

Sempadur P 8

Veneer adhesive, in powder form and low in formaldehyde, for emission class E1

Characteristics

Base

Urea-formaldehyde resin

Colour

Light beige

Solids content

100%

Viscosity (Brookfield)

2'000–3'000 mPa·s (50% in water)

pH Value

5.0 (50% in water)

Form

Powder

Flammability

Ready-mixed, aqueous adhesive not flammable

Storage

12 months in unopened original packaging at 15–25 °C

Application area and materials

For all the usual veneering tasks. For hot pressing, lamination of paper foils and stabilising papers. When using emission class E1 chipboard, this emission class is retained even after veneering.

Performance and material properties

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

Bond strength

EN 12765, stress group C3

DIN 68 705 part 2 (1981) IF

Fire resistance category

EN 13501, provided the appropriate materials and constructions are used

Resistance

Resistant against weak caustics, acids and solvents

Packaging

Paper sacks 25 kg

Application data

The curing behaviour Sempadur P 8 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.

Mixing ratio

Sempadur P 8 : Water

10 : 9-10 by weight

3 : 2 by volume

Adhesive application quantity

120–200 g/m²

Pressure

0.2–0.8 N/mm²

Material moisture content

6–12%

Application temperature

> 10 °C

Maximum open assembly time

< 15 minutes

Pot life

20 °C < 4 hours

30 °C < 1,5 hours

Minimum press time

80 °C > 6 minutes

90 °C > 4 minutes

100 °C > 3 minutes

120 °C > 2 minutes

Conditioning time

2 hours

Final strength

7 days

Application

It is essential that the surfaces are clean and grease-free in order to provide the best adhesion and quality of join. Minimum press temperature is > 80 °C. For woods such as birch, sycamore, or oily/resinous woods, and for veneering with a moisture content below 6% we recommend that 10% Collano FL 330 be added to the set of mixed adhesives. This provides a better adhesion. Stir the adhesive well again after approx. 15 minutes maturing time.

Additional details

Not suitable for alkaline materials such as cement-bonded chipboard.

Clean-up

With water before adhesive has dried.

Safety

Follow the instructions on the safety data sheet.

The current data sheets are available at:

collano.com/en/downloads

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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