



**ADESIVI RESINE
VERNICI**

NGI P QF WT A/240/IM

NGI P QF WT A/240/IM is a polyvinyl acetate (PVA) adhesive one component ready to use with high water resistant, suggested for press application cold and hot with very short time. Used primarily for wood veneer and other wood materials. Compliance with European Standards DIN EN 204-D3

CHARACTERISTICS

Physical Aspect	Fluid / creamy
Colour	White
Odour	Typical of PVA
Solid content	50% ± 1
Brookfield viscosity at 20 ° C G.6 rpm mPas	15000 ± 1000
M.F.T. (min. film forming temp.)	5-6 ° C
PH at 20 ° C	3

RECOMMENDED CONDITIONS OF USE

The open time and drying are significantly different from the work conditions

Good results are obtained using the following conditions:

Room temperature, adhesive and paste parts:	18-20 ° C
Humidity of wood (hard or soft)	12.8%
Relative Humidity	60-70%
Coating on both sides only woods (no veneers.)	90-110 gsm
Pressure on bonding not in tension	0.1 to 0.5 N / mm ²

We recommend that the adhesive should be spread evenly over the surface, considering an amount too low can result not sufficient adhesive strength, while an excessive causes the surface sweating through the veneer.

Open time:

- Using chipboard coating of 100 g / m ² adhesive	2-3 minutes
- Using chipboard coating of 150 g / m ² adhesive	6-9 minutes

Pressing time:

using veneer with thickness from 0.6 to 0.8 mm:	
- 20 ° C with coating of 150 gsm adhesive	5-20 minutes
- 50 ° C with coating of 150 gsm adhesive	6-8 minutes
- 70 ° C with coating of 150 gsm adhesive	4-7 minutes with 100 g / m ² 3 minutes approx
- 90 ° C with coating of 150 gsm adhesive	about 1 minute

USE SUGGESTIONS:

LEGNODUR A/240/IM must be spread evenly over the surface to be bonded with a spatula, roller coating or other suitable tool.

The preparation of wood and its bonding have made possible the same day to avoid a variation of tolerances in the dimensions of parts with consequent lengthening of the time pressing and weakening of the adhesive joint.

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LEGNODUR A/240/IM with high resin content wood and tannin, can cause stains pasting colored species at high temperature. impurities of iron coming from the tools can still generate react with the tannins in the wood and in particular with oak and cherry and beech, the dark spots. It is recommended that a preliminary test.

The parts to be bonded must be matched before the end of open time and pressed until a sufficient initial adhesive strength.

During the laminate bonding is necessary to determine in advance the nature of the back which can sometimes present traces of release agent that may affect the ability of the adhesive wetting and consequently the open time.

In the most critical cases you can highlight glaring defects bonding; prior sanding with 100 sandpaper and subsequent removal of the powder can improve adhesion.

The adhesion must be possible at temperatures below 15 ° C. Below this temperature, the adhesive strength can progressively decreasing to determine the complete detachment of the parties when they reach the minimum film forming temperature.

Before other work after pressing, it is better to wait for the object to be cooled.

Avoid adding flours and various other ingredients that modify the performance of adhesive VINACOLL A/240/IM.

Tanks, gear, whatever line of work or in contact with the adhesive is indispensable to stainless steel, plastic, hard PVC, polyethylene, polyester resin. With other materials can happen corrosion caused by contact with the acidic nature of the adhesive.

Is suggested to clean the equipment came in contact with the VINACOLL A/240/IM with warm water before the adhesive dries, the film as being water resistant adhesive, is difficult to remove. If used solvents such as acetone or methyl acetate to facilitate their removal.

The maximum water resistance is reached after four days from bonding.

After long periods of storage it is recommended to stir the glue.

STORAGE

The product must be stored at a temperature not below 5 ° C, away from flames and sparks, in well ventilated areas. Inside closed and sealed packagings the product is stable for at least 6-8 months from production date.

PACKAGING

Can	1 kg
Bucket	5 – 10 – 20 Kg
Tank	25 Kg
Drum	120 – 200 Kg
IBC Cont.	1.000 Kg

RECOLL INTERNATIONAL srl guarantees that the information in the present sheet are given to the best of its experience and technical-scientific knowledge; however, it is not liable for results obtained as application conditions are out of its control. It is recommended to always verify the suitability of the product for the specific case. The present sheet annuls and substitutes any previous sheet.

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