

PRO 30D - Waterr. Wood Adh.

Product description

PRO 30D - Waterr. Wood Adh. is a ready to use, fast drying, PVAc based adhesive with superior water resistance (D3).

Properties

- Easy to apply
- High adhesive strength
- Fast drying
- Transparent after drying
- Resistant to high temperatures



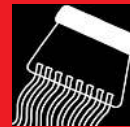
Applications

- Interior applications with frequent shortterm exposure of the bonds to running or condensed water
- Interior applications which are exposed to high relative humidity
- Exterior applications which are not exposed to weather factors
- Manufacturing of door and window-frames that need to meet class D3 according to EN204
- Bonding of wood, board, chipboard, veneer
- Assembly glueing of soft wood
- Construction bonding such as mortise and tenon joints, punches, etc.
- Stationary edge-banding with veneers, plastic laminates and solid wood strips
- Surface bonding of decor-finish film, HPL and CPL to chipboard, MDF and plywood
- Bonding joints in boards and block bonding of softwood, hardwood and chipboard
- Bonding of seams in floating parquet and laminate parquet floors

Technical data

Base	PVAc
Consistency	High viscous fluid
Curing system	Physical drying
Density	ca. 1,10 g/ml
Open time	ca. 8 minutes
Consumption	80 - 140 g/m ² in full surface bonding. 160 - 180 g/m ² in assembly
Application temperature	5°C - 35°C
Durability class (EN 204)	D3
Min. Film Forming Temperature (MFFT)	5°C
pH level	ca. 3
Pressing pressure	1 kg/cm ² - 2 kg/cm ²
Pressing time	See application method
Solid content	ca. 50%

Footnote: evaporation time, open time and curing speed may vary depending on environmental factors such as temperature, moisture, and type of substrates.



PRO 30D - Waterr. Wood Adh.

Substrates

- Substrate condition
The materials should be flat and well fitting as well as clean, dry and free of dust and grease.
- Substrate preparation
Slightly grinding or sanding can improve the adhesion.
- Substrate types
PRO 30D - Waterr. Wood Adh. has a good adhesion to following substrates: many non-porous and porous substrates like wood, carton, laminate, etc.... We recommend a preliminary adhesion and compatibility test on every surface.

Application method

- Application method
Apply the adhesive with the aid of a fine-toothed comb or brush on one of the materials to be bonded. Join the parts together and clamp for 1 to 2 hours. Pressing times: if applicable. Curing time depends strongly on the used kind of wood, temperature, amount of adhesive and the porosity of the materials to be bonded. Minimum pressing times High-frequency bonding with longitudinal heating > 15 sec and Decor-finish 5 - 10 sec. Minimum pressing times assembly bondings: 8 - 15 minutes. Minimum pressing times bonding joints and block bonding: 10 - 15 minutes. Surface bonding of HPL/CPL in short cycle presses at 70°C: to plywood approx. 90 sec. and to chipboard approx. 45 sec.
- Cleaning method
Before curing, PRO 30D - Waterr. Wood Adh. can be removed with water from non-porous materials or tools. Cured product can only be removed mechanically.
- Repair method
Repair with the same material.

Health- and Safety Recommendations

Take the usual labour hygiene into account. Consult the packaging label and safety data sheet for more information.

Packaging/Logistics

Packaging: Various sizes available. Please consult the product catalogue, the Soudal website or a Soudal representative.
Shelf life: 24 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C

Remarks

- When bonding certain woods such as beech and cherry discoloration may occur because of the variety of composition and pretreatment.
- PRO 30D - Waterr. Wood Adh. should not be diluted.

This technical data sheet replaces all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. It is general in nature and does not constitute any liability. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. Since the design, the quality of the substrate and processing conditions are beyond our control, no liability under this publication is accepted. It is the responsibility of the user to determine by his own tests whether the product is suitable for the application. In every case it is recommended to carry out preliminary experiments. The manufacturer reserves the right to modify products without prior notice.