

## Product Information

### Wood adhesive system 3326

- General assembly glue

3326 is all-round glue that is developed to fit as many applications as possible. It provides good bonding to wood and even hard and difficult to glue wood species.

#### Product Specification

3326					
<b>Product</b>	PVAc adhesive				
<b>Delivery Form</b>	Liquid				
<b>Colour</b>	White				
<b>Viscosity</b> (at time of production)	7000 - 14000 mPas (Brookfield RVT sp6, 20rpm at 25°C / 77°F)				
<b>Dry Content</b>	45 - 48%				
<b>Density</b>	App. 1080 kg/m <sup>3</sup>				
<b>pH</b> (at time of production)	5,0 - 7,0 (at 25°C / 77°F)				
<b>Storage Life</b> (months)	<table border="1"> <thead> <tr> <th>20°C/68°F</th> <th>30°C/86°F</th> </tr> </thead> <tbody> <tr> <td>36</td> <td>18</td> </tr> </tbody> </table>	20°C/68°F	30°C/86°F	36	18
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36	18				
<b>Storage Condition</b>	<p>Recommended storage temperature 15-20°C. Only short term exposure to temperatures below 5°C or above 30°C is acceptable.</p> <p>Frozen and thawed product cannot be used due to irreversible changes in the product.</p> <p>During storage the glue will mature and the viscosity can increase.</p> <p>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.</p>				
<b>Formaldehyde Info</b>	Contains no formaldehyde, the system fulfils F****.				
<b>Glue Line Properties</b>	Gives elastic glue lines. Light coloured glue lines. EN204 class D1				
<b>Approvals</b>	This system is classified as F**** with the JAIA registration number 005449 (Japan Adhesives Industry Association).				
<b>Discolouration</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.				

#### Contact Information

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[www.akzonobel.com/adhesives](http://www.akzonobel.com/adhesives)

Version: 06 (2016-04-29)

Reason for changes: Updates in Product Specification

## Gluing Operation Information

<b>Applications</b>	Edge glued panels General assembly Others Solid wood lamination	
<b>Press Type</b>	Clamp Carrier Cold Press Continuous Press High Frequency Hot Press	
<b>Glue line temperature</b>	10 - 80°C	
<b>Press Time, 20°C / 68°F</b> (pine-pine, 65% RH, 150 g/m <sup>2</sup> , 15 g/ft <sup>2</sup> )	8'	
<b>Press Time, 30°C / 86°F</b> (pine-pine, 65% RH, 150 g/m <sup>2</sup> , 15 g/ft <sup>2</sup> )	--	
<b>Pressure</b>	0,1 - 1,0 MPa	
<b>Assembly Time, 20°C / 68°F</b> (pine-pine, 65% RH, 150 g/m <sup>2</sup> , 15 g/ft <sup>2</sup> )	Open: 8'	Closed: 10'
<b>Assembly Time, 30°C / 86°F</b> (pine-pine, 65% RH, 150 g/m <sup>2</sup> , 15 g/ft <sup>2</sup> )	Open: 4'	Closed: 5'
<b>Glue Spread</b>	Edge glued panels: 120 - 180 g/m <sup>2</sup> General assembly: 90 - 300 g/m <sup>2</sup> Others: 90 - 300 g/m <sup>2</sup> Solid wood lamination: 150 - 250 g/m <sup>2</sup>	
<b>Moisture content of wood</b>	5 - 15%, preferably 7 - 10%	
<b>Preparation of wood</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.	
<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.	
<b>Gluing of impregnated wood</b>	Can in most cases be used but must be evaluated in each case.	
<b>Post curing</b>		

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## Machinery

<b>Applicator</b>	Toothed trowel Brush Hand roller
<b>Mixer</b>	Not applicable
<b>Accessories</b>	Not applicable

## Handling and HSE info

<b>Handling</b>	Always use gloves and goggles when handling the product.
<b>Cleaning</b>	Use lukewarm water for glue on skin and machinery. Cleaning should start before the system dries.
<b>Waste handling - of the products</b>	Normally not to be considered as hazardous waste. Leave residues to dry before sending it off for disposal. For 2 component systems the hardener may be considered as hazardous waste, check the SDS (section 13).  <b>NOTE!</b> There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.
<b>Waste water treatment - of the waste water</b>	<u>Chemical precipitation → drain*</u> Please contact Environmental Advisor at the Environmental Department for further information regarding chemical precipitation.  * municipal sewage with biological treatment  <b>For more info, see General Information.</b>  <b>NOTE!</b> There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.
<b>Health and Safety</b>	For more information, see respective SDS.

### Legal clause

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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