

Nordale Craftbond 3000 D3

September 2019

Description:

Nordale Craftbond 3000 D3 is a pre-catalysed, good shelf life, thermosetting PVAc adhesive. This product is ready for use and requires no mixing of catalysts. It is recommended for the bonding of most materials as used in the manufacture of automotive interior components i.e. carpets, fabrics, foam and textiles to timber, compressed cardboard, Triflex and fibreglass. This adhesive cures to provide rapid high strength bonds resistant to heat and moisture. It can be used in hot press, radio frequency (RF) or cold press and conforms to BS EN 204 - Exposure group D3. Nordale Craftbond 3000 has been tested to SCAQMD Rule 1168 and found to have VOC level < 15g/l.

Typical Properties:

Appearance:	White, Dries Clear.
Odour:	Low. Dries odourless.
Viscosity:	Approx. 4500 cP at 23°C
Solids:	Approx. 48 %
pH:	Approx. 3.3

Directions for Use:

Nordale Craftbond 3000 D3 adhesive may be applied via powered roll glue spreader or air assisted/airless spray equipment. Nordale Craftbond 3000 D3 is designed for use with hot press or radio frequency (RF) equipment or standard cold press setups.

- Ensure adhesive is stirred well prior to use.
- All surfaces to be bonded must be clean, dry and free from dust, oil grease etc.
- Timber moisture content should be between 10% and 14%.
- Ambient and timber temperatures should be above 15°C (Do not use below 10°C)
- Can be applied using powered roll glue spreaders, air assisted airless spray equipment, brush, hand roller or extrusion.
- Is suitable for use with both hot and cold presses.
- Adhesive should be applied as a thin, even coating to one surface only. Parts should be combined, while the adhesive is wet, using good even pressure (30 to 130psi is recommended) until the adhesive has set. See cure requirements below.

Hot Press Cure	60 – 90 seconds @ 100°C (dependant on coating weight and substrate thickness)
Radio Frequency Cure	A low power setting is preferred to produce workable amperage without arcing. A minimal change after the initial amperage drop-off will indicate adhesive is set.
Cold Press Cure	20 – 30 minutes @ 23°C

For wood veneer laminates to MDF, plywood, HMR or MR boards the recommended coating weight is 80 – 120 gsm dependant on the surface roughness and porosity.

For lamination of High Pressure Laminates to particle board or MDF board using a hot press the following settings have been found to be generally suitable.

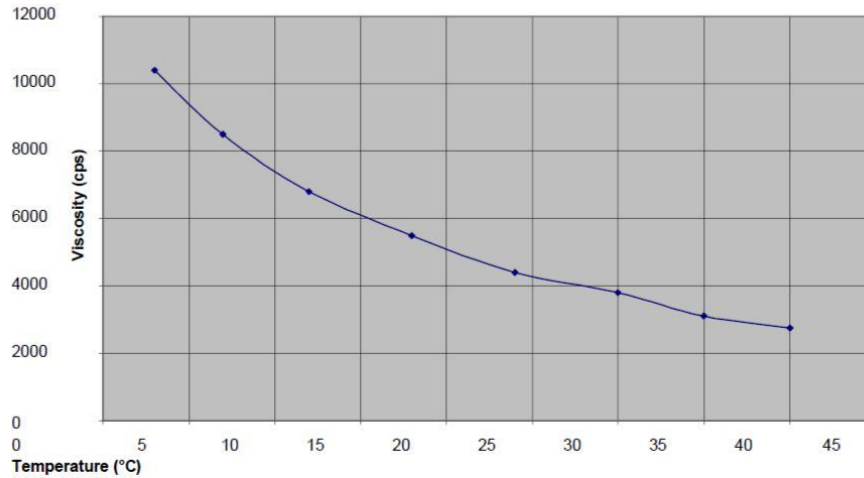
Adhesive coat weight	70 – 80 gsm
Temperature	80 °C
Press time	2 minutes
Pressure	100 – 150 psi

Nordale Craftbond 3000 D3 will change in viscosity as the temperature changes, roll coaters and other applicators should be adjusted in order to compensate for these viscosity changes. Higher viscosity can create higher coat weights and vice versa. See graph below.

Nordale Craftbond 3000 D3

September 2019

442.3051 Viscosity vs Temperature

**Limitations:**

Due to the nature and consistency of MR MDF and HMR Particle board, it is recommended that the surface is sanded prior to bonding. Nordale Craftbond 3000 D3 should not be used when timber and ambient temperatures are below 10°C. Nordale Craftbond 3000 D3 is unsuitable for load bearing applications.

Clean Up:

With water whilst wet.

Storage and Handling:

Please read the Material Safety Data Sheet for this product BEFORE use. Viscosity of this adhesive will increase with time in storage. Product should be stored between 5°C and 30°C on a wooden pallet and kept from freezing. Rotate stock using oldest material first. Keep stock covered to prevent drying out and contamination. Do not mix with other adhesives. Supplied ready for use but can be diluted with water if required.

Please ensure that products classed as a dangerous good are stored in compliance with the applicable regulations.

Shelf Life:

Best used within 6 months from date of manufacture when stored under the above conditions in the original unopened containers.

Last Updated: 07-09-2015

DISCLAIMER

Any information given is, to the best of our knowledge, the best currently available, with respect to our products and their use, but it is subject to revision as additional knowledge and experience is gained. Such information is offered as a guideline for experimentation only and is not to be construed as a representation that the material is suitable for any particular purpose or use. Customers are encouraged to make their own enquiries as to the material's characteristics and, where appropriate, to conduct their own tests in the specific context of the material's intended use. This information is not a license to operate under nor is it intended to suggest infringement of any patent. We guarantee a uniform quality standard for this product. The only conditions and warranties accepted by Henkel in relation to this product or process are those implied by either Commonwealth or State statutes.

All Technical Data Sheets are uncontrolled documents, copies are not automatically updated