65A Wood Adhesive Water Resistant D3

Technical data

Basis	PVAc
Consistency	High viscous fluid
Curing system	Physical drying
Density	Ca. 1,10 g/ml
Viscosity (Brookfield)	8.000 mPa.s → 15.000 mPa.s
Total solid content	Ca. 50 %
Open time (23°C, 55% RV)*	Ca. 8 min.
Pressing pressure	1 kg/cm² → 2 kg/cm²
Pressing times	See application
Water resistance (EN204)	D3
Application temperature	15 °C → 35 °C
pH level	2,5 → 3,5
Min. Film Forming Temperature (MFFT)	5 °C
Consumption*	80 - 140 g/m² in full surface bonding. 160 - 180 g/m² in assembly.

* These values may vary depending on environmental factors such as temperature, moisture, and type of substrates. ** This information relates to fully cured product.

Product description
65A Wood Adhesive Water Resistant D3 is a ready to use, fast drying, PVA-based adhesive with superior water resistance (D3).

Properties
- Easy to tool
- Transparent after drying
- High end strength
- Fast drying time
- Resistant against high temperatures

Applications
- Interior applications with frequent short-term 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

Packaging
Colour: white
Packaging: 750gr. 5 kg

Shelf life
24 months unopened and stored in dry and cool conditions (Between 5 and 25 °C)

Substrates
Substrates: many non-porous and porous substrates like wood, carton, laminate, etc...
Nature: The to be bonded materials should be flat and well fitting as well as clean, dry and free of dust and grease.
Surface preparation: Slightly grinding smooth non-porous surfaces can improve the adhesion.

Remark: This technical data sheet replaces al 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. 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. In every case it is recommended to carry out preliminary experiments. Soudal reserves the right to modify products without prior notice.

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We recommend a preliminary adhesion test on any substrate.

Application method
Application method: Apply the adhesive with a notched trowel, brush or machine 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 Dekor-finish 5 – 10 sec. Minimum pressing times assembly bondings: 8 – 15 min.
Minimum pressing times bonding joints and block bonding: 10 – 15 min. Surface bonding of HPL/CPLin short cycle presses at 70°C: to plywood approx. 90 sec. and to chipboard approx. 45 sec.
Cleaning: Before curing, 65A Wood Adhesive Water Resistant D3 can be removed with water from substrates and tools. Cured 65A Wood Adhesive Water Resistant D3 can only be removed mechanically.
Repair: With the same material.

Health- and Safety Recommendations
Take the usual labour hygiene into account. Consult label and material safety data sheet for more information.

Remarks
- When bonding certain woods such as beech and cherry discoloration may occur because of the variety of composition and pretreatment.
- Do not dilute the adhesive.

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