**Adhesive Application:** Application should be as light as possible depending on the timber moisture and the ambient conditions (temperature and humidity). Under conditions of long assembly heavier spreads will be necessary to counter dry-out of the glue lines before clamping.  
Heavier glue spreads will result in longer clamping times.

**Assembly and Clamping:** Ambient conditions and timber moisture contents and the rate of glue spread will determine the maximum possible open assembly time.  
Clamps should be applied as soon as possible after assembly.

Under normal conditions a clamping pressure of 0.7 to 1.5 Mpa is sufficient; it is essential that clamps be re-tightened 5-10 minutes after their initial tightening to allow for collapse during glue squeeze out.

Under normal conditions 30 minutes clamping time is sufficient at temperatures of 25 - 30<sup>0</sup> C.

When temperatures are lower and/or conditions are damp a longer clamping time should be used.

The optimum clamping time should be established by trials held under existing conditions in the workplace.

Do not use when adhesive or wood substrates are below 8°C, as adhesive may “chalk” leading to delamination.

**Minimum Film-forming**

**Temperature:** Approximately 4<sup>0</sup> C (S. African Bureau of Standards method 1041)

**Density:** 1.08 grammes per cubic centimetre

**Viscosity:** 6 - 8 Pascal seconds @ 23<sup>0</sup> C \* (SABS method 1035)  
(\* 1 Pascal second = 10 Poise)

**pH:** 3.5 - 4.5 @ 23<sup>0</sup> C (SABS method 1034)

**Breaking strength:** Minimum 4.0 kiloNewtons / min. (SABS method 1032)

**Amylaceous content:** Nil (SABS method 1039)

Note: The water holding capacity of some natural organic fillers may be undesirable in applications where the water is released under pressure. The swelling effect of water on these fillers may mean they are unsuitable in gap-filling applications. Tests should first be conducted.

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