

# woodmax

## wood adhesives

### FN 12.47

#### CHARACTERISTICS

One-component adhesive based on modified poly (vinyl acetate) dispersion and additives. The joint shortly attains high strength and demonstrates good adhesion to wooden surfaces.

The joint conforms to water resistance class D2 according to PN- EN 204.

#### APPLICATION

- bonding of soft wood
- dowel joints
- bonding of other wood-based materials
- intended for nozzle application
- bonding of plywood
- intended for use on hot presses
- intended for use on cold presses or for manual bonding

#### SPECIFICATION

Total solids (dry matter content)	47 ± 2 [%]
Brookfield viscosity RV	3 500 ÷ 7 000 [mPas]

#### PARAMETERS

pH	approx. 4
MTTF	approx. 4 [°C]
Joint	Transparent, non-dulling and resistant to ageing
Density	approx. 1.05 g / cm <sup>3</sup>
Strenght - cycle 1 as per PN-EN 204	Min. 10 [MPa]
Strenght - cycle 2 as per PN-EN 204	Min. 8 [MPa]

#### INDICATIONS FOR THE USE OF THE ADHESIVE

##### Material preparation

Bonded surfaces should be dry, clean, dust, oil and fat free to ensure proper bonding. Bonded surfaces must be aligned. Wood moisture content should be 8 ÷ 12 [%].

##### Adhesive application

Stir the adhesive thoroughly before use. It can be applied on one or both surfaces with a brush, putty knife, feeding vessel, applicator, hand roller. Recommended adhesive amount depending on the substrate is 120 ÷ 180 (g/m<sup>2</sup>). Do not use iron tools.

##### Discolouration

The adhesive will not cause wood discolouration. It is recommended not to use iron tools, as discolouration may occur in contact with woods containing tannin.

##### Open time

Open time: 3 ÷ 8 [min]. Open time depends on bonded components, wood grade, porosity, amount of adhesive used, ambient temperature and humidity.

##### Bonding temperature

Use at temperature 15 ÷ 30 [°C]. Applies both to ambient temperature and temperature of bonded materials and adhesive.

##### Pressing

###### - pressing pressure

0.1 ÷ 1.2 [N/mm<sup>2</sup>] depending on the stress distribution in bonded materials. For manual application, press the surfaces together to remove excess adhesive.

###### - pressing time

depends on bonded components, porosity, absorption rate, wood grade, moisture content, ambient temperature and humidity, quantity of adhesive used and stress distribution in bonded materials. Press the surfaces together until the bond strength allows further treatment or transport.

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### - recommended average pressing times

cold presses 15 ÷ 30 [min]

### Observe the following to ensure proper bonding:

Bonding temperature	15 ÷ 25 [°C]
Relative air humidity	40 ÷ 70 [%]
Wood moisture content	8 ÷ 12 [%]
Amount of adhesive used	90 ÷ 180 [g/m <sup>2</sup> ]
Maximum open time	3 ÷ 8 [min]

### NOTES

Recommended bonding parameters in the Technical Data Sheet are given for non-expanded adhesive.

The expanded adhesive must be tested for its suitability. Note especially the adhesive work parameters, as they may vary.

### CLEANING

Clean tools with water immediately after use. Do not allow the adhesive to set. Remove set adhesive mechanically after soaking in hot water for approx. 1 hour.

### PACKAGING AND TRANSPORT

The product is available in plastic 20 kg, 60 kg and 1000 kg containers. Packaging and transport are not subject to the regulations on dangerous goods (ADR, RID). Different packaging can be used if agreed upon between the manufacturer and the client. The packaging must not affect product quality.

### STORAGE

Store in original tightly closed containers at temperature from + 5 to + 30 [°C]. If storage conditions are observed, the product retains its properties for up to 12 months from the date of production.

**Disclaimer** - Information provided herein is the result of investigations which were carried out by Application Laboratory of SYNTHOS S.A. according to valid standards and the present state of knowledge. The manufacturer of the adhesive may have not predicted all of its applications. Carrying out of application and bonding tests by the user and validation of the final product properties are highly recommended

as the way the adhesive is used is entirely beyond the control of the adhesive manufacturer. The user of the adhesive is responsible for the proper selection and application of the product. The manufacturer holds no responsibility with respect to existing damage to the surface or its deteriorated condition, which may be the effect of ambient conditions, initial preparations or structural defects. After storing the adhesive for prolonged periods of time, a layer of water may appear on its surface, it is a natural phenomenon which disappears after the adhesive is stirred.

Safety instructions are contained in the SDS.

### Detailed information:

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Every batch/delivery is accompanied by a quality certificate containing data on the properties identified in exit control.