

Technical Information

Häfele D3 Leim 003.09.370

PVAc-glue for the mounting according to D3/EN 204 water resistant

Characteristics

- medium viscosity
- fast setting
- Long open time
- gap filling
- gives transparent, tough-elastic glue-joint
- High water resistant, 1 component = Durability class D3 as per EN 204,

Application Areas

- Joins where increased water resistance is needed
- solid wood gluing
- Door- and stairs-gluing
- Windows, window scantlings, composite window elements

Technical Data

Base:	Polyvinylacetat
colour:	weiß, transparent nach Trocknung
Viscosity Brookfield RVT, 2/50/23, mPa.s ISO 2555:	12,000 to 18,000
pH-value (20°C) ISO 976:	2,5 to 3,5
minimum film formation temperature(MFFT)°C : DIN 53787	approx. + 5 °C

Information about working

Open time

Open time, minutes: approx. 8 min

Press-time

Surface bonding (Chipboard/HPL):

Quantity applied 100 g/m² approx. 10 min

Quantity applied 200 g/m² approx. 20 min

*The shown Data is based on 8-12 % wood humidity, 20 °C Room- and Materialtemperature
As well as 65 % relative air humidity and 0,5 N/mm² forming pressure.
The real open time and setting time are highly affected by the working conditions such as temperature,,
humidity and absorption of the wood material, condition of the surface, material stresses, used glue, etc.*

The glue will be delivered useable. If required it can be thinned with water up to 3%.
Temperature of the material and the glue should be minimum + 10°C.
Free of grease and dusty should on the used material's is needed.
Because of the amphophil it can be created a discolour on some wood material's (for example pine).

Metal parts may cause discoloration, due to their reaction with the tannin of the wood (especially oak). Normally a one side glueing will be sufficient. Applying glue to both sides, however, is recommended when gluing difficult-to-bond woods and hardwood, in order to improve bonding strength; in this case the open time is increased..

Cleaning

Equipment used to apply the glue may be cleaned easily using cold or luke-warm water before the adhesive has dried hard. Hard dried glue remnants have to be removed mechanically.

Stocking

Store in the original tightly closed container in a cool, dry place away from frost. Stir well before use. Storage life up to 12 months.

Classification

Please refer to the corresponding safety data sheets for details on:

Hazardous information

Transport Regulations

Safety Regulations

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