

D310

TECHNICAL DATA SHEET

Ready-to-use one component adhesive for humidity resistant bondings, according to DIN EN 204, belonging to D3 group.

D4 group will be reached by adding a 5% of isocyanic hardener. The product passes the WATT 91 test, both as D3 and as D4.

D 310 is used to bond wood elements for doors, windows, partition walls and stairs, as well as laminated foils, solid wood, hard wood and exotic wood.

TECHNICAL DATA

Base	PVAc Dispersion
Appearance	White
Viscosity (Brookfield)	approx. 13.000 mPas*
Specific weight	approx. 1,09 g/cm ³
Solvent/cleaner	water
Hardener:	5% of isocyanic hardener
Shelf life with hardener	4 - 5 hours, during this time bondings with resistance belonging to D4 group can be reached.

APPLICATION

Method of application	toothed spatula, roller, brush, roller application equipment.
Grammage	approx. 120-200 g/m ²
Open time	approx. 4-6 minutes

* The above mentioned value is taken during the manufacturing cycle at a temperature of 20°C. It can vary slightly during the storage.

PROPERTIES

- **D 310** has got good flow properties on automatic application equipment.
- Once dried the adhesive flash lines are completely invisible.
- Bonding resistance according to DIN EN 204 and belonging to D4 group is reached after approx. 7 days.

INSTRUCTIONS FOR USE

Best conditions to obtain a perfect bonding:

- Wood, adhesive and room temperature by 18°C
- Wood humidity 8-12%
- Air humidity 60-75 %

D 310 and hardener has to be mixed accurately and applied on one side. The adhesive application on both sides is recommended in case of particularly stressed bonding, and/or with hard and exotic woods and/or by humidity resistant bondings with absorbing woods.

The bonding is immediate; adjustments can be done within the wet-sticking time.

Pressing time and wet-sticking time can vary according to temperature, kind of wood, wood humidity and thickness of adhesive applied.

The pressure strenght has to be measured in order to create an adhesive flash line as thin and closed as possible. The pressure however has not to be so strong to seal or to deform the wood.

Tools and application equipment have to be cleaned with water, right after being used.

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PRESSING TIME

for normal wood bondings	by 20°C - approx. 15 minutes
	by 50°C - approx. 5 minutes
	by 80°C - approx. 2 minutes
for surface bondings with laminated board	by 20°C - approx. 15-20 minutes
	by 50°C - approx. 5 minutes
	by 80°C - approx. 2 minutes

The pressing time has to be longer in case of thick materials where heat is needed to let the glue film penetrate.

STORAGE CONDITIONS

Keep the container tightly closed at a temperature between +15 and + 25 ° C.

Protect from moisture, heat and other external agents in the original packaging.

The adhesive, if stored correctly, is stable for 12 months.

PACKAGING

Buckets of 10 kg and 25 kg,

Tank of 1100kg

Our indications are based on laboratory tests and refer to normal conditions of use.

Since the processing methods and environmental conditions of use are beyond our control, we cannot provide guarantees on the quality of the results.

It is the user's responsibility to verify that the product is suitable for the application.

We therefore recommend carrying out adequate preventive tests before starting continuous production.