



ADVABOND XL3 (5000)

Description

ADVABOND XL3 (5000) is a high performance, one-part cross-linking PVA wood glue which when cured gives strong bonds in general carpentry, door pressing and veneering applications. With a slightly lower viscosity, it is ideal for laminating.

Bonds made with ADVABOND XL3 (5000) exhibit good heat and water resistance and will conform to EN 204 ó Group D3. It is therefore ideal for use in high humidity areas such as bathrooms and laundries.

ADVABOND XL3 (5000) is classed as fast setting and responds well to RF curing.

Typical Properties

Appearance	White creamy liquid
Dry Film	Tough and hard yet flexible
Viscosity	4,500 ó 5,500 cPs
Total Solids Content	47 - 49 %
Specific Gravity	1.06 g/ml
pH	3 - 5

Application Information

ADVABOND XL3 (5000) is designed to be used by roller. Dilution is not recommended. Ensure substrates are free from oils dirt or grease.

Woodworking

- Timber moisture content should be between 10% and 12%
- Ambient and timber temperatures should be above 15°C. Best results are obtained when operating in the temperature range of 18-23°C.
- Apply enough adhesive to ensure the glue line is fully covered and wet-out when surfaces are pressed together.
- 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; 200-900 kPa (30 to 130 psi) is recommended.
- Parts should be clamped for 3 to 4 hours and will reach full strength in 24 to 48 hours, depending on the moisture content of the timber, ambient temperature and humidity.

Door Pressing and Veneering

- Application rate should be tested on each species of veneer. It will vary depending upon absorption rates but an indicative norm to achieve good bonds is 190-240 gsm.
- Open time should not exceed 5-10 minutes.
- Assembly time should not exceed 20 minutes.
- Best results are obtained by a pressing platen temperature of 90-105°C for approximately 45-60 seconds using a pressure of 400 ó 600 kPa (4 ó 6 bar).

All information is based on results gained from experience and tests therefore believed to be accurate but is given without acceptance of liability for loss or damage attributable to reliance thereon as the required performance, production techniques and substrates used can vary significantly. Therefore it is imperative that a full evaluation is undertaken to confirm the suitability of the product before commercial production.



Limitations

Do not use ADVABOND XL3 (5000) below 10°C.
ADVABOND XL3 (5000) is not suitable for exposed exterior or load bearing applications.
For higher viscosity, try ADVABOND XL3, or even ADVABOND XL3 HV.

Cleaning

Clean up adhesive while wet with warm water.

Storage

Product should be stored in the original container out of direct sunlight between 5°C and 30°C and protected from freezing. Rotate stock using oldest batches first. Close containers air tight after use. For best performance use product within 12 months.

Safety & Disposal

This material is non-hazardous. Refer to the Material Safety Data Sheet (MSDS) for further information.

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