

## PVAc Glue

**Application:** HF/RF applications; KA edgebanding; assembly of windows and furniture for moist conditions (bathroom, kitchen, etc.) as well as for dowel driving units with a high pressure pump.

**Characteristics/ Directions for use:** Self-crosslinking PVAc glue highly water resistant (fulfills EN 204 D3 and Type II ANSI/HPVA HP-1-1994). Excellent bond strength and durability. CAUTION: May cause discoloration of veneer in flat press applications.

Min. temp. (for materials, glue and room air):	15°C (58°F)
Glue Application:	one sided
Application amount :	4-6 mil wet=10-16 g/sqft
Open time [min]:	approx. 6-8 minutes
Pressure [N/mm <sup>2</sup> ]:	30 psi minimum=2 kp/sqcm=.2 N/sqmm
Min. press. time at room temp. [min]:	approx. 10-15 minutes (depending on the substrates to be glued)

We recommend that all materials coming into contact with the glue are made of high-quality stainless steel or of inert plastics, e. g. Teflon, PP, polyamide. Avoid contact with other metals (like zinc, brass, copper or aluminum). For more information, contact the equipment manufacturer or our technical service. Suitable for all usual applicator systems. Avoid contact with alkaline substrates or with iron, tanniferous wood may discolor. Minimum temperature for materials, glue and room air: 15°C (not identical with minimum temperature of film formation).

Tested according to Jowat test methods. Customer trials are recommended.

<b>Technical Data:</b>	Viscosity [mPas]:	approx. 6,000 (Brookfield)
	Density [g/cm <sup>3</sup> ]:	approx. 1.1 (9.1 lbs./gal.)
	Solids [%]:	approx. 50
	pH value:	approx. 3
	Appearance:	white – translucent with UV indicator

**Cleaning:** Machines and equipment may be cleaned after use with warm or cold water. Dried glue must be removed mechanically.

**Storage:** May be stored in properly closed original containers, cool and dry (15-25°C (59-77°F)). Best before date, please refer to label on the packaging unit.

**Packaging:** Types of packaging and units upon request.

**Remarks:** For further information concerning handling, transport and disposal, please refer to the Safety Data Sheet. Our information on this data sheet is based on test results from our laboratories as well as on experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding for us. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from these indications nor from the recommendations made by our free technical advisory service.

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## JOWAT Corporation Information

Gluing, as one of the most efficient methods of bonding, is constantly expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are constantly being improved and developed.

The in-house R&D department of JOWAT Corporation ("JOWAT") is responding with intensive efforts to keep pace with these constant changes. A highly trained and qualified team of chemists and engineers are using the latest techniques and the brightest ideas to make sure that our adhesives meet the needs of our customers for new and innovative applications.

We have assimilated information based on test results from our laboratories as well as on experience gained in the field by working with our customers. This information is available by contacting our technical service department. Customers who have obtained information and thereafter undertake modifications during a running production are invited to provide this information to us to assist us in maintaining our field information and obtain any updated information we may have. However, any technical information we provide is provided for informational and assistance purposes only, and should not be relied upon or used to replace field testing by the user of the adhesive in the actual application for which the adhesive is to be used. Our laboratory testing and field information obtained cannot simulate all eventualities that may occur in each specific application, and for that reason we cannot and do not insure performance or results in specific applications.

Any user of adhesives manufactured by JOWAT must test the adhesive(s) for suitability in each individual application, performing such tests in connection with the first use of a sample as well as all subsequent modifications during any ongoing production.

In addition to such other tests the users of our adhesives deem appropriate to insure suitable bonding, all users of adhesives manufactured by JOWAT should test the adhesives for suitability on original parts equal to normal processing conditions. The adhesive bond should then also be tested and assessed by subjecting it to the actual stress and conditions it will undergo in its intended use. ALL OF THESE TESTS ARE ABSOLUTELY NECESSARY AND MUST BE PERFORMED.

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