

# PROTOVIL WR/P

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Polyvinyl acetate water based adhesive with high performances that fulfils the requirements of the D3 class (EN 204). When the hardener CTZ F 200 is added (5% by weight), the D4 class according to EN 204 is fulfilled. Protovil WR/P is suitable for bonding of parquet floors, windows, doors, bathroom furniture, kitchen furniture, kitchen tops and doors and whenever a very high resistance to water and to high temperatures is requested.

## CHARACTERISTICS

### Sales specification:

Viscosity at 20°C (UNI EN 12092) 14.000 ± 2.000 mPa s

### Other technical characteristics \*:

Base	Waterborne polyvinyl acetate copolymers
Colour	White; transparent when filmed
Minimum film forming temperature	> +4°C
Open time (20° C , 55 % r.h.)	Approx. 10 minutes
Processing time after bonding (20° C, 55 % r.h.)	Approx. 30 minutes
Density at 20°C	1.1 ± 0.1 g/cm <sup>3</sup>
Final curing time	24 hours
Adhesive quantity	140 - 180 g/m <sup>2</sup>
Room and material temperatures	≥ 20°C
Pressure	3 - 5 kg/cm <sup>2</sup>
Applicator	Roller coaters
Cleaning	Hot water
Storage	in dry and cool room, in the original sealed packaging
Shelf life	12 months from the date of production
Packaging	Buckets, tanks, bulk

\*no sales specifications

## RECOMMENDATIONS

Practical suggestions of pressing times with a pressure of 4 kg/cm<sup>2</sup> of a wood with 10% of moisture are:

<b>bonding</b>	<b>Temperature (°C)</b>	<b>Pressing times</b>
Softwood on hardwood	20	15 – 30 min
Softwood on hardwood	70	5 – 7 min
High frequency	/	40 – 60 sec
Laminate on chipboard	20	10 – 15 min
Laminate on chipboard	70	60 – 70 sec

50% of the final strength is reached after approximately 20 minutes of pressing at 20°C. The final strength and the best performances are reached not before 24 hours.

PROTOVIL WR/P must be evenly applied on a clean surface, free from dust, grease or oil. When bonding hard woods and tropical woods, the glue should be applied on both surfaces.

The quantity of glue depends on the materials and on the surfaces to be bonded. Uneven thicknesses can affect the recommended glue quantity.

The bonding must be carried out within the open time. The open time depends on the glue quantity, the temperature, the type and the quality of the material to be joined.

The parts to be glued must be perfectly matching and smooth. To ensure a correct bonding, parts must be kept under pressure until a certain strength is developed.

The glue does not affect the colour of the wood, nevertheless avoid the contact with steel tools that might led to dark glue lines. Close the containers of the glue after the use. These suggestions must be followed to avoid possible bonding failures.

## RECOMMENDATIONS FOR THE GLUE MIXTURE

The containers where the glue mixture is prepared must be perfectly clean. Mix thoroughly the glue and the hardener until complete homogenisation has been achieved. The pot life of the mixture is 6 to 8 hours. Do not use it over that time.

**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.*