

## W-Leim Plus 3000

9581

Self-curing adhesive powder for hot bonding

### PRODUCT DESCRIPTION

#### Product numbers

9581000300

#### General

W-Leim Plus is a self-curing adhesive powder with low formaldehyde emission and a soft glue line for hot bonding of veneers and (priming) films.

#### Application area



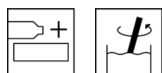
Hot bonding for veneering and film coating in a temperature range of 70 °C - 140 °C.

Stress class C3 in accordance with ÖNORM EN 12765.

The subsequent formaldehyde emission complies with the requirements according to the German Chemicals Prohibition Ordinance when tested by gas analysis in accordance with EN 717-2.

### PROCESSING

#### Processing instructions



- For critical wood species (e.g. birch, teak, pine, maple), wetting difficulties may occur (the veneer may peel off easily). We recommend adding 10 to 30 % of Weißleim D2 to the adhesive mixture for these veneers.
- Before starting work, please carry out a trial bonding and a pull-off test.
- Before processing the adhesive mixture, a waiting time of 15 minutes and stirring again are recommended.
- Any change in the processing sequence, environmental conditions, non-observance of instructions or the use of products not listed may have an unfavourable effect on the result.

#### Blending ratio

|                                          | W-Leim Plus 3000 | Cold water    |
|------------------------------------------|------------------|---------------|
| For manual application (spatula, roller) | 5 kg             | approx. 3 l   |
| For machine application                  | 5 kg             | approx. 3.5 l |

The powder must be mixed to a smooth, lump-free adhesive mixture.

**Pot life**

| Ambient and adhesive mixture temperature | Pot life        |
|------------------------------------------|-----------------|
| 20 °C                                    | approx. 5 - 6 h |
| 25 °C                                    | approx. 4 h     |
| 30 °C                                    | approx. 2 h     |

Machine application: in the event of severe thickening of the adhesive mixture, empty and clean the machine as quickly as possible.

**Application technique**

The adhesive mixture from W-Leim Plus 3000 can be applied manually using a spatula or a suitable roller, as well as by machine.

|                                                                              | Application quantity     |
|------------------------------------------------------------------------------|--------------------------|
| Bonding of films to particle boards                                          | 60–100 g/m <sup>2</sup>  |
| Veneering of particle boards                                                 | 100–150 g/m <sup>2</sup> |
| Open assembly time from application of the adhesive to assembly of the parts | Max. 5 mins              |
| Closed assembly time from assembly of the parts to pressing                  | 20 - 30 mins             |

The closed assembly time depends on the adhesive application quantity, ambient temperature, humidity, wood species, wood moisture content, wood temperature and the absorbency of the substrate panel.

Pressing pressure:

0.4–1.5 N/mm<sup>2</sup> (4–15 kg/cm<sup>2</sup>) depending on the fit accuracy

Pressing times:

|       |          |        |          |
|-------|----------|--------|----------|
| 70 °C | 9 mins   | 100 °C | 2 mins   |
| 80 °C | 5 mins   | 110 °C | 1.5 mins |
| 90 °C | 3.5 mins | 120 °C | 1 min    |

For the specified press times, the heat penetration of wood veneers up to approx. 0.7 mm thickness is already taken into account. For bonding of plastic panels, we recommend extending the press time by approx. 50 % of the press times specified above.

**Cleaning the working equipment**

Clean immediately after use with warm or hot water.

**ORDERING INFORMATION****Size of trading unit**

25 kg (carton containing 5 × 5 kg)

**FURTHER DETAILS****Durability / storage**

Min. 2 year(s) in the original sealed containers.

Make sure the product is protected against, direct sunlight, frost and high temperatures (above 30 °C).

Close opened containers well and use up the content as soon as possible.

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### Safety information



As with all urea-formaldehyde adhesives, W-Leim Plus 3000 may also release traces of formaldehyde, which may cause irritation of the skin and mucous membranes in sensitive persons. We therefore recommend good ventilation and the installation of appropriate extraction systems above the presses and other machines.

During work, wear closed protective clothing, protective gloves and safety goggles with side protection. If the product comes into contact with your eyes, rinse immediately with water and consult a doctor! If the product comes into contact with your skin, wash off immediately with plenty of soap and water!

Further information on the subject of safety during transport, storage and handling as well as disposal can be found in the relevant safety data sheet. The current version can be accessed on the Internet at **[www.adler-lacke.com](http://www.adler-lacke.com)**.

The product is only suitable for industrial use.

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