

PATTEX WOOD EXPRESS

DESCRIPTION

Pattex Wood Express is a white synthetic resin glue based on PVAC. It is a ready to use, fast setting wood glue that can be used to glue together all sorts of wood, wood composites and even laminates.

IDH	Packaging type	Size
2755964	Bottle	75g
2755965	Bottle	250g

CHARACTERISTICS

- Ideal for the assembly, joint and area bonding applications
- Short setting time
- High temperature resistance
- Indoor use

SCOPE OF USE

Fast setting glue for all types of bonding and hot and cold edge bonding.

- For assembly bonding applications (carcass bonding)
- For joints (solid wood and board joints)
- Veneer and plastic edge banding, except PVC, ABS and polyester edging not untreated or not sanded on rear side
- Surface area bonding, HPL boards etc.

APPLICATION DETAILS

Material preparation:

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 Pattex Wood Express to one surface with a brush, 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 > 0.5 N/mm²
- Work pieces under tension generally required higher clamping pressure.

Pressing:

Pressing can either be hot or cold with the usually 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 normal wood and wood materials

- approx. 12 minutes at 20 °C
- approx. 8 minutes at 30 °C

2. Bonding HPL board

- 15 minutes at 20 °C
- 8 minutes at 60 °C
- 4 minutes at 80 °C

3. Bonding veneer edging

- 6 minutes at 20 °C
- 90 seconds at 60 °C
- 60 seconds at 80 °C

Clamping times should be increased when bonding solid wood work pieces (invariably pre-warmed) and multi-layer compressed edging.

The above values are based on glue application of 150 g/m², lower amounts of glue lower the clamping time. With hot pressing technique only proceed with further work once the work pieces have cooled.

Wood discolouration:

The pH of Pattex Wood Express is 3,5. With oil-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 the open time is a maximum of 7 minutes.

Locate work pieces while the glue is still wet.

PLEASE NOTE**Cleaning:**

Clean with cold water directly after use. Soften encrusted glue with water and then remove.

Storage:

Store well-sealed

TECHNICAL DATA

pH	Approx 3.5
Bond strength	Pattex Wood Express joints are resistant to short term penetration by water and fulfil EN 204 (formerly DIN 68602) stress classes D1 and D2. Final strength of the glue is greater than that of the wood it bonds. Pattex Wood Express joints are thermal resistant up to approximately 70 °C, even 95 °C for short periods, such that subsequent veneering is possible.
Density (specific weight)	approx 1.1 g/cm ³
Joint properties	Elastic, tool-friendly, ageing-resistant
Application temperature	Do not apply below 6 °C. This temperature applies not only to room temperature but particularly to that of the work pieces and the glue itself.
Open time	Max. 7 minutes at room temperature (20 °C)
Amount required	Approx. 150g/m ² , depending on substrate absorbency

LIMITATIONS

Though adhesive is not water resistant, no long-term water immersion is recommendable. Put the cap back immediately after applying the glue since it cures very fast.

Storage

Store well-sealed and protected from frost.