

TECHNICAL DATA SHEET

PENOSIL WoodFix PVA D3 647

Single-component PVA-type moisture proof wood adhesive used indoor and outdoor.

- Indoor and outdoor.
- Moisture proof.
- Moisture resistance class D3.
- Quick and strong connection.
- After drying semitransparent and solid.
- Indispensable in furniture industry.

Fields of application

- Connecting wooden parts in places where moisture proofness of the adhesive connection is required.
- Kitchen-, bathroom-, and outdoor furniture; window- and doorframes, enrichments.
- 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.

Adhering

Adheres well to wood, paper, cardboard and corrugated fibreboards, hard-back books, porcelain, leather, and fabric items, cover plates, linoleum with insulated base.

Application instructions

Application conditions

Application temperature and material between +15 °C and +25 °C. Humidity content of the adherent wood 8-12%. Pressurization period depending on material 20-45 min. Pressure 0,1-0,5 N/mm².

During the curing process of the adhesive, humidity is released. Therefore, rooms should be sufficiently ventilated to reduce the humidity.

Surface preparation

The surfaces must be dry, clean from dust, loose particles and oil. Non-porous surfaces should be cleaned with solvent and a clean, non-fluffy cotton cloth. Solvent excess should be removed before evaporating with a clean cloth.

Application method

Stir the glue thoroughly before use. Apply a thin layer of glue with roller, brush or with notch trowel 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 hard wood 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

Clean the uncured adhesive with water or use PENOSIL Cleaning Wipes. Cured adhesive should be removed mechanically.

Technical data

Properties	Value	Unit
Viscosity	5000–15000	
Consumption	100-200	g/m ²
pH	2,5-3,5	
Basis	Polyvinyl acetate	
Consistency	Liquid	
Open time	6...10	Min
Application temperature	+15...+25	°C
Service temperature	-40...+80	°C
Shelf life	12	
Shear strenght (DIN EN 204/205)	12	N/mm ²

The values specified were obtained at +23 °C and 50% relative humidity, unless otherwise specified. These values may vary depending on environmental factors such as temperature, moisture and type of substrates.

Technical classification and certificates

- DIN EN 204/205 D3- wood adhesive

Colour

White, transparent after curing.

Package

500 ml plastic bottle, 6 pcs in a box.

1 l ml plastic bottle, 12 pcs in a box.

Storage conditions and shelf life

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.

Limitations

- Not suitable for surfaces in permanent contact with water.
- There is no adhesion to PE, PP, PTFE (Teflon®).
- Elements will have a rigid connection, which is why the adhesion is not suitable for moving connections.
- Due to the wide variety of possible substrates, we recommend a preliminary compatibility test.

Safety regulations

Ensure sufficient ventilation during application and wear necessary personal protective equipment. More specific safety information is available on the 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. Manufacturer reserves the right to modify products without prior notice.
This TDS replaces and supersedes all previous data sheets on the same product.