

Technical Data Sheet

Everbond PVA Xlink 3

Water Resistant Crosslinking Pva Adhesive**Conforms to AS 2754.2 1991 and EN204**

Adheseal

*The Adhesive and Sealant Specialists***DESCRIPTION:**

Everbond PVA Xlink 3 is a water-borne synthetic resin, single component self crosslinking adhesive designed for the woodworking industry for use in cabinetry, Shopfitting and Joinery industries.

It is suitable for dowelling, laminating, etc . It is suitable for all types of timber and features quick bonding properties, high strength, non-staining of timber, no mixing, long shelf life and the option of curing under ambient or hot press conditions.

Minimum pressing time :

Surface gluing of decorative papers from 10 sec.

High frequency gluing with longitudinal heating from 20 sec.

Surface gluing of high-pressure laminates in short-cycle presses (+70°C) from 60 sec.

Assembly bonding 30 mins.

Board joint and blocks bonding 45 mins.

CURING:

Curing is by water dissipation and crosslinking under ambient conditions to a firm very water resistant bond.

Cure will be optimised when the adhesive interphase is at moisture equilibrium, which in most situations takes approximately seven days to achieve and is directly dependant on the factors such as substrate and adhesive mass, timber density , moisture content and prevailing ambient conditions.

Cure can be accelerated by hot pressing and water resistance further increased by thermocuring after mixing catalyst number 1 at rate of 1% w/w.

Thermo curing:

Recommended thermocuring cycle is as follows;

30 seconds at 80°C.

30 seconds at 130°C

(1-2mm timber veneer to solid timber or particle board, timber moisture 8-12%, adhesive spread rate 150 - 200 gsm, pressure 4-5 kp/cm²).

Ensure the adhesive is homogenous before use. After use brushes, rollers, glue baths etc should be washed out with water before the adhesive dries out.

STORAGE:

Store indoors under ambient conditions. Keep containers closed when not in use.

PRECAUTIONS:

Refer to MSDS before handling product.

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Physical Properties:

Type of product	Synthetic Resin
Curing system	Water Dissipation
Density (specific gravity)	1.05—1.15
Consistency	White liquid
Viscosity (#5/10rpm/20°c)	9300-13500 cP
Minimum Application temperature	8°c
Storage: Cool Dry between	10°c—30°c
Movement Capability	1
Glue Spread: Surface Bonding : Assembly Bonding	80—140 g/m2 160—180 g/m2
Minimum Press Time	See above
Shelf life	6 Months in original packaging
Clean up	Water
Solids	48/50%
Test certificates to AS:	As2754.2 1991 and EN204

Safety

This product is not classified as hazardous according to Work safe Australia however skin irritation and sensitisation may occur in sensitive individuals. Please consult M.S.D.S. for this product for further information.

Guarantee / Warranty

We warrant our products to be free of defects and manufactured to rigid quality control specification. As it is impossible to control the use and application of the products, the company's liability is limited to replacing such quantities of product as are proven to be defective. The company disclaims any claims for repainting or other labour resulting from the use of the product. No responsibility is assumed for consequential damages arising from the use of the product. All other warranties including (merchantability or fitness for a particular purpose) are excluded. No representative of the company is authorised to grant any warranty or waive this limitation of liability. All claims concerning product defects must be made within twelve months of shipment. Absence of such claim in writing during this period will constitute a waiver of all such claims with respect to such product.

Adequate Tests

The information contained in this bulletin we believe is correct to the best of our knowledge and tests. The recommendation and suggestion contained herein are made without guarantee or representation as to the results. We recommend that adequate tests be made in your laboratory or plant to determine if this product meets all your requirements.