



Technical Data Sheet



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Pattex Wood Glue - Classic

CHARACTERISTICS

- High bonding strength
- Ideal for the assembly, joint and area bonding applications
- DIN EN 204 / D2

APPLICATION FIELD

- For assembly bonding applications (dowel, tongue and groove, mortise and tenor joints)
- For joints (solid wood, edge banding etc.)
- Large surface area bonding, HPL boards, hardboard etc.

INSTRUCTIONS FOR USE

Pretreatment

Work pieces should be clean and a tight fit. Woods with high oil or tannin content, such as teak, should be wiped off with acetone before applying the glue. Wood moisture content should be between 12 and 8%. Higher moisture content increases final setting time.

Glue application

Apply glue to one surface with a brush, plastic comb, glue roller, or glue application device. With hard woods glue must be applied to both surfaces. Do not use tools that contain iron (risk of discolouration).

Clamping pressure

Surface bonding > 0.2 N/mm²

Assembly bonding and hard woods > 0.5 N/mm²

Work pieces under tension generally required higher clamping pressure.

Pressing

Pressing can either be hot or cold with the usual tools, appliances or presses.



Clamping time

Clamping time depends on the ambient conditions, wood type and moisture content and the amount of glue applied. Under normal conditions minimum clamping time is:

1. Bonding wood
approx. 15-20 minutes at 20°C
approx. 10-15 at 30°C
2. Bonding HPL board
approx. 40 minutes at 20 °C
approx. 25 minutes at 40 °C
approx. 15 minutes at 60 °C

With hot pressing work pieces can be further worked after they have cooled.

Hot sealing technique

Hot sealing is only possible if glue is applied to both surfaces. Warming to 70-80°C softens the dried adhesive film which can then set.

Wood discolouration

The pH of Pattex Wood Glue - Classic is 3.5. With oil or tannin containing woods discolouration is unlikely if no iron-containing tools are used during glue application. Wood discolouration can be removed with a 2-3% aqueous oxalic acid solution.

Open time

Open time depends on room temperature, relative humidity, wood hardness and moisture content and the amount of glue applied. At a room temperature of 20°C open time is a maximum of 8 minutes. Locate work pieces while the glue is still wet.

TECHNICAL DATA

Composition	Synthetic resin glue based on polyvinyl acetate
Density	ca. 1,1 g/cm ³
Heat resistance	up to +70°C
Open time	up to 8 min
Application temperature	min. +5°C
Consumption	Approx. 150g/m ²
Colour	white
Joint colour	transparent
Shelf Life	12 months From date of production, when stored in cool, dry conditions, protected from sunlight



LIMITATIONS

Cleaning tools

Clean tools immediately after use with water. Soften encrusted glue with water and then remove.

Storage

Seal well, protect from frost. Cold temperatures cause the glue to thicken; acclimatize to working temperature and stir well before use. Generally this process does not impair quality. Stable for 12 months

PACKAGING

750ml plastic bottle

HEALTH AND SAFETY

Before using the product please see related Material Safety Data Sheet that is available on request.

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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