

Technical Data Sheet

Wood & Specialty Adhesives

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Prefere 6415

One component PVAc adhesive of D4 quality

Application

Prefere 6415 is a one-component PVAc dispersion adhesive, which gives glue bonds with high moisture and heat resistance. Prefere 6415 is suited for products for interior use, interior use with frequent long-term exposure to running or condensed water and for exterior use, exposed to weather, but with adequate protection by a surface coating. The adhesive can also be used to bond certain metals to wood.

Prefere 6415 is tested by IFT Rosenheim to be of durability class D4, according to EN 204/205. The adhesive is also shown to give high heat resistance when tested according to EN 14257 (WATT 91).

Prefere 6415 is approved for finger jointing and for lamination of building profiles of pine and spruce, according to BRL 2339.

Prefere 6415 can be used under both cold and warm conditions and is suitable for use under radio frequency heating conditions.

Technical data

Appearance	White, viscous liquid
Solids content (1 hour at 120°C)	49,5 – 51,5 %
Viscosity at 23°C (Brookfield RVT, sp 4)	7450 ± 1050 mPa.s
pH	2,5 – 3,2

Pumps

Due to the low pH-value of the adhesive it is recommend to use acid-resistant parts in pumps and other components the adhesive may come in contact with.

Packaging

Prefere 6415 is supplied in road tankers, IBC containers; 120 kg plastic drums; 25 kg buckets.

Storage

The shelf life of Prefere 6415 is dependent on the storage temperature; the higher the storage temperature, the shorter the shelf life. Optimal storage temperature is 15-20°C.

The table below shows the shelf lives from the date of production (stated on the containers) at different storage temperatures:

Storage temperature	Shelf life
15°C	approx. 8 months
20°C	approx. 6 months
25°C	approx. 3 months
30°C	approx. 2 months

Prefere 6415 must be protected from frost. It should not be subjected to direct sunlight.

The adhesive must not be stored in unlacquered tin containers, due to the risk of rust formation and discoloration.

Glue Spread

Recommended glue spread is 120-250 g/m², depending on the surface smoothness of the adherents and the required open assembly time.

Assembly time

The assembly time depends on the absorbency and moisture content of the materials being bonded as well as on the glue spread, relative humidity, air temperature and ventilation. Porous materials, low glue spread, dry air and extensive airflow will enhance dry out and reduce the assembly time.

With a glue spread of approximately 150 g/m², room temperature of 20°C and 65% relative humidity, the maximum closed assembly time is approximately 20 min. The pressure must be applied while the glue is still wet.

Pressure

The pressure is first of all determined by the density, surface evenness and thickness tolerance of the adherends. Glue being squeezed out of the glue line when the pressure is applied, is an indication of sufficient pressure.

The normal pressure for gluing of soft wood is 0,5 – 1,0 N/mm² (5 - 10 kp/cm²) whereas the pressure should be in the range of 0,8 - 1,2 N/mm² (8 - 12 kp/cm²) when gluing hard wood.

Pressing time

Normally the pressing time is in the range of 15-35 min at 20-30°C depending on the wood species and absorbency and moisture content of the wood to be bonded. The pressing time gives sufficient bonding of medium density woods to allow further processing. Full strength and optimum moisture resistance is obtained after 1-2 days depending on the storage conditions. Curved constructions, high glue spread rate, high moisture content of the adherents and dense wood (hardwood) call for longer pressing times.

Note that Prefere 6415 is unsuitable for use at temperatures below 10°C. It is equally important to ensure that the wood temperature is above 10°C.

Cleaning

The application equipment should be cleaned with lukewarm water before the glue has dried. Dry glue remainders must be removed mechanically.

Safety precautions

Reference is made to the Safety Data Sheet for Prefere 6415.

When handling the adhesive it is recommended that certain precautions normally taken when handling chemicals is observed. It is recommended to wear protective gloves, likewise eye protection where there is a risk of splashes. Hands and forearms should be thoroughly washed with soap and warm water at the end of the working day.

Adequate ventilation of the workshops should be maintained.

The suggestions given in these notes are based on data gained from experience and experimentation. However, since operating conditions in the user's plant are beyond our control, we cannot assume responsibility for any risks or liabilities, which may result from the use of our products.