

## Adhesive 3311

D3 PVAc adhesive with high heat resistance (fulfills WATT 91)

Version: 10 (2023-01-21)

Adhesive 3311 is fast setting and has a high heat resistance. It is rather effective in radio frequency presses.

### Product Specification

<b>Product Type</b>	PVAc Adhesive
<b>Delivery Form</b>	Liquid
<b>Color</b>	White
<b>Viscosity</b> at time of production	8000 - 15000 mPa·s, Brookfield RVT, sp. 6, 20 rpm, 25°C/77°F
<b>pH</b> at time of production	2.5 - 4.0, 25°C/77°F
<b>Dry Content</b>	48.5 - 51.5 %
<b>Density (average)</b>	Appr. 1090 kg/m <sup>3</sup>
<b>Formaldehyde Info</b>	The product contains very low content of free formaldehyde, <600 ppm

**Glue Line Properties** Light coloured glue lines. High degree of heat and creep resistance. High degree of moisture and water resistance. Gives elastic glue lines. Fulfils EN 204 - D3 and WATT 91. Conforms to JAIA 006151.

### Storage Conditions and Storage Life

<b>Storage Life 20°C/68°F</b> , from time of production	6 months
<b>Storage Life 30°C/86°F</b> , from time of production	2 months
<b>Recommended Storage Temperature</b>	Min: 15°C / 59°F Max: 20°C / 68°F
<b>Short Term Temperature Exposure</b>	Only short time exposure to temperatures below 5°C / 41°F and above 30°C / 86°F is acceptable.
<b>Storage Conditions Info</b>	Frozen and thawed product cannot be used due to irreversible changes in the product. During storage the glue will mature and the viscosity can increase. The product can form a skin on the surface if the container is not properly closed. The product shall always be stored in closed packaging.

### Processing Instructions

<b>Applications</b>	Flooring, Interior doors, Solid wood lamination, Veneering
<b>Press Type</b>	Hot Press, Cold Press, Continuous Press, Clamp Carrier, Radio Frequency Press
<b>Discolouration Of Wood Information</b>	The product does not discolour the wood. However, iron which might come from the glue spreader can together with the tannic acids in some wood species, especially oak, give a discolouration.
<b>Gluing of Impregnated Wood</b>	Can in most cases be used but must be evaluated in each case.

#### Contact Information

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### Glue spread

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Solid wood lamination	120 - 250 g/m <sup>2</sup> , 11 - 23 g/ft <sup>2</sup>
Veneering	90 - 150 g/m <sup>2</sup> , 8 - 14 g/ft <sup>2</sup>
Flooring	90 - 175 g/m <sup>2</sup> , 8 - 16 g/ft <sup>2</sup>
BOF/BOS board on frame / board on styles	120 - 300 g/m <sup>2</sup> , 11 - 28 g/ft <sup>2</sup>

When gluing hard and oily wood species the material should be newly planed and the adhesive should be spread on both surfaces to be glued.

### Assembly Time

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Values were measured under conditions pine-pine, 65% RH

<b>Conditions</b>	<b>150 g/m<sup>2</sup></b>
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<b>Open, 20°C</b>	8 min
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<b>Closed, 20°C</b>	10 min
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<b>Open, 30°C</b>	4 min
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<b>Closed, 30°C</b>	5 min
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### Pressing

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<b>Glue Line Temperature</b>	Min: 10 °C / 50 °F , Max: 80 °C / 176 °F
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<b>Pressing Time 20°C</b>	7 min, pine-pine, 65%RH, 150 g/m <sup>2</sup> , 15 g/ft <sup>2</sup>
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<b>Pressure</b>	0.1 - 1.0 MPa
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### Preparation of Material

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<b>Moisture Content of Wood</b>	5 - 14%, Preferably 7 - 10%
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<b>Temperature of wood</b>	In order to meet the given press times the temperature of the wood must not be below 20°C / 68°F.
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<b>Preparation of Material</b>	For best result the wood must be smoothly planed. For optimum bond strength the bonding operation shall take place within 24 hours after preparation.
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### Post Curing

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Can be processed further after 2-6 hours, but best result is achieved if samples are left 24 hours.

The standard can be fulfilled after 7 days conditioning.

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### Handling and Environmental Information

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#### Handling

Avoid direct contact with the products. Always wear protective gloves and protective goggles.  
In case of skin contact, clean the affected skin area immediately with soap and lukewarm water.

#### Cleaning

For cleaning of equipment and tools, use lukewarm water.  
Cleaning should start before the system dries.

#### Waste Handling

Adhesive: The product is not classified and not regarded as hazardous waste.  
Leave residues to cool down and dry or cure before sending it off for disposal.  
Attention! National and/or regional differences in regulations may prevail. Please contact the responsible authorities.

#### Waste Water Treatment

Waste water treatment can be performed by using different methods such as chemical precipitation, mechanical precipitation and biological treatment. Permissions and requirements for handling waste water and sediment are controlled by the local authorities. Always consult with the responsible authorities and third party companies involved in handling the waste streams.

#### Health And Safety

The Safety Data Sheet provides information regarding health and safety. Study this information carefully.

The information is based on laboratory tests and practical experience. It is introductory and intended to help the user find the most suitable method of working. Since the user's production conditions are beyond our control, we cannot be held responsible for the results of the work which is affected by local circumstances. In each particular case testing and continuous control are recommended.

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