

Strong Glue D3 PVAc

USE

One-component aqueous polyvinyl acetate dispersion with excellent water resistance. STRONG GLUE D3 PVAC is also suitable for bonding hardwood for bonding:

- interior joints that are frequently exposed to water or condensation of atmospheric humidity for short periods or to long-term exposure to high atmospheric humidity
- exterior joints where one of the substrates to be bonded is made of wood.

Do not use in structures permanently exposed to water (e.g. ships, boats) or static charges (e.g. load-bearing roof frames). The product is classified as D3 according to DIN EN 204.

TECHNICAL SPECIFICATION

Form:	synthetic dispersion
Appearance:	white, homogeneous, thick liquid dispersion with a characteristic mild odour
Viscosity: (Brookfield)	10 000 ± 2 000 mPa.s (depending on temperature, quantity and substrate)
pH:	3,0 ± 0,4
Density:	approx. 1,08 g/cm ³

INSTRUCTION FOR USE

Application ambient temperature, adhesive and material:	15 - 25 °C
Application:	brush, spatula, roller, or machine roller
Wood humidity:	8 - 12 %
Minimum film forming temperature:	5 °C
Open time:	approx. 10 min
Adhesive strength:	min. 10 N/mm ²

The product must be mixed before use. It can be diluted with water (max. 10%), but it is recommended to use it without dilution (if diluted, drying will be slower and the thickness of the adhesive film will be thinner).

To achieve ideal adhesive strength, it is necessary to ensure a clean, dust-free, tightly fitting surface. Do not use the adhesive if the temperature of the workplace, adhesive and workpiece are below than 15 °C. If the temperature of the adhesive layer drops below 5 °C, the adhesive does not form a film, but a white powder. During the entire drying period, the temperature of the glued layer must not fall below 5 °C. If the workpiece is not warm enough across the entire cross-section, after pressing, the adhesive film layer inside the workpiece cools down before completely hardening (its temperature drops below the MFT), the film will not form. In this case, a perfect layer of glue appears on the surface of the workpiece, but inside the workpiece, instead of a layer of glue, there is a white powder.

Usually, it is enough to apply the adhesive to one side (120-180 g/m²), but in case of very absorbent surfaces it is necessary to apply the product to both sides (60-100 g/m²/side). The ideal wood moisture content is 8-10%. In case of laminate and hardwood floors, apply the adhesive to the edge of the board and after the prescribed pressure, wipe off the excess from the surface.

In normal processing, do not leave the surfaces coated with the adhesive open for more than 5 minutes, as hardening may occur on the surface, which is unsuitable for bonding.

To increase the strength of the adhesive, the joined surfaces should be pressed with a pressure of 0.2-0.8 N/mm². It can be used in cold, hot and high-frequency presses (in winter, in case of cold presses, the lower temperature extends the drying time). In general: lower workplace and workpiece temperatures can, in addition to prolonged drying time, also damage the bond strength.

TECHNICAL DATA SHEET



The minimum required pressing time and temperature must be optimized according to the technology used. As a guide to using this product, we recommend the following:

Material	20 °C	50°C	70°C
Hardwood	17 min	10 min	7 min
Softwood	15 min	10 min	7 min
Laminated sheets	40 min	25 min	17 min

To achieve maximum strength, it is necessary to press for 2 hours. After 20 minutes, the strength reaches 50% of the prescribed tensile strength. The glued joints reach their final strength after 24 hours of drying. Perfect waterproofing is achieved after 7 days.

The structure of the glued material and the application conditions affect the bonding, therefore it is advisable to carry out your own tests. Failure to comply with the storage and processing conditions negatively affects the bonding results.

CLEANING

Clean the undried adhesive with warm water immediately after use. To prevent unwanted adhesive build-up on the surface of machine applicators and machine components, we recommend AGGLU Separating Paste, AG-CLEAN PVAc can be used to remove residues of dried adhesive.

STORAGE

Storage time: 12 months
Optimum temperature and storage humidity: 5 - 40 °C, humidity max. 50 %

Store in a dry place, protect from frost and direct sunlight. The product is sensitive to frost, but is slightly frost-resistant. After freezing (-20 °C), the adhesive can be used after slowly warming up again and stirring constantly. The viscosity may increase slightly. In the event of a prolonged period of frost, the adhesive may become gel.

HEALTH AND SAFETY INSTRUCTION

Further handling, transport and disposal warnings are provided in the corresponding safety data sheet.

The data in this technical sheet is based on our practical experience and laboratory test results. As they cannot take into account all possible uses, they are not-binding. The data are neither a guarantee of quality nor assurance of properties. No legal claims can be drawn from these data, as well as from our free technical advisory service. Values are continuously updated according to the latest technology. This edition replaces all previous releases and is valid as of that date.