

## Product Information

### Wood adhesive E363

- Fast setting formaldehyde free D3 PVAc adhesive

Adhesive E363 is fast setting and suitable for radio frequency presses. E363 fulfils the requirements for EN 204, class D3 and EN14257, WATT 91. It is formaldehyde free and compliant with IKEA IOS-MAT-0003.

### Product Specification

<b>E363</b>		
<b>Product</b>	PVAc adhesive	
<b>Delivery Form</b>	Liquid	
<b>Colour</b>	White	
<b>Viscosity</b> (at time of production)	12000 - 18000 mPas (Brookfield RVT, sp.5, 20 rpm, 23°C / 73.5°F)	
<b>Density</b>	Appr. 1100 kg/m <sup>3</sup>	
<b>Dry Content</b>	55.0 – 59.0%	
<b>pH</b> (at time of production)	2.0 – 4.0 (25°C / 77°F)	
<b>Storage Life</b> (months from time of production)	<b>20°C/68°F</b>	<b>30°C/86°F</b>
	6	3
<b>Storage Condition</b>	<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 30°C / 86°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 E363 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>	
<b>Formaldehyde Info</b>	Formaldehyde free	
<b>Glue Line Properties</b>	<p>Light colored glue lines.</p> <p>High degree of moisture and water resistance.</p> <p>Gives elastic glue lines.</p>	
<b>Approvals</b>	Approvals ongoing.	
<b>Discolouration</b>	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.	

### Contact Information

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[www.akzonobel.com/adhesives](http://www.akzonobel.com/adhesives)

**Version:** 02 (2020-10-20)

**Reason for changes:** Storage temperature range changed

## Gluing Operation Information

<b>Applications</b>	Flooring Solid Wood Lamination Edge glued panels Veneering Doors	
<b>Press Type</b>	Cold Press High Frequency Hot Press Clamp Carrier Continuous Press	
<b>Glue line temperature</b>	12°C - 70°C / 54°F - 158°F	
<b>Press Time, 20°C / 68°F</b> (pine-pine, 65% RH, 150 g/m <sup>2</sup> , 15 g/ft <sup>2</sup> )	5 min	
<b>Press Time, 30°C / 86°F</b> (pine-pine, 65% RH, 150 g/m <sup>2</sup> , 15 g/ft <sup>2</sup> )	---	
<b>Pressure</b>	0,1 - 1,0 MPa	
<b>Assembly Time, 20°C / 68°F</b> (pine-pine, 65% RH, 150 g/m <sup>2</sup> , 15 g/ft <sup>2</sup> )	Open: 4 min	Closed: 7 min
<b>Assembly Time, 30°C / 86°F</b> (pine-pine, 65% RH, 150 g/m <sup>2</sup> , 15 g/ft <sup>2</sup> )	Open: 2 min	Closed: 4 min
<b>Glue Spread</b>	Solid wood lamination: 150 - 250 g/m <sup>2</sup> , 15 - 25 g/ft <sup>2</sup> Block gluing: 60 - 200 g/m <sup>2</sup> , 6 - 20 g/ft <sup>2</sup> . Veneering: 90 - 150 g/m <sup>2</sup> , 9 - 15 g/ft <sup>2</sup> Flooring: 90 - 175 g/m <sup>2</sup> , 9 - 17 g/ft <sup>2</sup> Board on frame: 120 - 300 g/m <sup>2</sup> , 12 - 18 g/ft <sup>2</sup> 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.	
<b>Moisture content of wood</b>	5 - 14%, preferable 7 - 10%	
<b>Preparation of wood</b>	For best result the wood must be smoothly planed. For optimum bond strength the bonding operation shall take place within 24 hours after preparation.	
<b>Temperature of wood</b>	In order to meet the given press times the temperature of the wood must not be below 20°C / 68°F.	
<b>Gluing of impregnated wood</b>	Can in most cases be used but must be evaluated in each case.	
<b>Post curing</b>	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.	

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## Handling and HSE info

<b>Handling</b>	Always use gloves and goggles when handling the product.
<b>Cleaning</b>	Use lukewarm water for glue on skin and machinery. Cleaning should start before the system dries.
<b>Waste handling - of the products</b>	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).  <b>NOTE!</b> There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.
<b>Waste water treatment - of the waste water</b>	<u>Chemical precipitation → drain*</u> Please contact Environmental Advisor at the Environmental Department for further information regarding chemical precipitation.  * municipal sewage with biological treatment  <b>For more info, see General Information.</b>  <b>NOTE!</b> There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.
<b>Health and Safety</b>	For more information, see respective SDS.

### 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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