

FIX D3

MOISTURE RESISTANT WOOD ADHESIVE

Dispersion adhesive for gluing of all kinds of wood where water resistant joint D3 according to EN 204 and highly temperature resistant joint according to EN 14275 WATT 91: shear strength at 80 °C > 7 N/mm² are required.

PROPERTIES

- For indoor and outdoor surfaces.
- D3 water resistant joint.
- High temperature resistance.
- Solvent free.
- Environmentally friendly.

TESTS AND CERTIFICATES

Classification of non-structural adhesives for wood and wood products: EN 204 D3 (wood-wood)

AREA OF USE

It is used in all cases where the following is required:

- waterproof adhesive according to standard EN 204 D3 - production of glued elements for use in rooms where the relative air humidity is constantly high and glued elements that are often exposed to condensation or short-term water spillage:
- resistance of the adhesive joint to humid climate: doors, windows, furniture for humid rooms, kitchen counters, stairs
- high joint strength and short compression time
- increased resistance to temperature or organic solvents.

The adhesive is suitable for:

- width and thickness gluing of all types of wood
- construction gluing
- surface gluing [veneer, laminate].

TECHNICAL DATA

Base

water dispersion of polyvinyl acetate polymer
white, when the adhesive hardens, the joint is

Colour

transparent

Binding speed

high

Viscosity at 23 °C [Brookfield RVT, vr.4/20 rpm°]

7000- 10000 mPa s

Ph value [ISO 976]

approx. 3.0

Chalk point

approx. 4 °C

Open time at 20 °C, 65% relative air humidity, on beech wood with 10% humidity:

- when applying the adhesive 100 g/m²: approx. 2 minutes
- when applying the adhesive 200 g /m²: approx. 7 minutes

INSTRUCTIONS FOR USE

- After a long storage time, it is recommended to mix the adhesive before use.
- Surfaces must be well prepared - flat, smooth, dry, free of dust, grease or other dirt.
- Apply the adhesive manually or by machine with conventional devices and applicators.
- The application should be one-sided, in a thin layer, even over the entire surface.



- For glued structures and joints where high joint strength is required, double-sided application of adhesive is recommended.
- The optimal working conditions are:
 Temperature of room, adhesives and glued materials: 18-20 °C
 Relative humidity in the room: 60-70 %
 Humidity of glued elements: 8-10 %

Application of the adhesive:

- For width and construction gluing 120 - 180 g/m²
 - When veneering 100 - 150 g/m²
- Compression pressure:
- For joints and surface gluing of laminate min 0.5 N/mm²
 - When veneering min 0.2 N/mm²

- Compression time: depends on the ambient temperature, the adhesive and the glued elements, the humidity and the type of wood, the compression pressure and the amount of adhesive applied. Taking into account the stated optimal working conditions, the recommended compression time is:

| | | minimum |
|----------------------------------|----------|---------------|
| width gluing (soft/hard wood) | at 20 °C | 15/30 minutes |
| | at 50 °C | 3/5 minutes |
| veneeding (thickness 0.6-0.8 mm) | at 20 °C | 10-15 minutes |
| | at 50 °C | 6-8 minutes |
| | at 70 °C | 4-6 minutes |
| surface gluing (laminate) | at 20 °C | 15-20 minutes |
| | at 50 °C | 6-8 minutes |
| | at 70 °C | 4-6 minutes |

- When gluing wood with higher humidity, at higher adhesive applications or at lower gluing temperatures than recommended, a corresponding extension of the pressing time is required. Extending the compression time is also recommended for heavily loaded joints.
- Do not glue at temperatures below +15 °C. Further processing is possible after 12 hours.
- Cleaning: wash machines and tools with water before the glue dries.

PACKAGING

- 500 ml bottle

STORAGE

12 months in a dry place at a temperature between 5 °C and 25 °C, in the original sealed packaging. PROTECT FROM FROST! Storage at temperatures above 25 °C significantly shortens the shelf life of the adhesive. After a long storage time, it is recommended to mix the adhesive before use.

HEALTH, SAFETY, HANDLING AND DISPOSAL INFORMATION

Additional safety information, safe handling instructions, information on personal protective equipment, and disposal information can be found in the safety data sheet. Safety data sheet available on request. You can also obtain a copy from your TKK sales representative.

WARNING

The information given is based on our tests and practical experience. However, due to specific conditions and working methods we recommend preliminary tests for each case of use.



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