



Fortis AD5305-S is a single component, moisture curing structurally certified polyurethane timber adhesive used for glue lamination. It reacts rapidly with atmospheric moisture, to provide a superior bond for load bearing timber applications.

- Features and Benefits**
- Structural Glue Lamination Adhesive
 - GLTAA Certificate #007
 - EN302 /AS/NZS 4364:2010
 - Suitable for most hardwoods
 - 30 minute working time
 - Expands as it dries
 - Water resistant
 - Superior adhesion at low dosage
 - Excellent heat resistance

- Typical Applications**
- Timber Glue Lamination
 - Structural Beams

- Properties**
- Colour: amber
 - Coverage: 55-200 g/m²
 - Clamp time: 90min @ 20°C (65% RH)

Pack Size 225kg, 1100kg

Shelf Life 12 months @ 25°C unopened

- Safety**
- Contains Isocyanates
 - Refer to Safety Data Sheet prior to use
 - Good industrial hygiene practices should be observed at all times
 - Appropriate PPE should be worn including impervious gloves & eye wear

Storage Store in cool, dry conditions, out of direct sunlight and in a well-ventilated area. Do not store below 5°C or over 40°C

Surface Preparation Excellent timber-to-timber contact is necessary to achieve optimum bond strength. A smooth surface achieved through planing or similar technique will aid in providing a good timber-to-timber contact. A good mechanical fit for finger jointing is necessary and internal or bonding pressures for laminating must be at least 1400kPa for optimum performance.

Extensive laboratory testing has shown that to achieve optimum performance with **Fortis AD5305-S** a water mist must be applied to the timber prior to glue application. The water application should be approximately 30-50 grams per square meter (GSM) for both adhering faces. This process has been found beneficial for the oiliest of Australian timbers.

Application **Fortis AD5305-S** can be heated up to 35°C prior to pumping to reduce viscosity and improve pumping ability and flow. Ask Fortis for advice regarding the simple set-up of heat rooms.

Fortis AD5305-S generally requires lower dosages than traditional resins used for engineered wood products. Typically dosages of 55 - 140 gsm are common.

Assembly time tolerances will be mill and substrate specific, being dependent on the wood moisture content, spread rate, temperature of the substrate, temperature and relative humidity of the mill and atmospheric conditions.

The cure time of **Fortis AD5305-S** can be accelerated through the heating of the substrate, glue-line or adhesive itself. Conversely, cure time can be retarded with colder temperatures.



An excellent timber-to-timber contact is necessary to achieve optimum bond strength. If products have not been under pressure for the full time to a testable bond (as in finger-jointing applications), it is important that the finished products are handled gently until a testable bond has been achieved.

Clean-Up

Clean tools with acetone or white spirit immediately after use, ie before adhesive has dried. Allow glue to dry then scrape, chisel, sand or cut excess glue. If glue comes in contact with hands, use acetone or white spirits to remove immediately and then rinse off with soapy water.

For further information, including Safety Data Sheets and Technical Bulletins on adhesive applications and surface preparation, refer to the Fortis website www.fortisadhesives.com.au.

Disclaimer - Fortis products should be used in accordance with the information contained herein. Each user should read and consider this information carefully in the context of how the products will be handled and used in the workplace including in conjunction with other products. While the information contained herein is to the best of our knowledge at the date of publication, Fortis makes no representation about the accuracy of the information. If you need clarification or more information, you should contact Fortis Adhesives & Coatings. Fortis products are sold without express or implied warranties, other than as provided by statute, and subject to our standard terms and conditions (provided to customers and available on request). Subject to our standard terms and conditions, and any statutory provisions, Fortis accepts no responsibility (including in negligence) for loss or damage of any nature resulting from the use of Fortis Adhesives & Coatings products or reliance upon the information contained herein.

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