

Technical Information

FOLCO® LIT D3 W91

General Information

Article number	14301-006
Type of product	FOLCO® LIT D3 W91 is an unfilled PVAc-based adhesive with crosslinkable groups.
Field of application	Thermolaminating of decorative finish foils; surface bonding of e. g. HPL/CPL in short cycle presses; carcass and assembly gluing; bonding of joints in boards and block gluing of softwood and chipboard as well as hardwood (testing is required in advance).
Properties	Good water resistance: durability class D3 according to DIN EN 204. Good heat resistance: ≥ 7 N/mm ² according to DIN EN 14257 (WATT 91). In compliance with the requirements to surface flammability as well as smoke density and toxicity (according to IMO FTP Code part 2 and 5)*. FOLCO® LIT D3 W91 achieves a high final strength with short pressing time, especially with additional heat.

Characteristics

Viscosity (on the day of manufacture)	approx. 12.000 mPa·s (Brookfield DVII, 20 °C, Sp. 6, 20 rpm.)
pH-value	approx. 3

Further properties

Min. film forming temperature (MFFT)	approx. + 6 °C
(Dispersion-) density	ca. 1,08 g/cm ³
Open time at 150 g/m ²	max. 8 - 12 min.

Instructions for use

Wood preparation	Work pieces should be properly planed and free of dust and grease. Tolerances cause prolonged setting times and less mechanical strength.
Use	Among others, the temperature, humidity and absorption of the materials, the coating weight and the tension within the material have different influence on the open time, the setting time and the pressing time. Heat accelerates the setting procedure and shortens the open time.

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Instructions for use

For good results we recommend the following working conditions:

Room-, material- and adhesive temperature	18 – 22	°C
Relative air humidity	60 – 70	%
Wood moisture (should correlate with the later wood moisture):		
Interior use approx.	6 – 10	%
Exterior use approx.	11 – 15	%
Coating weight:		
for surface bonding	80 – 150	g/m ²
for thermolaminating	50 – 80	g/m ²
for assembly	100 – 150	g/m ²
Press pressure for tensionless work pieces	0,1 – 1	N/mm ²
Minimum pressing time:		
Surface gluing (HPL / chipboards)		
with 70 °C	ca. 1	min.
with 20 °C	30 – 40	min.
decorative finish foil (short cycle presses)	5 – 10	sec.
Assembly gluing	8 – 15	min.

FOLCO[®] LIT D3 W91 is applied with the common application tools on one or both sides. The coating weight depends on the absorption and the surface conditions of the materials to be bonded. Do not apply below +10 °C (room and material temperature).

Within the open time the parts are to be joined and pressed.

The compatibility with other adhesives has to be checked before mixing.

The final water resistance is built up after approx. 7 days.

Wood discoloration

Usually **FOLCO[®] LIT D3 W91** does not lead to wood discoloration. Because of the varied nature of wood components unpredictable discoloration may in some cases appear. E. g. iron together with the tannin in wood may cause discoloration. We recommend to do your own trials.

Cleaning

Fresh and not yet dried adhesive can be removed with water immediately after use.

Technical Information

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Additional advices

Safety advices	Please consider the material safety data sheet of the product prior to handling.
Storage	<p>In original containers under suitable conditions FOLCO[®] LIT D3 W91 can be stored for min. 12 months. The material should be stored cool and free from frost. A storage temperature of above 25 °C minimizes considerably the storability of the product.</p> <p>The characteristics which are necessary for the products' allowance are checked by our quality control department during production and before delivery. Dependent on the storage temperature and the time the values can change and fall below or exceed the indicated limits. The viscosity of FOLCO[®] LIT D3 W91 may increase after a longer storage time. In this case we recommend to stir the product before use. However, this does not influence the adhesion properties of the product.</p>

This data sheet replaces all former technical information.

Last change: 07.03.2016

The characteristic values required for the product to be released are checked by our quality control department at the time of production; these values may change in line with storage conditions and periods and may be higher or lower than the specified limit values. The advice we provide on the application of our products is based on extensive development work and many years of experience and is given to the best of our knowledge. However, the wide variety of requirements on site under the most diverse conditions mean that it is necessary for the processor to test the product for its suitability in any given case. We reserve the right to make changes in keeping with technical developments or improvements to our products. The agreed product characteristics are exclusively as set out in this technical information sheet. Any further agreements on product characteristics must be made in writing to be valid. This applies in particular with regard to the product's suitability for a specific purpose.