

# KOMBICOLL SUPER-N D3

## Properties

Kombicoll Super-N D3 is a PVAc adhesive with good water resistance which meets the requirements of class D3 standard DIN EN 204. Kombicoll Super-N D3 sets very quickly. If heat is applied, very short pressing times can be achieved. The bonded joints are characterised by a good high-temperature resistance. Machining the joints causes very little wear on the tool.

## Processing Instructions

The open time and setting time depend strongly on working conditions such as temperature, humidity, absorbency of the materials being worked, amounts applied and material stress. Good results will be achieved if the following conditions are observed:

Room, material temperature & glue temperature	20 °C
Wood moisture level, relative	8 - 12 %
Humidity	65%
Amount of adhesive to apply according to purpose	50 - 150 g/m <sup>2</sup>
Open time approx.	approx. 8 - 12 min
Pressure for stress-free workpieces	0,1 - 1 N/mm <sup>2</sup>
Pressing time Surface bonding (Chipboard / HPL)	at 20 °C: 30 - 40 min at 70 °C: approx. 1 min

## Classification D3 as per DIN EN 204

### Applying the adhesive

Apply Kombicoll Super-N D3 thinly and evenly to one side or, if a high degree of water resistance is required, to both sides, using a spreading machine, glue roller, serrated trowel, glue brush or another suitable device.

### Wood preparation

All parts should mate well and be dust- and grease-free. Fitting tolerances will lead to longer setting times and weaker bonds. The joints should be cut shortly before bonding.

## Application

Examples of climatic conditions and areas of application:

- D3: Interior with frequent short-term exposure to running or condensed water and/or occasional high level of humidity. Exterior not exposed to weather.
- Surface bonding of decor-finish film
- High-frequency bonding
- Surface bonding of HPL/CPL in short cycle presses
- Carcass and assembly gluing
- Solid wood gluing
- Doors and stairs gluing
- Windows, window scantlings and composite window elements

## Pressing

Lay the items to be bonded together within the workable time and press them for as long a time as is needed to achieve the required initial firmness upon release. The pressure should be high enough to ensure contact of the parts over the entire area of the joint. Depending on the material and the type of bond being used, the mechanical firmness required for further processing of the parts is achieved within the shortest possible space of time. The higher levels of water resistance form more slowly and should be tested not earlier than 7 days after bonding.

## Wood discolouration

The different composition of timber components, depending, among other factors, of the growth region and the wood preparation, can lead to unpredictable discolourations in various wood species, as for example beech, cherry tree and others. Moreover, iron, combined with the wood's tannic acid, can also lead to wood discolourations, specially in oak. We recommend test runs!

## General notes

Storage tanks, tubes and application tools made of steel, galvanised steel, aluminium or other non-ferrous metals are not recommendable due to the weakly acidic formula of the dispersion, which might lead to corrosion. We recommend the use of storage tanks, tubes and application tools made of stainless steel or plastic (hardened PVC, polyethylene, polyester resin).

## Chemical-technical data

Based on	PVAc dispersion
Colour	white, transparent after drying
Viscosity (Brookfield)	approx. 12.000 mPa.s
pH value:	approx. 3

## Storage

Stock Kombicoll Super-N D3 in tightly sealed original containers, in a frost-free place. After a longer time of storage, Kombicoll Super-N D3 might have a higher viscosity. If that is the case, simply mix it thoroughly to make it ready for use again. The glue can be stored for up to 12 months.

## Safety advice

Please observe the information given on our EC-safety data sheets! (Please request).

## Cleaning

Clean machines and utensils with water before the adhesive dries.

## Labelling

According to the current Hazardous Substances Ordinance, Kombicoll Super-N D3 is not subject to labelling.