

Adhesive recommendation for SWISSCDF (compacted, black coloured wood fibreboard)

Adhesive Bonding of SWISSCDF with:	Syncoll® 102.76 / 102.83	Jowacoll® 103.10 / 103.30	Jowacoll® 119.60	Jowatherm® 280.50	Jowat® 444.00	Jowatherm- Reaktant® 607.60/61	Jowapur® 685.17 / 685.32	Jowapur® 685.33	Jowat-PowerPUR® 687.40	Jowapur® 688.30 / 688.60	Jowat® 2K SE 690.00 / 690.20	Jowat® 696.31	Jowat® 950.21 / 40
Synthetic resin panels HPL													
Wood veneer													
Solid wood													
PE coated SWISSCDF-panels													
Aluminium													
Galvanized steel sheet													
Ceramic tiles													
SWISSCDF surface													
SWISSCDF joints													
Synthetic resin edges (HPL, ABS)													
PVC-coating		(x.30)											

Bonding	Adhesive	Base	Processing data	Remarks
Coating of synthetic resin panels on SWISSCDF	Jowat® 444.00	Contact adhesive CR	Evaporate time: ca. 10 min. Pressing temp.: 15 - 25 °C Pressing time: some sec.	Apply contact adhesive on both sides
	Jowacoll® 103.10 / 103.30	PVAc-dispersion	Open time: 5 - 8 min. Pressing temp.: 20 - 90 °C Pressing time: 30 - 1.5 min.	Waterproof (complied DIN EN 204 D3)
	Jowapur® 685.33 / Jowat-PowerPUR® 687.40	1C PUR	Open time: 35 - 40 min. Pressing temp.: 20 °C Pressing time: 60 - 120 min.	Cooking water proof (DIN EN 204 D4) - recommended use of Jowat® separating agent (901.10)
Veneer of SWISSCDF	Jowacoll® 103.30	PVAc-dispersion	Open time: 5 - 8 min. Pressing temp.: 20 - 90 °C Pressing time: 30 - 1.5 min.	Waterproof (complied DIN EN 204 D3)
Metal bonding with SWISSCDF	Jowat® 690.00 Jowat® 690.20	2C SE-polymer	Processing temp.: 15 - 25 °C Processing time.: 8 - 30 min.	
Universal	Jowat-PowerPUR® 687.40	1C PUR	Open time: 30 - 40 min. Pressing temp.: 20 °C Pressing time: 105 - 120 min.	Cooking water proof (DIN EN 204 D4) - recommended use of Jowat® separating agent (901.10)
Butt bonding with SWISSCDF	Jowapur® 685.17 / 685.32	1C PUR pasty	Open time: 14 - 32 min. Pressing temp.: 20 - 40 °C Pressing time: 80 - 15 min.	Cooking water proof (DIN EN 204 D4) - recommended use of Jowat® separating agent (901.10)
Surface bonding with SWISSCDF	Jowat-PowerPUR® 687.40	1C PUR	Open time: 30 - 40 min. Pressing temp.: 20 °C Pressing time: 105 - 120 min.	Cooking water proof (DIN EN 204 D4) - recommended use of Jowat® separating agent (901.10)
Edge with SWISSCDF	Jowatherm® 280.50 Jowatherm® 607.60	EVA hot melt PUR hot melt	Processing temp.: 140 - 200 °C	Pre-treat panel edges with Jowat® Primer 23 409.15

Remark: Please refer to our technical data sheets, which are available in our Webshop (shop.jowat.ch)

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