



# PONAL DUO

Technical Data Sheet v.2, October 2025

## PONAL 2K PUR Spachtel

### CHARACTERISTICS

- for filling and gluing
- substance replacing and gap filling
- water resistance according to DIN EN 204 D4
- heat resistance according to WATT 91 > 6 N/mm<sup>2</sup> (DIN EN 14257)
- after curing processible like wood
- tack-free after 120 minutes
- editable after 4 hours
- high final strengths
- varnishability
- solvent and softener free

### APPLICATION FIELD

- Universal adhesive filler for repairing wood and wood-based materials, especially when replacing substance and restoring strength and function.
- For strong, gap-filling bonding of a wide variety of material combinations made of wood, metals, plastics, and mineral materials, including natural stone.
- Recommended and approved for the restoration of listed wooden components such as historic windows, doors, portals, staircases, picture frames, and furniture.



INSTRUCTIONS FOR USE

Pretreatment

At least one of the layers to be bonded should be absorbent. The material to be bonded should be dry (wood 8 to 12% moisture) and free of grease and dust. Clean laminates, metal etc. with solvent (washing benzene). Allow materials to acclimatize according to manufacturer's instruction. Clean wood rich in ingredients such as teak with acetone. Only glue working materials to non-treated surfaces (natural base). Painted surfaces should be stripped beforehand.

Application

Mixing of components

Add two strings of resin and one string of hardener (same lengths and thickness) and mix carefully. To get a precise mix ratio one string should be at least 5 cm.

Open time

After mixing open time is 10 minutes, depending on temperature.

Inking of the product

Product could be inked for example with Mixol Universal (Fa. Diebold). Input of ink should be low as possible. (Drop dosage).

Application of mixed ratio

Apply with all typical tools e.g. plastic spatula, notched trowel. For repairing and spatula work, filling of holes and slots apply generous. Re-workability of glued material after fully curing.

Pressing time

Pressing pressure is not required. Typically, a fixing time of 15-20 minutes is sufficient for stress-free parts (at 23°C and 50% humidity). According to temperature and humidity curing time is ca. 5 hours at 23°C. Continue editing after this time. Heat accelerates the curing, coldness delayed the curing process. Final strength is reached after 24 hours.

TECHNICAL DATA

Composition	2C Polyurethane adhesive
Mix ratio (Resin/hardener)	2:1
Open time, minutes	10, after mixing
Application temperature, °C	10 - 30, curing time depend on temperature
Consumption, g/m <sup>2</sup>	For spatula work optional, for gluing ca 150 - 250
Water resistance	according to DIN EN 204 D4
Shelf life, months	12

LIMITATIONS

Cleaning tools

Clean tools immediately with standard solvents, e. g. acetone, as long as the glue has not cured.

Storage

Store tightly close and in a dry and cool place at room temperature.

HEALTH AND SAFETY

It is recommended to consult the current safety data sheet for precautions and safety advice before starting processing.

The safety data sheet is available at [www.mysds.henkel.com](http://www.mysds.henkel.com).

Information for allergy sufferers on Tel. 0049 (0)211 797 0 (keyword emergency)

Avoid contact with skin and eyes. Keep out of reach of children.



DISPOSAL

Dried product residues can be disposed of with household/commercial waste. Dispose of large quantities separately. Waste code/EWC code 080501. Recycle empty packaging.

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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