

PROTODUR 303.0

Self-hardening powder urea-formaldehyde glue with medium reactivity, for hot bonding or by high frequency. Low formaldehyde content that fulfils the requirements of the E1 class.

CHARACTERISTICS *

Appearance	powder
Colour	white
Base	Product of condensation of urea and formaldehyde
Mixing ratio	2 parts of glue to 1 part of water
Working temperature	> +5°C
Pot life when mixed with water, at 45°C	95 ± 25 min
Setting time at 90 – 100 °C	50 ± 10 sec
Adhesive quantity	100 g/m ² to 180 g/m ²
Materials moisture	8 – 12%
Temperature of the press	suggested ≥ 80°C
pressure	2 to 6 kg/cm ² depending on the application
Applicator	Roller coaters
cleaning	Hot water
Storage	in dry and cool room, in the original sealed packaging
Shelf life	6 months from the date of production, at 20°C
Packaging	Bags of 25 kg

**no sales specifications*

RECOMMENDATIONS

Dissolve PROTODUR 303.0 in the ratio of 10 kg of glue and 5 kg of water. The pot life of the adhesive mixture is approximately 3 hours at 20°C.

Protodur 303.0 is suitable for bonding different types of wood because of its formulation and its high yield.

When bonding difficult-to-bond kinds of wood, the water based polyvinylacetate glue PROTOVIL VP 420 can be added to the adhesive mixture up to 15% by weight.

The gel time for an adhesive mixture made by 100 parts of Protodur 303.0 and 50 parts of water are depending on the temperature. Practical figures are:

Temperature (°C)	20	30	90	100	110
Gel time	11 h	5 h	2.5 min	60 secs	40 secs

Protodur 303.0 is a product from the condensation of urea and formaldehyde and therefore can cause allergy by skin contact. An adequate ventilation of the workplace must be provided to avoid the mucosal irritation than can be caused by the formaldehyde.

Refers to the Material Safety Data Sheet for further information.

For all matters not covered in this Technical Sheet, refer to our General Sales Conditions and to the advice of our Technical Sales Dept. .

COLLANTI CONCORDE acts under the ISO 9001 system.

Materials and application conditions affect the final performances of our products.

Preliminary trials are therefore recommended.

Issuing date: January 2019.

Material Safety Data Sheet available.

All information and recommendations in this bulletin are based upon practical experience and they don't exempt our customers to make tests when they receive the goods. We can bring changes to our characteristic details of our products in according with the technical and productive development. All information in this bulletin request some tests, because there are many details which are not verifiable during the working from us, particularly when you use raw materials of other suppliers. Our suggestions don't exempt you to check and in any case to resolve the problem when there is a possible violation of patents of other suppliers.