

Product Information

Adhesive 0937

- Medium fast setting formaldehyde free D3 PVAc adhesive

Wood adhesive 0937 is medium fast setting and suitable for cold presses, hot presses and radio frequency presses. 0937 fulfils the requirements for EN 204, class D3 and EN14257, WATT 91. It is formaldehyde free and compliant with IKEA IOS-MAT-0003 and IOS-MAT-0069.

Product Specification

		0937	
Product	PVAc adhesive		
Delivery Form	Liquid		
Colour	White		
Viscosity (at time of production)	5000 - 15000 mPas (Brookfield RVT, sp.5, 10 rpm, 25°C)		
Density	Appr. 1100 kg/m ³		
Dry Content	48.0 – 52.0%		
pH (at time of production)	3.0 – 5.0 (25°C / 77°F)		
Storage Life (months from time of production)	20°C/68°F	30°C/86°F	
	6	3	
Storage Condition	<p>Recommended storage temperature; 10°C - 25°C / 50°F - 77°F. Only short term exposure to temp below 5°C / 41°F or above 35°C / 95°F is allowed.</p> <p>Frozen and thawed product cannot be used due to irreversible reactions in the product.</p> <p>The product can form a skin on the surface if the container is not properly closed. The products shall always be stored in closed packaging.</p> <p>When 0937 is stored for a longer period of time the viscosity of the dispersion may increase. Stirring the emulsion will bring back the viscosity to original level.</p>		
Formaldehyde Info	Formaldehyde free		
Glue Line Properties	<p>Light colored glue lines.</p> <p>High degree of moisture and water resistance.</p> <p>Gives elastic glue lines.</p> <p>IOS-MAT-0134 – class 3</p>		
Approvals	Approvals ongoing.		

Contact Information

Stockholm, Sweden +46 8 743 40 00
High Point, USA +1 336 841 5111
Amata, Vietnam +84 8 844 5743
Medellin, Colombia +57 4 3618888
www.akzonobel.com/adhesives

Version: 01 (2021-05-07)

Reason for changes: New

Discolouration	The product does not discolour the wood. However, iron which might come from the glue spreader can together with the tannic acids in some wood species, especially oak, give a discolouration.
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Gluing Operation Information

Applications	Flooring Solid Wood Lamination Edge glued panels Veneering Doors
Press Type	Cold Press High Frequency Hot Press Clamp Carrier Continuous Press
Glue line temperature	12°C - 70°C / 54°F - 158°F
Press Time, 20°C / 68°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	7 min
Press Time, 30°C / 86°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	---
Pressure	0,1 - 1,0 MPa
Assembly Time, 20°C / 68°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	8-10 min
Assembly Time, 30°C / 86°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	4-5 min
Glue Spread	Solid wood lamination: 150 - 250 g/m ² , 15 - 25 g/ft ² Block gluing: 60 - 200 g/m ² , 6 - 20 g/ft ² . Veneering: 90 - 150 g/m ² , 9 - 15 g/ft ² Flooring: 90 - 175 g/m ² , 9 - 17 g/ft ² Board on frame: 120 - 300 g/m ² , 12 - 18 g/ft ² While gluing hard and oily wood species the material should be newly planed and the adhesive should be spread on both surfaces to be glued.
Moisture content of wood	5 - 14%, preferable 7 - 10%
Preparation of wood	For best result the wood must be smoothly planed. For optimum bond strength the bonding operation shall take place within 24 hours after preparation.
Temperature of wood	In order to meet the given press times the temperature of the wood must not be below 20°C / 68°F.

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Gluing of impregnated wood	Can in most cases be used but must be evaluated in each case.
Post curing	The standard can be fulfilled after 7 days conditioning Can be processed further after 2 - 6 hours, but best result is achieved if samples are left 24 hours.

Handling and HSE info

Handling	Always use gloves and goggles when handling the product.
Cleaning	Use lukewarm water for glue on skin and machinery. Cleaning should start before the system dries.
Waste handling - of the products	Normally not to be considered as hazardous waste. Leave residues to dry before sending it off for disposal. For 2 component systems the hardener may be considered as hazardous waste, check the SDS (section 13).

NOTE! There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.

Waste water treatment - of the waste water	<u>Chemical precipitation → drain*</u> Please contact Environmental Advisor at the Environmental Department for further information regarding chemical precipitation.
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* municipal sewage with biological treatment

For more info, see General Information.

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Health and Safety	For more information, see respective SDS.
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Legal clause

The information is based on laboratory tests and practical experience. It is introductory and intended to help the user find the most suitable method of working. Since the user's production conditions are beyond our control, we cannot be held responsible for the results of the work which is affected by local circumstances. In each particular case testing and continuous control are recommended.

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