



TECHNICAL DATA

MEKOL D3

Dispersion one component water resistant adhesive for gluing wood

DESCRIPTION

MEKOL D3 is dispersion glue for gluing of all kinds of wood where water resistant joint D3 according to EN 204 and highly temperature resistant joint according to DIN EN 14275, test method **WATT 91: tensile strength at 80°C > 7, 0 N/mm²** are required.

FIELDS OF APPLICATION

The adhesive is used first of all in cases where water resistance according to stress group D3 under EN 204 is required.

- where joint would be exposed to high relative air humidity, condense or short term water exposure- doors, windows, furniture for humid spaces, kitchen working surfaces, stair construction, laying laminated floors
- high bond strength and fast setting
- temperature and solvent resistance

The adhesive is suitable for:

- cold gluing, gluing on heated presses and (only with B component) gluing on high frequency presses
- block gluing and surface gluing of all kinds of wood
- assembly gluing

CHARACTERISTICS

Chemical base	polyvinyl acetate dispersion
Colour	white, dry film is translucent
Setting time	fast
Viscosity at 23°C (ISO 2555-Brookfield RVT, spindle 5/20 rpm)	7 000 - 10 000 mPas
pH value (ISO 976)	approx. 3,0
Chalk point	approx. 4°C
Open time at 20 °C, 65% RH, beech wood with 10% moisture content:	
- spread quantity 100 g/m ²	approx. 2 minutes
- spread quantity 200 g/m ²	approx. 7 minutes

The final water-resistance is achieved in seven days after gluing.

APPLICATION

After longer storing period good stirring of adhesive is recommended.

The materials to be bonded must be dry, free from dust, oil and grease and be conditioned.

Adhesive can be applied with brush, spatula or glue roller, with gluing devices fitted to frame presses and dove tailing machines or with glue spreaders. Single-side application of the adhesive is usually sufficient. When bonding wood types which are difficult to bond or applications where high quality of bond is required, two-sided application is recommended.

The most convenient binding conditions are:

temperature of wood and all materials involved	18 - 20°C
moisture content of wood	8 - 10 %
relative humidity	60 - 70 %
spread quantity	
-edge and joint bonding	120 - 180 g/m ²
-veneering	100 - 150 g/m ²

pressure

- joining and surface gluing of HPL	min. 0,5 N/mm ²
- veneering	min. 0,2 N/mm ²

The pressing time:

depends on temperature of gluing, humidity of wood, spread quantity, pressure and type of wood.

At such conditions the pressing times should be at least:

edge bonding (soft- / hardwood) at 20°C	15 / 30 minutes
edge bonding (soft-, hardwood) at 50°C	3 / 5 minutes
surface bonding (HPL boards) at 20°C	15 - 20 minutes
surface bonding (HPL boards) at 50°C	6 - 8 minutes
surface bonding (HPL boards) at 70°C	4 - 6 minutes
veneering (thickness 0,6 - 0,8 mm) at 20°C	10 - 15 minutes
veneering(thickness 0,6 - 0,8 mm) at 50°C	6 - 8 minutes
veneering(thickness 0,6 - 0,8 mm) at 70°C	4 - 6 minutes

Bonding at higher humidity content of wood, higher quantity of adhesive applied, lower temperatures of material and when used as a two component glue the time of pressing must be prolonged.

Do not glue at temperatures below 15°C!

Additional working operations are possible 12 hours after gluing.

CLEANING

Machines, tools and packaging should be washed with warm water before glue is dried.

PACKING

Polyethylene bottles	500 g net
polyethylene vessels	5 kg net
polyethylene vessels	15 kg net

STORAGE

The adhesive and the hardener should be stored in factory-sealed containers at temperature between +5°C and +25°C.

Protect them from the frost. Storing at temperatures above +25°C shorten the shelf life of adhesive considerable.

Properly stored adhesive is usable at least 12 months.

Always stir the adhesive well before use.

The information provided herein, especially recommendations for the usage and application of our products, is based on our knowledge, results of laboratory tests and practical experience gained to date.

We guarantee a constant quality of our products under our technical specifications. Technical advice of our application department is available without obligation. This does not release the buyer from testing our products in his own responsibility with respect to their suitability for intended application and application process. Such an evaluation should be repeated if materials are changed in any way or bought from a different source.

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