



TECHNICAL DATASHEET

DANAFIX

Wood adhesive for veneering

Product:**D-coll 3695****Date of issue:** 12.09.2018
(Replaces:)**Company** DANA LIM A/S
Københavnsvej 220, DK-4600 KøgePh.: 56 64 00 70, Fax.: 56 64 00 90, www.danalim.dk
Technical Service Ph.: 56 64 00 75**Prepared by:** Bo Brehmer**Product Description and Application:**

D-coll 3695 is a PVAc based wood adhesive and is specially designed for veneering under warm pressing. It suits the most common available veneer types.

Article numbers:20 kg bucket:

ZF3695SP20

120 kg drum:

ZF3695F120

Physical / Chemical Properties:**Adhesive:****3695**Type:

Water based PVAc-dispersion

Colour:

White

Solid content [%]:

49 ±1%

Viscosity (Brookf. RVF, 20 rpm) [cP]:

7.000 - 8000

Density [kg/ltr.]:

1,1

pH:

2,5 - 3,5

Shelf life:

Minimum 12 months in unopened packing if stored cool.

Cured joint:Colour:

Matt transparent

Directions for use:

Preparation:	<i>Both surfaces must be clean, dry and well adjusted. Optimum results are obtained with newly worked wood.</i>
Application:	<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>
Wood moisture content:	<i>Optimum at 10 - 14 % and up to 18 %.</i>
Amount of glue:	<i>100-200 g/m² depending on the surfaces and required open time.</i>
Application temperature:	<i>10 - 90 °C</i>
Open assembly time: 20 °C, 50 % RH pine, 9 % moisture	<i>6 - 10 min. Absorbent materials, less amount of glue, low moisture content in material and air and ventilation will influence the open time.</i>
Pressure:	<i>Soft wood as e.g. conifer wood 0,6-0,8 MPa (6-8 kp/cm²) Hard wood as e.g. deciduous wood 1,0-1,2 MPa (10-12 kp/cm²)</i>
Pressure times: pine approx. 50 % RH, approx. 9 % moisture content of the wood	<i>7-8 min. at 20°C, 50-60 sec. at 80°C, 30-40 sec. at 90°C. Pressure times should be increased for hard woods, two-sided application, higher humidity of the air and higher moisture content of the wood. The pressing time can be reduced if the wood is preheated. Full water resistant is obtained after app. 5-7 days.</i>
Vacuum impregnation:	<i>Conifer can be vacuum impregnates 48 hours after gluing.</i>
Cleaning:	<i>Wet adhesive can be removed with water. Dry adhesive can only be removed by organic solvents (e.g. acetone).</i>
Storage:	<i>Adhesive should be stored cool (max. 20 °C) in tightly closed packing. Must be protected from frost.</i>

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

Safety:

Hazard Symbols:	<i>None</i>
Risk and Safety phrases:	<i>None</i>

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.

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