

Product Information

LignuPro® 3 Adhesive A363

- Fast setting formaldehyde free D3 PVAc adhesive



Wood adhesive A363 is fast setting and suitable for radio frequency presses. A363 fulfils the requirements for EN 204, class D3 and EN14257, WATT 91. It is formaldehyde free and compliant with IKEA IOS-MAT-0003.

Product Specification

LignuPro® 3 Adhesive 363		
Product	PVAc adhesive	
Delivery Form	Liquid	
Colour	White	
Viscosity (at time of production)	12000 - 18000 mPas (Brookfield RVT, sp.5, 20 rpm, 23°C / 73.5°F)	
Density	Appr. 1100 kg/m ³	
Dry Content	55.0 – 58.0%	
pH (at time of production)	2.0 – 4.0 (25°C / 77°F)	
Storage Life (months from time of production)	20°C/68°F	30°C/86°F
	6	3
Storage Condition	<p>Recommended storage temperature; 10°C - 25°C / 50°F - 77°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.</p> <p>The product can form a skin on the surface if the container is not properly closed. The products shall always be stored in closed packaging.</p> <p>When A363 is stored for a longer period of time the viscosity of the dispersion may increase. Stirring the emulsion will bring back the viscosity to original level.</p>	
Formaldehyde Info	Formaldehyde free	
Glue Line Properties	<p>Light colored glue lines.</p> <p>High degree of moisture and water resistance.</p> <p>Gives elastic glue lines.</p> <p>Compliant with IOS-MAT-0134 Class 5.</p>	
Approvals	Approvals ongoing.	

Contact Information

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www.akzonobel.com/adhesives

Version: 02 (2021-02-22)

Reason for changes: More narrow range for dry content.

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.
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Gluing Operation Information

Applications	Flooring Solid Wood Lamination Edge glued panels Veneering Doors	
Press Type	Cold Press High Frequency Hot Press Clamp Carrier Continuous Press	
Glue line temperature	12°C - 70°C / 54°F - 158°F	
Press Time, 20°C / 68°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	5 min	
Press Time, 30°C / 86°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	---	
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: 5 min	Closed: 7 min
Assembly Time, 30°C / 86°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	Open: 3 min	Closed: 4 min
Glue Spread	Solid wood lamination: 150 - 250 g/m ² , 15 - 25 g/ft ² Block gluing: 60 - 200 g/m ² , 6 - 20 g/ft ² . Veneering: 90 - 150 g/m ² , 9 - 15 g/ft ² Flooring: 90 - 175 g/m ² , 9 - 17 g/ft ² Board on frame: 120 - 300 g/m ² , 12 - 18 g/ft ² While gluing hard and oily wood species the material should be newly planed and the adhesive should be spread on both surfaces to be glued.	
Moisture content of wood	5 - 14%, preferable 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.	

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Gluing of impregnated wood	Can in most cases be used but must be evaluated in each case.
Post curing	The standard can be fulfilled after 7 days conditioning Can be processed further after 2 - 6 hours, but best result is achieved if samples are left 24 hours.

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.
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* municipal sewage with biological treatment

For more info, see General Information.

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Health and Safety	For more information, see respective SDS.
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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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