



Recommendations

For gluing MDF & Compact MDF



Recommendations for gluing MDF and Compact MDF

Gluing MDF and Compact MDF normally does not present any particular problems. The choice of glue depends on the properties of the materials to be glued. Temperature and ambient humidity during application and curing of the glue are essential to obtain good results. A minimum temperature of 15°C is recommended for the processing of most glues.

Also the moisture content and the temperature of the panels as well as the planned surface finishes (e.g. veneering) must comply with the instructions of the glue manufacturer. They must approximate the eventual equilibrium moisture content of the woodwork installation as closely as possible.

Furthermore, the absorption power of the panel and the differences in absorption between the various parts of a single panel (face / edges) must be taken into consideration. Other factors influencing the choice of glue include the glue application method (by hand, roller or spray gun), press temperature, pressure and time under pressure, etc.

Three types of glues are recommended for gluing MDF or Compact MDF panels together, or for gluing a surface finish on an MDF or Compact MDF panel:

- PVAc glue (= standard white wood glue), type D3
- PU hotmelt
- UMF glue with a high melamine content (> 30%)

For gluing fire retardant panels (e.g. Fibrabel FR, Fibralux FR, Fibralux MR FR NAF, ...), we particularly recommend to use the following glues:

	Recommended glue type	Recommended supplier - reference
Gluing FR panels together	PVAc, type D3	Jowat - JowaColl 103.30 Jowat - JowaColl 103.70 Rakoll - GXL3
Gluing HPL (High Pressure Laminate) on FR panels	PVAc, type D3	
	PU hotmelt	Jowat - Jowatherm 609.30
Gluing wood veneer on FR panels	UMF with high melamine content (>30%)	AkzoNobel - Casco MUF system A014/H015

The instructions of the glue supplier should always be respected, e.g.:

- storage conditions of the glue
- preparation and temperature of the glue & the MDF or Compact MDF panel
- application type & -instructions
- glue spread (g/m²)
- press type, press time & pressure
- ...

In order to define the open time, amount of glue needed, press conditions,... it is strongly advised to perform a preliminary test on the industrial line with a limited number of panels.

When gluing a surface finish on Compact MDF, a longer press time might be indicated to allow good absorption of the glue. Immediately after pressing, it is possible that the adhesion between the board and the surface finish is not optimal yet. This is a normal phenomenon, which will disappear after curing of the glue.

To ensure good bonding, it is required to allow the glue for curing. Therefore, after pressing, let the boards rest for at least 24 hours, on a flat and horizontal surface in a warm environment.

To ensure its stability, a board should always be finished at both sides, with the same surface finish.