



Technical data
supplied by the
manufacturer



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
- Mounting 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

Product Model

PRO 30D Waterproof Wood Adhesive

PRO 30D Waterproof Wood Adhesive is a ready to use, fast drying, PVA-based adhesive with superior water resistance (D3).

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
Open time*	Ca. 8 min.
Pressing pressure	1 kg/cm ² - 2 kg/cm ²
Pressing times	See application
Water resistance (EN204)	D3
Consumption*	80 - 140 g/m ² in full surface bonding. 160 - 180 g/m ² in assembly.
pH level	2,5 - 3,5
Min. Film Forming Temperature (MFFT)	5 °C
Total solid content	Ca. 50 %

Packaging

Colour: white

Packaging: 750gr. 5 kg

Shelf life

At least 12 months in unopened packaging in a dry storage place at temperatures between +5°C 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.

We recommend a preliminary compatibility test.

Health- and Safety Recommendations

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

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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 PL/CPLin short cycle presses at 70°C: to plywood approx. 90 sec. and to chipboard approx. 45 sec.

Cleaning: Before curing, PRO 30D Waterproof Wood Adhesive can be removed with water from substrates and tools. Cured PRO 30D Waterproof Wood Adhesive can only be removed mechanically.

Repair: With the same material

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.

This technical data sheet replaces all 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 beyond our control, no liability under this publication are accepted. In every case it is recommended to carry out preliminary experiments. Soudal reserves the right to modify products without prior notice.