

## Technical Data Sheet

### Wood & Specialty Adhesives

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## Prefere 6202

PVAc adhesive of D2 quality

### Application

Prefere 6202 is a PVAc dispersion adhesive designed for assembly work in the furniture industry. The adhesive can also be used for a variety of other purposes including "Do it your self" applications. Prefere 6202 gives high bond strength and conforms to the requirements for Durability class D2 according to EN 204/205.

Prefere 6202 is not recommended if moisture-resistant glue is required. Nor is it recommended for glue bonds that will be exposed to constant loads or high temperature over extended periods of time.

### Technical data

Appearance	White, viscous liquid
Solids content (1 hour at 120°C)	ca 51%
Viscosity at 23°C (Brookfield RVT, sp 5)	12 000 ± 3000 mPa.s
PH	6,5 – 7,5
Minimum filmforming temperatur	+ 3°C

### Storage

Recommended storage temperature for Prefere 6202 is 10-25°C. In this temperature range the shelf life is approximately one year from the data of production. Higher temperatures will reduce the shelf life of the product. The adhesive should be stored in tightly closed containers and must be protected from frost and direct exposure to sunlight. It should not be stored in unlacquered tin containers, due to the risk of rust formation resulting in discoloration of the glue.

### Packaging

Prefere 6202 is supplied in road tankers, IBC containers, 120 kg drums and 25 kg buckets.

### Glue spread

Recommended glue spread is 150-250 g/m<sup>2</sup>, depending on the surface smoothness of the adherents and the required open assembly time.

### Assembly time

The assembly time depends on the absorbency and moisture content of the materials being bonded as well as on the glue spread, relative humidity, air temperature and ventilation. Porous materials, low glue spread, dry air and extensive air flow will enhance dry out and reduce the assembly time. The open assembly time is under normal conditions ca 6 - 8 min at 20°C.

### Pressure

The pressure is first of all determined by the density, surface evenness and thickness tolerance of the adherends. Glue being squeezed out of the glue line when the pressure is applied, is an indication of sufficient pressure. Normal pressure is 0,2-1,0 N/mm<sup>2</sup> (2-10 kp/cm<sup>2</sup>) depending on the type of bonding operation and the materials to be bonded.

### Pressing time

At 20°C the pressing time is in the range of 4 - 6 min depending on the glue spread and the materials to be glued. *Note that Prefere 6202 is not suitable for use at temperature below 6°C. It is also important to ensure that the wood temperature is above 6°C.*

### Cleaning

The application equipment should be cleaned with lukewarm water before the glue has dried. Dry glue remainders are best removed with a mixture of equal parts of water and acetone, to which a small quantity of a synthetic detergent has been added.

### Safety precautions

Reference is made to the Safety Data Sheet for Prefere 6202.

When handling the adhesive it is recommended that certain precautions normally taken when handling chemicals is observed. It is recommended to wear protective gloves, likewise eye protection where there is a risk of splashes. Hands and forearms should be thoroughly washed with soap and warm water at the end of the working day.

Adequate ventilation of the workshops should be maintained.

*The suggestions given in these notes are based on data gained from experience and experimentation. However, since operating conditions in the user's plant are beyond our control, we cannot assume responsibility for any risks or liabilities, which may result from the use of our products.*