

# SabreBond™ TG90

SabreBond TG90 is a high performance aliphatic wood glue used for the bonding or joining of solid timber, which when cured gives higher bond strengths than standard PVA wood glues in general carpentry and joinery applications. SabreBond TG90 is a fast setting adhesive and is particularly suitable for bonding MDF as well.

## Directions for Use

SabreBond TG90 can be applied using glue spreaders, glue rollers, notched trowels, brushes or other appropriate tools.

Dilution is not recommended. Ensure substrates are free from oil dirt or grease.

- Ambient and timber temperatures should be above 15°C.
- Apply enough adhesive to ensure the glue line is fully covered and wet-out when surfaces are pressed together.
- Adhesive should be applied as a thin, even coating to one surface only. Parts should be combined, while the adhesive is wet, using good even pressure (30 to 130 psi is recommended).
- Parts should be clamped for 3 to 4 hours and will



reach full strength in 24 to 48 hours, depending on the moisture content of the timber, ambient temperature and humidity.

- TG90 is not suitable for exterior or load bearing applications.
- Clean application tools with water before adhesive starts to dry and set. Set adhesive needs to be removed mechanically.

## Physical Properties

<b>Appearance</b>	Pale yellow creamy liquid
<b>Viscosity</b>	4,500 – 5,500 cPs
<b>Total Solids Content</b>	49 – 52 %
<b>Specific Gravity</b>	1.06 g/ml

## Gluing Tips & Procedures

- Preparation and Machining – Careful attention to the machining and preparation of edges before assembling will result in obtaining the strongest possible bonds.
- Planning the edges to be bonded is recommended over against using a circular saw, as saw blades tend to damage the bonding surfaces by tearing the wood fibres as they cut, leaving a rough surface which often requires excessive clamping pressure to bring the two surfaces together; where as a planner shears the fibres longitudinally, leaving them undamaged, with a flat surface, that requires less clamping pressure, leaving an almost invisible glue line.
- Most joint failures are the result of poor preparation or machining, so this process is critical. A factor like dull knives or planner blades will crush and glaze the wood fibres leaving the bonding surface like glass. These glazed fibres will not absorb the adhesive and result in weak adhesion or bond. A simple test is to place a droplet of water onto the surface and if it stays beaded for over 30 seconds, the surface will be glazed.
- Another often challenging area is the gluing of resinous timbers like Teak, Heart Rimu, Jarrah, Mahogany and others that require special preparation before gluing. These timbers have

resinous extractives that can concentrate on the surface as the timber dries, making them almost water-resistant and prevents water-borne adhesives from penetrating the surface. The safest way is to dress these timbers immediately before gluing, not letting the dressed timber to sit too long as the resins will rise quickly to the surface again – within an hour or so.

- For the ultimate bond strength, it is imperative also that the adhesive is spread evenly over the entire bonding surface.

## Shelf Life

1 year from date of manufacture.

## Storage

Product should be stored in the original container out of direct sunlight between 5°C and 30°C and protected from freezing. Rotate stock using oldest batches first. Close containers air tight after use. For best performance, use product within 12 months of manufacture.

## Health & Safety

This material is non-hazardous. Refer to the Material Safety Data Sheet (MSDS) for further information.

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### IMPORTANT NOTICE

Sabre Adhesives Limited makes no warranties, express or implied, including, but not limited to, any implied warranty of merchantability or fitness for a particular purpose. User is responsible for determining whether the product is fit for a particular purpose and suitable for user's method of application. Due to the fact that specific substrates, such as: plastics, polycarbonates, etc, may differ from manufacturer to manufacturer we recommend preliminary compatibility tests. Please remember that many factors can affect the use and performance in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a product. Given the variety of factors that can affect the use of our products some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

### LIMITATION OF REMEDIES AND LIABILITY

If the product is proved to be defective, the sole remedy shall be to refund the purchase price or to repair or replace the defective product. Sabre shall not otherwise be liable for loss or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including negligence, warranty, or strict liability.

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