Technical Data Sheet

Häfele D2 LEIM
Nr. 003.09.360

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PRODUCT DESCRIPTION
Technology PVA Dispersion
Product Type Surface and Assembly Glue
Application Assembly
Appearance white; transparent after drying

Application Areas
● Edge gluing of softwood
● Assembly and carcass gluing
● Dowel insertion as well as mortice and tenon gluing
● Gluing of laminate sheets to chipboard, block board and the like
● Edgebanding of veneer, solid and HPL edges in stationary presses, either cold or using heating elements

Product Properties
● Medium viscosity
● Very short setting time
● Gives tough-elastic glue joints
● Workable glue joints
● Highest bonding strength with wood and furniture gluing
● High moisture resistance in compliance with D2 as per EN 204

Technical Data
D2 LEIM:
Minimum film formation temperature,℃ (MFFT) DIN 53 787 ~+3
Viscosity, Brookfield - RVT, 6/20/20, mPa.s ISO 2555 9,000 to 21,000
pH value (20 ℃) ISO 976 5.5 to 7.5

DIRECTIONS OF USE
Preliminary Statement
Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions.
Instructions for Use
Open Time
Open time (HPL on chipboard) : Quantity applied 100 g/m², minutes ~8; Quantity applied 200 g/m², minutes ~12

Pressing Time
(at approx. 0,5 N/mm², at 20℃) Surface bonding (Ch ipboard/HPL) :
Chipboard/HPL approx.100 g/m², minutes ≥6
Chipboard/HPL approx. 200 g/m², minutes ≥12
The data shown is based on 8-12 % wood moisture, 20 ℃ room and material temperature, 65 % relative ai r humidity and 0.5 N/mm² pressure.
The actual open time and needed pressing time will depend heavily on the working conditions such as temperature, humidity and absorption of the wood, surface characteristics, stresses in the material and application thickness ot the glue, etc.
The glue is supplied ready for use. If required, it can be thinned with water up to 3 %.
The working temperature of the workpiece and glue should be at least + 10℃.
Ensure that the parts to be bonded are close fitting and free from dust and grease.
Fit tolerances increase the setting time and reduce the bonding strength.
Dispersion glues themselves do not give rise to discoloration of the wood. Metal parts, however, may cause discoloration, due to their reaction with the tannin of the wood (especially with oak).

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.

Storage:
Store in the original tighly 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
ADDITIONAL INFORMATION
Disclaimer
Note: