

PROTOVIL D4

One component polyvinylacetate water based adhesive that fulfils the requirements of the D4 class (EN 204) and the WATT 91 (EN 14257) ; certifications are available upon request. Protovil D4 is suitable for bonding of parquet floors, windows, doors, tropical woods, 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) 8.000 ± 2.000 mPa s

Other technical characteristics *:

Base	Waterborne polyvinylacetate 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 ³
Final curing time	24 hours
Adhesive quantity	160 - 250 g/m ²
Room and material temperatures	≥ 20°C
Pressure	3 - 5 kg/cm ²
Applicator	Roller coaters
Cleaning	Hot water
Shelf life	4 months from the date of production, at 20°C. Keep at temperature higher than 5°C
Packaging	Buckets, tanks

**no sales specifications*

RECOMMENDATIONS

Practical suggestions of pressing times with a pressure of 4 kg/cm² of a wood with 10% of moisture are:

bonding	Temperature (°C)	Pressing times
Soft wood on hardwood	20	15 – 30 min
Soft wood on hardwood	70	5 – 7 min
High frequency	/	40 – 60 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. Water resistance (D4) is reached after 7 days.

PROTOVIL D4 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.

COLLANTI CONCORDE acts under the ISO 9001 system.

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

Preliminary trials are therefore recommended.

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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.