

PG380/C15

PG380 water-based polymer emulsion adhesive has to mix with bridging agent to use. It has very good weather resistance, D4 waterproof rating, which is suitable for cold-pressed and hot-pressed integrated paneling of medium-hard wood.

Product parameter details

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| Item No. | PG380 | C15 |
| Product | Water-based polymer emulsion | Isocyanate hardener |
| Appearance | Liquid | Liquid |
| Color | White | Brown |
| Viscosity | 11000±2000 cps | 200±50 cps |
| pH | 7±1 | / |
| Solid content % | 48±2 | 97±2 |
| Storage period | 9 months | |
| Storage conditions | Store in a sealed original container, store in a cool place, and avoid heat, sun or freezing. The storage temperature is suitably between 10-35 °C. It is recommended to stir evenly before using the barrel. | |

User Guide

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| Application range | Window frame components, solid wood panels, flooring, 2-layer composite flooring (glued flooring). |
| Mixed ratio | PG380 main agent : C15 Hardener =100:15(weight ratio) |
| Applicable period | Above 25 °C, PG380: C15=100:15, glue after mixed should be used up within 40 minutes. The longer the application time, the higher the viscosity and the worse the penetration performance. |
| Lowest operating temperature | 5°C |
| Thermal activation temperature: | 50-80 °C, the temperature should not be too high to prevent the PVC skin from deforming when heated. |
| Wood moisture content | 8-14%, If high moisture content of the wood needs to extend the pressurization time. The excessive moisture content of the wood will cause cracking due to shrinkage during the drying process. |



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| Wood Preparation | In order to obtain the best bonding strength, the wood surface must be planed. For a better bonding strength, the gluing should be carried out within 24 hours after the wood shaving. For wood with more oil or resin, it should be glued within 4 hours after wood shaving. |
| Glue spread amount | Generally 250-280g /m2, depend on the application conditions. If the ambient temperature above 30 °C please use 300g / m2 for or use double-sided adhesive application to improve. The short aging time can reduce the amount of glue. After pressing, please check whether the glue amount is proper by checking whether the glue is extruded uniformly. |
| Pressurization time | Ambient temperature above 25°C, wood moisture content around 8%-14%, pressurization time should be 45 min at least. The higher the density of wood, the greater the environmental humidity, the lower the ambient temperature, the longer the pressing time. |
| Pressurized pressure | The pressure depends on the material of the wood being bonded. The bonding surface to be in direct contact should choose the maximum pressure strength. The pressures recommended for various wood species are: low density 7.0 - 10.0 Kg/cm2, medium density 9.0-12.0 Kg/cm2, high density 12.0-17.0 Kg/cm2. The pressurization of the panel is clamped every 20-25 cm from the beginning of 5 cm to ensure pressure equalization. |
| Open time | The ambient temperature above 25 °C should be completed within 5 minutes. The longer the open time, the higher viscosity, and the lower the permeability. After applying glue, open time is usually different with difference operating environment temperature, humidity and amount of distributed glue. The shorter time, the faster pressure is applied, and the better bonding strength is. |
| Processing health requirements | After depressurization, the indoor temperature above 25 °C needs to be kept for at least 4 hours before entering the next process, and the maximum bonding strength is reached after 7 days. |

Machine

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| Gluing machine | Single wheel gluing machine, two-wheel gluing machine, three-wheel single-sided gluing machine, four-wheel double-layer gluing machine, chain type gluing machine, etc. |
| Mixing machine | Mixer, mixer MG002, mixer MG003, etc. |



Operational suggestion and health, safety and environment protection information

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| Operational suggestion | This product contains isocyanates, so protective gloves suitable for isocyanates should be worn. The curing agent must not come into contact with water or moisture. |
| Cleaness | Must be cleaned before the system is cured. |
| Health, environmental protection and safety | Glue-cured glue can be treated as a general non-hazardous waste. Curing agent - contains isocyanate and should be disposed of as hazardous waste. The blended gum and curing agent - which are fully cured, can be disposed of as a general, non-hazardous waste. |

Legal Terms

This information is based on laboratory testing and long-term actual production experience. This is an introductory message designed to help users find the best way to work. Because the end user's production conditions are outside our control, we are not responsible for the results of the work affected by each user's own production conditions. In any case, we recommend testing to determine the appropriate production process parameters prior to use.