



# TECHNICAL DATASHEET

## DANAFIX

### D3 wood adhesive for finger joints

**Product:**  
**D-coll 3330**

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## Product Description and Application:

D-coll 3330 is a water based PVAc adhesive especially designed for finger joints application. The adhesive has the water resistance class D3 according to DIN EN 204/205.

### Article number:

20 kg bucket:.....	ZVF3330SP20
650 kg container:.....	ZVF3330TK600

## Physical / Chemical Properties:

Adhesive:	3330
Type:.....	Water based PVAc dispersion
Colour:.....	White
Solid content [%]:.....	47
Viscosity (Brookf. RVF, 20 rpm) [cP]:.....	4.000
Density [kg/ltr.]:.....	1,1
pH:.....	2,5 – 3,5
Shelf life:.....	Minimum 12 months in unopened packing if stored cool.

### Glue joint:

Colour:.....	Transparent
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## Directions for use:

<b>Preparation:</b>	<i>Both surfaces must be clean, dry and well adjusted. Optimum results are obtained with newly worked wood.</i>
<b>Application:</b>	<i>The adhesive is applied on one surface. When bonding hard woods, two-sided application is recommended, as well as increasing assembly time and pressing time.</i>
<b>Wood moisture content:</b>	<i>8 - 14 %</i>
<b>Amount of glue:</b>	<i>100-200 g/m<sup>2</sup> depending on the surfaces and required open time.</i>
<b>Application temperature:</b>	<i>10 - 80 °C</i>
<b>Open assembly time:</b>	<i>10-12 min. 20 °C, 50 % RH pine, 9 % moisture Absorbent materials, less amount of glue, low moisture content in material and air and ventilation will influence the open time.</i>
<b>Pressure:</b>	<i>Soft wood as e.g. conifer wood 0,6-0,8 MPa (6-8 kp/cm<sup>2</sup>) Hard wood as e.g. deciduous wood 1,0-1,2 MPa (10-12 kp/cm<sup>2</sup>)</i>
<b>Cleaning:</b>	<i>Wet adhesive can be removed with water. Cured adhesive can only be removed by mechanically.</i>
<b>Storage:</b>	<i>Adhesive should be stored cool (max. 20 °C) in tightly closed packing.</i>

**All information's are meant as a guideline. Sufficient test should be carried out to determine final working condition.**

## Safety:

**Hazard Symbols:** None  
**Risk and Safety phrases:** None

*For further information concerning safety, refer to safety Datasheet.*

## Further information:

**DANA LIM offers a range of adhesives for professionals:**

*100-series: Upholstering adhesives  
200-series: Flooring adhesives  
300-series: Wall adhesives  
400-series: Wood adhesives  
500-series: Sealants & PU-foams  
600-series: Building-additives, fillers etc.  
700-series: Paper-, packaging- and newspaper adhesives  
800-series: Hot melt  
900-series: Cleaning-, release agents and hardeners.*

*The information and data contained in this data sheet are based on extensive laboratory testing and our practical experiences, and are meant for helping the user to find optimum working methods. As the conditions at the user are beyond our control, we make no warranties concerning the results, achieved by the products. The information's in this technical data sheet are typical values, intended as a guideline. They should not be regarded as product specifications. Please also refer to our standard sales conditions and terms of delivery.*