

Adhesive system 3347/3336

Version: 01 (2025-03-06)

Suitable for door and window applications requiring high moisture resistance

Adhesive system 3347/3336 is suitable for 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

	Adhesive 3347	Hardener 3336
Product Type	PVAc Adhesive	Hardener
Delivery Form	Liquid	Liquid
Color	White	Transparent yellowish
Viscosity at time of production	13000 - 17000 mPa·s , Brookfield RVT , sp. 6 , 20 rpm , 23°C/73°F	1 - 100 mPa·s , 20°C/68°F
pH at time of production	4.5 - 5.5, 23°C/73°F	0.5 - 1.5, 20°C/68°F
Density (average)	Appr. 1090 kg/m³	
Density (interval)		1265 - 1300kg/m³
Formaldehyde Info	The product contains very low content of free formaldehyde, <600 ppm	
Active Ingredient Amount		27.5 - 28.5 %

Glue Line Properties Fulfills the requirements in EN 204, class D4 and WATT 91. Full water resistance of the glue joint is reached after 7 - 14 days.

Storage Conditions and Storage Life

	Adhesive 3347	Hardener 3336
Storage Life 20°C/68°F , from time of production	6 months	24 months
Recommended Storage Temperature	Min: 15°C / 59°F Max: 30°C / 86°F	Min: 15°C / 59°F Max: 20°C / 68°F
Short Term Temperature Exposure	Only short time exposure to temperatures below 5°C / 41°F and above 30°C / 86°F is acceptable.	Only short time exposure to temperatures below 5°C / 41°F and above 30°C / 86°F is acceptable.
Storage Conditions Info	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. 6 months storage life if stored in original unopened container.	

Contact Information

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Processing Instructions

Applications	Exterior doors, Interior doors, Window Scantlings
Press Type	Radio Frequency Press, Hot Press, Cold Press
Discolouration of Wood Information	Can in some cases cause discolouration of wood. To avoid this risk a gluing test is recommended.
Gluing Of Impregnated Wood	Can in most cases be used but must be evaluated in each case.

Mixing Ratio

	Adhesive 3347	Hardener 3336
Mixing ratio per weight	100	5

Mixing Instructions 30 s with electrical mixer, 2 minutes by hand. The mixture must be homogenous.

Pot Life

Mixing Ratio	20°C/68°F
100:5	10 days

Glue spread

Single sided spreading: 60 - 200 g/m².

Assembly Time

Pine-pine, 65% RH

Conditions	100:5, 150 g/m²
Open, 20°C	-
Closed, 20°C	≤12 min

Pressing

Glue Line Temperature	Min: 10 °C , 50 °F , Max: 80 °C , 176 °F
Pressing Time 20°C	20-45 min , pine-pine, 65%RH, 150 g/m ² , 15 g/ft ²

Pressing Time

For mixing ratio 100:5

Pressure 0.1 - 1.0 MPa

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Preparation of Material

Moisture Content of Wood 5 - 15% , Preferably 7 - 10%

Temperature of wood In order to meet the given press times the temperature of the wood must not be below 20°C / 68°F.

Preparation of Material For best result the wood must be smoothly planed. For optimum bond strength the bonding operation shall take place within 24 hours after preparation.

Post Curing

The full moisture resistance will be reached after approximately 14 days.

Handling and Environmental Information

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

Hardener: Depending on classification the hardener may be considered as hazardous waste, check the SDS (section 13).

Adhesive: For waste handling, please refer to section 13 in the SDS.

Adhesive/hardener mixture: Can normally be treated as non-hazardous waste when fully cured.

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 a guideline 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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