

# Collano FL 330

Universal dispersion adhesive for veneer and solid wood, water-resistant D3

## Characteristics

### Base

PVAc-Dispersion

### Colour

White

### Density

1.1 g/cm<sup>3</sup>

### Solids content

46%

### Viscosity (Brookfield)

6'000 mPa·s

### pH value

4.5

### Chalking point

8 °C

### Form

Liquid

### Flammability

Not flammable

### Storage

9 months in unopened original packaging at 15–25 °C (frost susceptible)

## Application area and materials

For veneering as well as general carpentry work. For high-quality wood bonding in furniture and interior construction, veneer and laminate bonding, joint and construction bonding (body, table, chair, window, etc.), veneering of cement-bonded chipboard and gypsum plasterboard. For cold or hot pressing and high-frequency bonding.

## Performance | Material properties

Information derives from tests carried out by Collano. Further information on request.

### Bond strength

EN 204, stress group D3

Stress group D4 with Collano hardener HR 910

### Temperature resistance

EN 14257 (Watt 91) > 7 N/mm<sup>2</sup> at 80 °C

### Eco label

eco2, suitable for Minergie-ECO

## Packaging

Plastic bottles 300 g and 800 g

Plastic tanks 10 kg for Collano Easy Applico 2000

Plastic pails 12 kg and 25 kg

IBC containers 600 kg and 1'100 kg

## Application data

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The curing behaviour of PVAc dispersions depends on the absorbency and strength of the adherends, as well as the ambient temperature and press temperature. The specified figures are guideline values and are based on results of tests on precision bonds made under standard climatic conditions (20 °C and 65% relative humidity). Deviations are possible depending on the type of use.

### Adhesive application quantity

100–200 g/m<sup>2</sup>

### Pressure

0.1–0.8 N/mm<sup>2</sup>

### Material moisture content

8–12%

### Application temperature

> 10 °C

### Maximum open assembly time

< 10 minutes

### Pot life

12 hours with Collano Hardener HR 910

### Minimum press time

20 °C: > 10 minutes

50 °C: > 5 minutes

80 °C: > 2 minutes

### Conditioning time

2 hours

### Final strength

7 days

## Application

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It is essential that the surfaces are clean and grease-free in order to provide the best adhesion and quality of join. In case of long run times of the application system, the adhesive can be restored to normal consistency by adding 5% water. If required, the adhesive may be coloured using a water-soluble wood stain or Pintasol/Mixol. Wait at least 24 hours before carrying out surface treatments. Apply the adhesive to one of the surfaces, or to both surfaces for hardwoods and exotic woods, and for slotted/tenon joints. When applying from plastic tank, follow the Collano Easy Applico 2000 operating instructions.

### Additional details

In contact with iron, adhesive may cause wood discoloration. Water-resistance of the seal (D4) is increased by adding 5% (by weight) of Collano hardener HR 910. Mix well with hardener. Mixture can be processed for 12 hours.

### Clean-up

With water before adhesive has dried.

## Safety

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Follow the instructions on the Safety Data Sheet.

### Guarantee

We guarantee the consistency and faultless quality of this product, manufactured in accordance with ISO quality standards, which has been developed on the basis of our long standing experience with the recommended applications under the specified conditions. Material, processing, and application conditions may significantly influence product properties. Pre-application tests by the user are therefore essential. For non-specified applications or deviations in application conditions, we recommend that Collano's technical support service be consulted first. Collano's general sales and delivery terms and conditions shall apply.

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