

Product Information

Doweling system 3372

- Suitable for automatic doweling machines.

Developed for doweling gluing in automatic doweling machines.

Product Specification

3372		
Product	PVAc adhesive	
Delivery Form	Liquid	
Colour	White	
Viscosity (at time of production)	200 – 1000 mPas (Brookfield LVT sp3, 60 rpm at 25°C / 77°F)	
Density	1060 kg/m ³	
Dry Content	33,5 – 36,5%	
pH (at time of production)	4,0 – 6,0 (at 25°C / 77°F)	
Storage Life (months)	20°C/68°F	30°C/86°F
	36	18
Storage Condition	<p>Recommended storage temperature; 15°C - 20°C / 59°F - 68°F. Only short term exposure to temp below 5°C / 41°F or above 30°C / 86°F is allowed.</p> <p>Frozen and thawed product cannot be used due to irreversible reactions in the product. The product can form a skin on the surface if the container is not properly closed.</p> <p>The products shall always be stored in closed packaging.</p>	
Formaldehyde Info	Contains no formaldehyde, the system fulfils F****.	
Glue Line Properties	<p>Light colored glue lines.</p> <p>Gives elastic glue lines.</p> <p>EN 204 Class D1</p>	
Approvals	No official approvals.	
Discolouration	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

Version: 07 (2016-09-28)

Reason for changes: Added min temp at Glue Line Temperature

Gluing Operation Information

Applications	Doweling	
Press Type	Automatic doweling machines	
Glue line temperature	12 - 70°C / 53 - 158°F	
Press Time, 20°C / 68°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	N/A	
Press Time, 30°C / 86°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	N/A	
Pressure	N/A	
Assembly Time, 20°C / 68°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	Open: 7 min	Closed: 10 min
Assembly Time, 30°C / 86°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	Open: -	Closed: -
Glue Spread	Enough to provide a thin layer on the wood tap.	
Moisture content of wood	Dowel 4 - 5%, hole 8 - 14%	
Preparation of wood	For best result the wood must be smoothly planed. For optimum bond strength the bonding operation shall take place within 24 hours after preparation.	
Temperature of wood	In order to meet the given press times the temperature of the wood must not be below 20°C / 68°F.	
Gluing of impregnated wood	Can in most cases be used but must be evaluated in each case.	
Post curing	Can be processed further after 2 - 6 hours, but best result is achieved if samples are left 24 hours.	

Machinery

Applicator	Doweling machine, nozzles
Mixer	Not applicable
Accessories	-

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Handling and HSE info

Handling	Always use gloves and goggles when handling the product.
Cleaning	Use lukewarm water for glue on skin and machinery. Cleaning should start before the system dries.
Waste handling - 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). NOTE! There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.
Waste water treatment - 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 For more info, see General Information. NOTE! There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.
Health and Safety	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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