Technical data sheet

PARACOL WOOD D3



CHARACTERISTICS

- One-component, white wood glue
- Extremely high bonding capacity
- Rapid curing
- Dries transparently
- Short press times
- Resistant to high temperatures (tested according to EN 14257 - WATT'91)
- Very short press times possible when using heat
- High water resistance (durability class D3 according to EN 204)

APPLICATIONS

- Gluing dowels, dovetails, mortise and tenon joints,...
- Tongue and groove bonding in floating parquet, softwood, chipboard...
- Applications complying with durability class D3 according to EN 204. Suitable for interior use with frequent moisture exposure and exterior use not exposed to weathering.
- Bonding of wooden window and door frames for interior and exterior use under shelter
- Surface bonding of decorative finishing foils
- Bonding of veneer
- Bonding in high-frequency press
- Surface bonding of laminate (HPL/CPL) in a continuous press
- Assembly bonding
- Suitable for the most common wood species and wood-based materials

TECHNICAL CHARACTERISTICS	
Type of product	PVA dispersion
Density (g/ml)	1
Viscosity	13000 mPa.s (Brookfield 20 rpm spindle 3, 23°C.)
Shear strength (N/mm²)	Shear strength at 80°C (EN 14257/WATT '91): 6.8 N/mm²
Discharge pressure	0.1 - 0.8 N/mm²
Press time	See application guidelines
Application temperature	+15°C to +30°C (optimal at 20°C)
pH	3
Minimum film formation temperature (MFFT)	± 7°C
Working time at 23 degrees C and 50% R.H.	8–10 minutes (at 150 g/m²)
Dry matter content	40 - 42%
Tensile strength after 5 min. (N/mm²)	3.3
Tensile strength after 15 min. (N/mm²)	6.2
Tensile strength after 30 min. (N/mm²)	7.2
Tensile strength D3 norm (N/mm², after 7 days at 23 degrees C and 50% R.H.): DIN 53787	15
Tensile strength D3 norm (N/mm², after 7d at 23dC & 50% R.H. & 4d of immersion in water): DIN 53787	3
Shelf life of unopened product	12 months

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DL CHEMICALS Since 1936 Manufacturer of Sealants

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Storage conditions	Store in a dry, cool place at +5°C to +25°C. Keep out of direct sunlight.

PACKING AND COLOURS
bucket 10kg - 27 pieces/pallet White
12 x flacon 250GR/box - 672 pieces/pallet White
bucket 25kg - 12 pieces/pallet White
bucket 5kg - 60 pieces/pallet White
12 x flacon 750GR/box - 480 pieces/pallet White

METHOD OF USE

Preparation

- The user needs to make sure that the product is suitable for the application. Consult our technical service if necessary.
- All parts should mate well and must be free from dust and grease. If the parts do not fit, the setting time will be longer and the bond strength will be lower. The joints should be processed shortly before bonding.
- Stir the product well.

Application

- Apply the product in a thin layer on one side or, in case of high water resistance requirements, on both sides using a brush, roller, spatula, fine notched trowel or glue spreading machine.
- Assemble the parts and then press them together.
- Minimum press times for assembly joints: 8–15 min; tongue and groove joints: 10–15 min; surface bonding of HPL/CPL in a continuous press at 70°C: 45 sec; surface bonding of decorative or finishing foils in a continuous press: 5–10 sec; bonding in a high-frequency press with longitudinal heating: >15 sec.
- Respect the open time and press time. These depend strongly on working conditions such as temperature, relative humidity, porosity of the material, glue quantity and moisture content of the wood. Recommended conditions:
  - Substrate and ambient temperature: 18°C - 20°C
  - Wood moisture content: 8 - 10%
  - Relative humidity: 40 - 60%

Consumption

- Surface bonding: 60–140 g/m²
- Assembly: 160–180 g/m²

Cleaning

- Before curing: Tools, surfaces and uncured residues can be removed with water.

SAFETY

Consult the safety information on the packaging and the safety data sheet for more information.

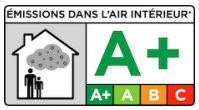
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POINTS OF ATTENTION

- Do not dilute the product.
- In some cases, discolouration may occur on certain wood species (beech or cherry). Iron in combination with tannins may also cause discolouration (e.g. oak). It is therefore recommended to carry out a test beforehand
- Prolonged storage and high temperatures may lead to an increase in viscosity, but do not affect the adhesive properties of the glue. Stir the adhesive well before use.

TECHNICAL APPROVALS AND QUALITY LABELS

- French VOC emission class A+



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