

## Recommended adhesives for SWISSCDF

Application	Adhesive type	
<b>Bonding with high pressure laminates (CPL/HPL)</b>	Placol 4506	Powder adhesive for veneer for hot gluing starting from +50°C, heat resistance >+150°C, moisture resistance according to EN 204-D3, formaldehyde emissions E1
	Mirapur 9520 Standard	Reactive liquid PUR adhesive with long open time. Water resistance according to EN 204-D4, heat resistance >+150°C
	Mirapur 9696 2K-PUR	Easy-to-spread 2C pasty adhesive. Heat resistance: 7N/mm <sup>2</sup> (EN 14257, WATT91). Water resistance: EN 204-D4
<b>Bonding with metal</b>	Mirapur 9696 2K-PUR	Easy-to-spread 2C pasty adhesive. Heat resistance: 7N/mm <sup>2</sup> (EN 14257, WATT91). Water resistance: EN 204-D4
<b>Veneering</b>	Placol 4506	Powder adhesive for veneer for hot gluing starting from +50°C, heat resistance >+150°C, moisture resistance according to EN 204-D3, formaldehyde emission E1
<b>Joints (SWISSCDF butt joint onto SWISSCDF surfaces)</b>	Mirapur 9520 Standard	Reactive liquid PUR adhesive with long open time. Water resistance according to EN 204-D4, heat resistance >+150°C
	Mirapur 9521 Standard	Strong reactive PUR adhesive with long open time. Water resistance according to EN 204-D4, heat resistance >+150°C
	Mirapur 9522 Rapid	Strong reactive PUR adhesive with short pressing time. Water resistance according to EN 204-D4, heat resistance >+125°C
<b>Surfaces (SWISSCDF onto SWISSCDF)</b>	Mirapur 9515 Rapid	Reactive liquid PUR adhesive with short pressing. Water resistance according to EN 204-D4, heat resistance >+70°C
	Mirapur 9520 Standard	Reactive liquid PUR adhesive with long open time. Water resistance according to EN 204-D4, heat resistance >+150°C
	Mirapur 9696 2K-PUR	Easy-to-spread 2C pasty adhesive. Heat resistance: 7N/mm <sup>2</sup> (EN 14257, WATT91) Water resistance: EN 204-D4
<b>Butt joint - PVC edges (with hotmelt glue)</b>	Miratherm 5107 natural / Miratherm 5108 white	Granula hotmelt EVA adhesive for butt joints, heat resistance +90°C approx., processing temperature between +180°C and +200°C
	Miratherm 5187 transparent / Miratherm 5188 white	Filler-free granular EVA adhesive for joints, heat resistance +90°C approx., processing temperature between +180°C and +200°C
	Miratherm 5139 natural / Miratherm 5137 white	Solid or granular EVA hotmelt PUR adhesive for butt joints, heat resistance +150°C approx., processing temperature between +120°C and +140°C

### Recommendations

Adhesive processing specifications are illustrated in our data sheets (ligamenta.ch)

Refer to the data sheets and recommendations of SWISSCDF suppliers.

SWISSCDF must be taken to room temperature before bonding, so that wood moisture matches the moisture level in the final destination. Compared to conventional wood-based panels, SWISSCDF requires much longer pressing time, due to higher moisture levels and slower water absorption. Pressing time shall be doubled at least, as specified in the data sheets. After pressing, allow to rest for a suitable period (min. 24h). In any case, it is recommended to carry out your own tests to identify suitable pressing time and resting time until the subsequent operation.

Adhesive information represent the state of the art and are based on the practical experience. When new materials are used, it is necessary to carry out bonding tests. Our recommendations shall be considered as general directives. Refer to the processing methods described in the adhesive and primer data sheet, available for download from ligamenta.ch. Our technical consulting service is ready to support you to select the most suitable adhesive.