

Product Information

3030

- **Fast-setting formaldehyde free D3 PVAc adhesive.**

3030 is suitable for gluing board on frame, EGP, 2 layer parquet and finger-jointing. The glue is fast setting and fulfils the requirements in EN 204, class D3.

Product Specification

3030					
Product	PVAc adhesive				
Delivery Form	Liquid				
Colour	White				
Viscosity (at time of production)	8 000 – 15 000 mPas (Brookfield RVT sp 5, 20 rpm at 25°C / 77°F)				
Density	1075 kg/m ³				
Dry Content	44,5% - 47,5%				
pH (at time of production)	4,0 - 5,0 (at 25°C / 77°F)				
Storage Life (months)	<table border="1" style="width: 100%;"> <thead> <tr> <th style="width: 50%;">20°C/68°F</th> <th style="width: 50%;">30°C/86°F</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">6</td> <td style="text-align: center;">2</td> </tr> </tbody> </table>	20°C/68°F	30°C/86°F	6	2
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6	2				
Storage Condition	Recommended storage temperature 15-20°C. Only short term exposure to temperatures below 5°C or above 30°C is acceptable. Frozen and thawed product cannot be used due to irreversible changes in the product. 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.				
Formaldehyde Info	The product is completely formaldehyde free.				
Glue Line Properties	Gives elastic glue lines. High degree of moisture and water resistance, EN 204, class D3. Light coloured glue lines.				
Approvals	EN 204, class D3				
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

Stockholm, Sweden +46 8 743 40 00
 High Point, USA +1 336 841 5111
 Singapore +65 6762 2088
 Medellin, Colombia +57 4 3618888
www.akzonobel.com/adhesives

Version: 02 (2016-06-22)

Reason for changes: Updates in Product Specification and Assembly time

Gluing Operation Information

Applications	Board on frame, 2 layer parquet, EGP, finger-jointing			
Press Type	Hot press, cold press			
Glue line temperature	Not below 15°C			
Press Time		50°C	70°C	90°C
	0,6 mm	--	1 min	--
	3,6 mm	--	3 min	--
	6,0 mm	--	--	--
Pressure	0,1 - 1,0 MPa			
Assembly Time, 20°C / 68°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	Open: 4 min		Closed: 8 min	
Assembly Time, 20°C / 68°F (pine-pine, 65% RH, 180 g/m ² , 18 g/ft ²)	Open: 5 min		Closed: 10 min	
Assembly Time, 30°C / 86°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	Open: 2 min		Closed: 5 min	
Glue Spread	Solid wood lamination: 150 – 250 g/m ² Veneering: 90 – 150 g/m ² Board on frame: 120 g/m ² EGP: 120-180 g/m ² Two layer parquet: Birch plywood: 130 -- 160 g/m ² Two layer parquet: HDF: 90 – 120 g/m ²			
Moisture content of wood	5 - 14%, preferably 7 - 10%			
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				

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Machinery

Applicator	Roller spreaders may be ordered through our technical representative.
Mixer	Not applicable
Accessories	Glue chiller may be ordered through our technical representative. 6282- Control unit 6284- Tank monitoring system 6289- Day tanks

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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