



PRODUCT SPECIFICATION

D3 PVA

D3 is ready for use, fast setting; single part curing polyvinyl acetate based emulsion.

RECOMMENDED USE

D3 is a multipurpose, water resistant adhesive, which conforms to the D3 requirements of BS EN 204-205. It also meets the requirements of BS 4071.

D3 is suitable for general assembly and lamination on particleboard and MDF.

BONDING INSTRUCTIONS

Working conditions:

Minimum temperature for use 12°C
Ambient temperature(warehouse, wood, laminates, adhesive) 18-20°C
Humidity of wooden substrates 8-12%

Coating weight:

Flat lamination, paper (single face coverage) 20-70g/m²

Flat lamination, HPL, thick foils (single face coverage) 100-200g/m²

Assembly (single face coverage) 150-200g/m²

Assembly time: 4-8 min

Pressure:

Wood on wood 2-5 bar (kgf/cm²)

Laminates on wood 1-2 bar (kgf/cm²)

Pressing time (minimum):

Wood on wood at 20°C 10-15 min

Assemblies with one face preheated 2-3 min

Laminates on wood at 20°C 20-30 min

Laminates on wood at 80°C 3-4 min

Stabilisation:

Before machining 2 hours (minimum)

Complete setting of adhesive at least 24 hours

D3 water resistance at least 1 week

SURFACE PREPARATION

- Substrates to be bonded should be perfectly clean, dry and free from dust and grease.

- For laminations, surfaces should be homogeneous and flat.
- Assemblies should be precise in order to avoid thick adhesive lines (0.2-3mm max).
- Wood should be allowed to condition for several days in the workshop atmosphere (15-20°C) before bonding. Its relative humidity should be approx. 10-20°C

APPLICATION

- For lamination apply an even coat of adhesive to one of the substrates by roller coater, brush or spatula.
- For assembly applications we recommend that both surfaces should be coated.
- Coating weight depends on substrate, porosity, open time ambient temperature.

General features

Flat lamination 100-240g/m²

Panelling, edge jointing 200-350g/m²

Other (mortice/tenon, tongue/groove) coat both sides

ASSEMBLY

- The parts to be bonded should be brought together immediately after application whilst the adhesive is still wet.
- The maximum open time depends on the substrates porosity, ambient temperature and coating weight. A guideline is given on page 1.

PRESSING

- After assembly pressure should be maintained during the adhesive's initial setting period, using conventional pressing methods such as presses, vices, jigs clamps or dead loads. Refer to the pressure values given on page 1. This is not necessary for finger joints.
- Pressing time depends on such variables as ambient temperature and humidity, coating weight, porosity of substrates and dimensions of assemblies. Reference values are given on page 1 but a test specimen will allow this to be calculated.

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- Pressing time can be reduced by heating one substrate to be bonded before pressing at room temperature. We recommend pre-heating of the surface (1-2 minutes at 80°C).
- Hot pressing should only be recommended for double sided flat lamination.

GENERAL PRECAUTIONS

- Do not add anything to the adhesive to modify its properties.
- Provided contact with iron is avoided the adhesive should not cause straining.
- After each use close the container tightly to avoid skin formation.
- Coating equipment and tools can be cleaned with warm (35-40°C) water, before the adhesive has dried out.
- For health, safety and disposal please refer to the safety data sheet.

TYPICAL CHARACTERISTICS

Physical form: Viscous liquid
Colour: White
Viscosity (Brookfield RVT, 20rpm, at 23°C):
Approx: 12000mPas
Specific gravity: Approx: 1.10

PACKAGING

Sizes Available: 1kg, 5kg & 25kg

STORAGE

Store in original packaging between 5 and 30°C.
Protect from frost.
After prolonged storage stir well before use.

SHELF LIFE

Under the above storage conditions, 12 months closed in its original packaging.

SAFETY DATA

For further information refer to the relevant health and safety data sheet.