

## Product Information

### Door and window system 3346 / 3336

- Suitable for applications with high moisture resistance

For the gluing of windows, doors, wall panels, outdoor furniture, impregnated wood, interior fittings in bathrooms and similar, where high moisture and water resistance are required

### Product Specification

	3346	3336								
<b>Product</b>	PVAc adhesive	PVAc hardener								
<b>Delivery Form</b>	Liquid	Liquid								
<b>Colour</b>	White	Transparent								
<b>Viscosity</b> (at time of production)	9000 - 16000 mPas (Brookfield RVT sp. 5, 20 rpm, 25°C / 77°F)	100 mPas								
<b>pH</b> (at time of production)	5,0 - 7,0 (at 25°C / 77°F)	0-1 (at 25°C / 77°F)								
<b>Storage Life</b> (months from time of production)	<table border="1"> <thead> <tr> <th>20°C/68°F</th> <th>30°C/86°F</th> </tr> </thead> <tbody> <tr> <td>6</td> <td>---</td> </tr> </tbody> </table>	20°C/68°F	30°C/86°F	6	---	<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>---</td> </tr> </tbody> </table>	20°C/68°F	30°C/86°F	36	---
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6	---									
20°C/68°F	30°C/86°F									
36	---									
<b>Storage Condition</b>	<p>Storage temperature 15°C to 20°C / 59°F to 68°F</p> <p>Only short term exposure to temp below 0°C / 32°F or above 30°C / 86°F is acceptable.</p> <p>Frozen and thawed product cannot be used due to irreversible reactions in the product.</p> <p>The product can form a skin on the surface if the container is not properly closed.</p>	<p>Storage temperature 15°C to 20°C / 59°F to 68°F</p> <p>Only short term exposure to temp below 0°C / 32°F or above 30°C / 86°F is acceptable.</p>								
<b>Formaldehyde Info</b>	Contains no formaldehyde, the system fulfils F****									
<b>Density</b>	Appr. 1090 kg/m <sup>3</sup>	Appr. 1280 kg/m <sup>3</sup>								
<b>Glue Line Properties</b>	Fulfils the requirements in EN 204, class D4 and WATT 91. Full water resistance of the glue joint is reached after 7 - 14 days.									
<b>Approvals</b>	Tested and approved by IFT in Rosenheim, Germany according to the requirements in EN 204, class D4 and WATT 91. Holds KOMO certification GCT 32557.									
<b>Discolouration</b>	3346/3336 can in some cases cause discolouration of wood. To avoid this risk a gluing test is recommended.									

### Contact Information

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www.akzonobel.com/adhesives

Version: 06 (2020-05-12)

Reason for changes: Change in storage life for 3346

## Gluing Operation Information

<b>Applications</b>	Windows Doors		
<b>Press Type</b>	Cold press Hot press High frequency press		
<b>Glue line temperature</b>	10°C - 80°C / 50 - 176°F		
<b>Press Time, 20°C / 68°F</b> (pine-pine, 65% RH, 150 g/m <sup>2</sup> , 15 g/ft <sup>2</sup> )	20 - 45 min		
<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>Pot Life</b>	<b>15°C/59°F</b>	<b>20°C/68°F</b>	<b>30°C/86°F</b>
		60 days	
<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: ---	Closed: Maximum 12 min	
<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: ---	Closed:---	
<b>Mixing Ratio</b> (by weight)	100:5, adhesive:hardener		
<b>Mixing Time</b>	30 sec with electrical mixer, 2 minutes by hand. The mixture must be homogenous.		
<b>Glue Spread</b>	Single sided spreading: 60 - 200 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>	Full water resistance of the glue joint is reached after 7-14 days.		

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## Machinery

<b>Applicator</b>	Roller spreaders may be ordered through our technical representative.
<b>Mixer</b>	6204- Mixing system for EPI, PVAC
<b>Accessories</b>	Glue chiller may be ordered through our technical representative. 6282- Control unit 6284- Tank monitoring system 6289- Day tanks 6201-50 Accessory for glue mixers

## 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</b> - of the products	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</b> - of the waste water	<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>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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