

## TECHNICAL DATASHEET

# PENOSIL Premium WoodFix PVA D3 647

Single-component PVA-type moisture proof wood adhesive used indoor and outdoor. Humidity resistance is D3 according to the standard DIN EN 204/205.

### Field of Applications

Connecting wooden parts in places where moisture proofness of the adhesive connection is required: kitchen-, bathroom-, and outdoor furniture; window- and doorframes, enrichments. In addition to wood, glues well paper, cardboard and corrugated fibreboards, hard-back books; gluing of porcelain, leather, and fabric items, cover plates or linoleum with insulated base. Suitable for indoor instalment of laminate and sheet-parquet.

### Application conditions

Properties	Unit	Value
Humidity content of the adherent wood	%	8–12
Working and material temperature	°C	15–25
Equipment		roller, brush, gluer comb
Material consumption	g/m <sup>2</sup>	100–200
Working time	minute	6–10
Pressure	N/mm <sup>2</sup>	0,1–0,5
Pressurization period depending on material	minute	20–45

### Application instructions

Stir the glue thoroughly before use. Apply a thin layer of glue to one of the bonded details and press it against the non-glued surface. In 10 minutes at the latest, put the glued details under press for 10–30 minutes. In case of hardwood and deciduous wood (oak, birch, etc.) it is highly recommended to apply glue to both bonded details and hold them under pressure for longer (up to 50 minutes).

### Cleaning

Uncured adhesive can be removed with water or use PENOSIL Premium Cleaning Wipes. Cured adhesive can be removed mechanically.

### Technical data

Properties	Unit	Value
Non-volatiles content	%	47–51
Viscosity	mPa	7000–9000
pH		2,5–3,5
<b>Properties of cured adhesive</b>		
Shear strength (DIN EN 204/205 D3/1)	N/mm <sup>2</sup>	12
Shear strength (DIN EN 204/205 D3/3)	N/mm <sup>2</sup>	
Temperature resistance	°C	-40 up to +80

The parameters indicated have been measured at +23 °C and 50% relative air humidity.

## Colour

White, transparent after curing.

## Package

500 ml plastic bottle, 8 pcs in box.

## Storage conditions

Guaranteed storage time 12 months starting from the date of manufacture if stored in a closed original package in a dry place between +5 °C and +30 °C. Avoid freezing.

## Safety regulations

Avoid contact with eyes. Keep out of the reach of children.  
Detailed safety information is available on safety data sheet (SDS).

Note: The instructions in the present documentation are based on tests carried out by the manufacturer and are presented in good faith. Due to variations in materials and substrates as well as the various application possibilities that are beyond our control, the manufacturer is not liable for the results achieved. In any case, it is recommended to test the product suitability at the place of application.