

# Recommended adhesives for SWISSCDF

Application	Product	Type	Properties / Destination	Processing specifications	
Bonding with laminate * HPL 1,3 mm	Collano FL 330	1C dispersion	Universal PVAc joints and veneering, water resistance D3	Applied quantity	100–200 g/m <sup>2</sup>
				Open time at 20 °C	8–10 min.
	Collano DW 2040	1C dispersion	Water and heat resistant wood adhesive (D3, Watt 91) with Collano HR 910 hardener, resistance class D4	Pressing time at 20 °C	> 90 min.
				Pressing time at 60 °C	> 15 min.
Bonding with aluminum * EN AW 505, 1,5 mm, P100 sanding, clean	Collano DW 2040	1C dispersion	Water and heat resistant wood adhesive (D3, Watt 91) with Collano HR 910 hardener, resistance class D4	Applied quantity	100–200 g/m <sup>2</sup>
				Open time at 20 °C	8–12 min.
				Pressing time at 20 °C	> 90 min.
				Pressing time at 60 °C	> 15 min.
Veneer * Oak 0.6 mm	Collano FL 330	1C dispersion	Universal PVAc for joints and veneering, water resistance D3	Applied quantity	100–200 g/m <sup>2</sup>
				Open time at 20 °C	8–10 min.
	Sempadur P 8	Powder urea	Powder adhesive for veneer, low formaldehyde emissions, ideal for E1 bonding	Pressing time at 20 °C	> 30 min.
				Pressing time at 60 °C	> 10 min.
Matched SWISSCDF	Semparoc I 12 NV	1C PUR	PUR adhesive	Applied quantity	100–200 g/m <sup>2</sup>
				Open time at 20 °C	10–15 min.
				Pressing time	> 90 min.
Mounting	Collano BM 866	1C Silan	High Tack - High-resistance adhesive with excellent grip	Bead width	5–10 mm
				Bead distance	10–12 cm
				Filming time	10–15 Min.
				Crosslinking speed	2–3 mm/24 h
Edges * ABS plastic	Collano KE 540/541	Hotmelt EVA	To glue edges of solid wood, veneer, PVC, ABS, polyester and melamine resin	Processing temperature	200–240 °C

\* Material description and finishing

#### Recommendations

The range of adhesives and applications are indicative. Collano offers a number of products for the materials listed in the tabel.

Gluing surface must be flat, clean and dry. To spread out adhesive properly, we recommend using Collano putties. Our technical consultants are available to select and commission adhesive application equipment.

The values in the table refer to tests in standard climate conditions with 20°C temperature and 65% relative humidity, for the described materials and applications. Therefore, deviations from the data sheet may occur.

Data and values are based on Collano's experience. However, materials and processing conditions can affect adhesive behavior and are not subject to our control, therefore the company declines any responsibility and recommends to execute practical tests. For applications and materials other than those included in the table, please contact our technical consultants. Detailed product information can be found in the corresponding data sheet.