

AQUAPEKS WA 8300 WA 8300

Product Information:

AQUAPEKS WA 8300 is a D3 /D4 Norm PVA dispersion for wood assembly adhesive with cold and hot press.

Product Properties

- Medium viscosity
- Fast setting
- Long open time
- Gap filling
- Gives transparent, tough-elastic glue joint.
- High water resistance one component
 - = Durability class D3 as per EN 204
- plus cross-linker (5%)
 - = Durability class D4 as per EN 204
- High heat resistance, tested according to EN 14257 (Watt 91)

Application Areas

- Joints where increased water resistance is required
- Gluing solid wood
- Gluing of blockboard cores and composed solid wood panels
- Doors and stairs
- Window scantlings, composite window elements
- Fleece-backing and veneering
- Suitable for solid wood bonding in

Technical Data

Minimum film formation temperature ~+5 °C MFFT
DIN 53787

Viscosity
Brookfield 22°C 15.000-18.000 mPa.s
ISO 2555

pH value (20 °C) ISO 976 3 to 4

Application

Application Temperature : 10 to 35 °C.

The product is applied to the substrate by spatula or doctor blade, but can also be applied by spraying or rolls. When bonding substrates without sufficient humidity or which are not moisture permeable, the required amount of moisture has to be provided by other methods. A proven procedure is the combined spraying of the adhesive simultaneously with water in a fine mist. In the case of separate adhesive and water mist application, the water must not be sprayed onto the bare metal but on the other substrate or ideally on the adhesive. Bonding surfaces should be brought together immediately after adhesive application, assuring sufficient contact pressure while curing, preferably in a press. Since The product cures by reaction with humidity, open containers must always be properly sealed and protected against moisture immediately after taking out the quantity needed. For the same reason we recommend to use up opened containers as soon as possible.

Instructions for Use

Open Time

Open time (beech/beech)	
Quantity applied 150 g/m ²	-10 minutes
Quantity applied 200 g/m ²	-20 minutes

Pressing Time

Surface bonding (Chipboard/HPL)	
Quantity applied 100 g/m ²	≥10 minutes
Quantity applied 200 g/m ²	≥20 minutes
Joint bonding (beech/ beech)	
Quantity applied 150 g/m ²	≥25 minutes
Quantity applied 200 g/m ²	≥35 minutes

The data shown is based on 8-12 % wood moisture, 20 °C room and material temperature, 65% relative air humidity and 0.5 N/mm² pressure. The actual open and setting times will depend heavily on the working conditions such as temperature, humidity and absorption of the wood, surface characteristics, stresses in the material and application thickness of the glue, etc. The glue is supplied ready for use. If required, it can be thinned with water up to 3 %. The working temperature of the workpiece and glue should be at least +10°C. Ensure that the parts to be bonded are close fitting and free from dust and grease. Fit tolerances increase the setting time and reduce the bonding strength. All parts which come into contact with the glue must be made either of stainless steel (V2A/V4A) or plastic. Due to the acidic nature of a D3 and D4 dispersion adhesive, some discoloration can occur as some wood types are sensitive to acid (e. g. pine). Usually, application of the glue to one side only is sufficient. Applying glue to both sides, however, is recommended when gluing difficult-to-bond woods and hardwood, in order to improve bonding strength; in this case the open time is increased.

Storage

When properly stored in a cool, dry location, with the container tightly closed when not in use, this product will have a shelf life of at least 9 months. Recommended Storage: 15°C to 25°C. Storage below 10°C or greater than 50°C can adversely affect product properties. The product is frost-sensitive.

Cleaning

Fresh, uncured material (cleaning application equipment, substrate contamination etc.) can be removed with the PUR-CLEANER; cured adhesive can only be removed mechanically.

Packaging

20 kg block in aluminum laminated flexible packaging, in cardboard or metal drums.
200 kg in aluminum laminated flexible packaging in metal drums.

Disclaimer:

The statements listed on this publication are according to our best knowledge. The statements do not exonerate the user from their own responsibility to determine that our products are suitable for their processes. They are intended to inform and advise and are subject to influence from the technical process.
This edition of December 7, 2023 replaces all previous editions. With the present edition all older editions are null and void.

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