

## PG95

PG95 is one-component D3 high-quality emulsion wood glue with fast curing speed, good filling properties, good waterproof and weather resistance properties, and is suitable for various process structure assembly and panel assembly applications. It could use for high frequency lamination.

### Product parameter details

Item No.	PG95
Product	Polyvinyl acetate polymer emulsion
Appearance	Liquid
Color	Light brown
Viscosity	17000±2000 cps (Brookfield Viscometer RVT, sp4, 10rpm, 25°C)
pH	3±1
Solid content %	50±2
Storage period	9 months (sealed storage)
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 glue.
Formaldehyde information	The finished products manufactured by this system can reach the E0 standard.
Discoloration	The product does not discolor wood. However, the reaction of iron ions with tannic acid in some woods, especially alders, can cause wood discoloration. To avoid this situation, it is recommended to test before using.

### User Guide

Application range	Window frame components, solid wood panels, veneers, floors, doors, bamboo products, wood structures, etc.
Pressure type	Cold press, high frequency press, hot press, jigsaw machine, continuous press machine, etc.
Wood moisture content	8 – 12%, high water content needs to double the pressurization time. Excessive moisture content in the wood can cause cracks due to shrinkage during drying.
Wood Preparation	For best results, the wood surface must be planed. For best glue strength, glue should be applied within 24 hours after the wood is planed. For woods with a

Winlong GW International Technology (Qingdao) Co., Ltd.

Web:<https://www.internetwoodglue.com> Email: [iwgytn@gmail.com](mailto:iwgytn@gmail.com) Whatsapp: +8613929521503



	high oil content or resin, gluing should be carried out within 4 hours after the wood is planed.
Amount of distributed glue	Single-sided glue: 100—200g/m <sup>2</sup> The amount of distributed glue depends on the materials, and the specific application technology. When gluing hard wood and oily materials, the material should be freshly processed and glued on both sides.
Open time 30°C	The open time after glue spray usually varies with the amount of glue and the operating environment temperature and humidity. The shorter the open time, the faster the pressure
Pressure	0.1-1.0MPa. the highest processing accuracy, and the better bonding on the surface, which can get better glued effect.
Pressurization time	At 25 °C, the non-rebound structure is assembled and pressurized for 2-5 minutes. At other temperatures, when bonding other materials and products with higher pressure structures, the pressurization time depends on the application process.

### Machine

Gluing machine	Sawtooth scraper, brush, MM3 rubber wheel, manual glue applicator, assembly bottle, glue applicator, etc.
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### Operational suggestion and health, safety and environment protection information

Operational suggestion	Gloves and goggles should be worn each time the product is used.
Cleaness	Wash the skin and the glue on the device with warm water. Must be cleaned before the glue is cured
Health, environmental protection and safety	Generally considered to be harmless waste. The remaining gel is left to dry and then disposed of as 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.

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