

## PVAc 30.10 adhesive

### PRODUCT DESCRIPTION

**PVAc 30.10** is suitable for face and edge bonding, assembly bonding, veneering with natural veneer and laminate in the cold and hot pressing process. Can be used for bonding of hard wood species. Adhesive is also convenient for gluing wooden toys, as well as for gluing packages in food industry, and objects having contact with food. Glue weld meets water resistance requirements of D3 class according to PN-EN 204 and WATT 91 standards.

### TECHNICAL DETAILS

Type:	PVAc-based dispersion
Delivery form:	Liquid
Colour:	White
Viscosity:	7000-20000 mPa.s (Brookfield RVT, ISO 2555)
pH:	4

### ADHESIVE APPLICATION

#### **Material preparation**

Bonded surface must be cleaned and dust-free, free of oil and grease, which may reduce adhesion. Wood moisture content should be  $8 \div 12$ . Relative air humidity 30-60%

#### **Applying of adhesive**

It is recommended to precisely mix the adhesive before use. Adhesive can be applied on one or both sides with a spatula, brush, manual or roller applicator. Depend from the type of surface, recommended amount of applied adhesive is 90-180 g/m<sup>2</sup>

### **Wood discoloration**

Adhesive does not cause the discolouration of wood, however when working with adhesive it is recommended to avoid tools containing iron, which in contact with wood containing tannin - can cause discoloration.

### **Bonding temperature**

Use in temperature above +15°C. This applies to the ambient temperature and, above all, the temperature of the bonded materials and the adhesive itself. Maximum bonding temperature up to + 80 ° C.

### **Assembly time (pine-pine)**

Open assembly time (OAT) is max. 10 minutes at 20°C, closed assembly time is max. 12 min.

### **Pressing time**

For bonding of pine slats, minimum pressing time is 10 min. at 20°C.

The pressing time depends from the same factors as the assembly time. Bonding other than pine wood species, bonding in different temperatures or bonding the structures with the existing tensions require of determine the pressing time for each case separately.

### **Press pressure**

0.3-1 Mpa. Thoroughly polished surfaces with good adhesion give the best bonding results.

### **Cleaning**

Wash tools immediately after work. Do not allow the adhesive to dry. Dried adhesive remove mechanically after soaking in hot water (about 1 h).



## **PACKAGING**

**PVAc 30.10** is available in following packages:  
5 kg, 10 kg, 20 kg, 1000 kg

## **STORAGE AND EXPIRY DATE**

Product should be stored in original, closed packaging in temperatures between +15 to +25°C. After opening the package, take required amount of adhesive and close the container tightly. Product stored under these conditions, retains its properties within 6 months of the manufacture date.

## **HAZARD INFORMATION**

For complete health and safety information please refer to the Material Safety Data Sheet.

Above information's are the result of our practical experience and have indicative character, they are not guarantee of product properties and cannot be the underline for complaint. For this reason use of adhesive under conditions other than those specified in this sheet does not guarantee obtaining optimum results. Manufacturer is not liable for any damages resulting from non-compliant use.

**CDW Sp. z o.o.**

ul. Wrzesińska 21, 62-307 Borzykowo, Polska

Tel. 61 640 05 15, Fax. 61 640 18 98

[www.cdw.net.pl](http://www.cdw.net.pl) [SKL@cdw.net.pl](mailto:SKL@cdw.net.pl)

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