

**PVAc 1K D4 Glue
with high heat resistance (WATT '91)**

Application: For all bonds with good heat resistance (Watt '91) requiring increased resistance to wet environments, e.g. for doors, windows and furniture in high-humidity areas. General-purpose glue for soft and hardwood bonding, as well as for particleboard and other wood-based substrates.

Characteristics/ Directions for Use: If used according to instructions, Jowacoll® 107.20 will meet the requirements according to durability class D4 according to the standard EN 204/205, and the EN 14257 (Watt '91) > 7.0 N/mm². Meets the FFF-FKS-EMPA guideline 08.03/2013 (Switzerland).
Slow setting; the glue sets fast at temperatures above 70°C.

We recommend that all materials coming into contact with the glue are made of high-quality stainless steel (German standard V4A according to DIN EN 10027 – W-No. 1.4571 or better) or of inert plastics, e.g. Teflon, PP, polyamide. Avoid contact with other metals like zinc, brass, copper or aluminium. For more information, contact the equipment manufacturer or our technical service.

For all standard applicator systems. Reactive PVAc dispersions may undergo an increase in viscosity during the storage period, due to their components. Higher temperatures contribute to this increase in viscosity. The product should therefore be stirred before use. Storage at higher temperatures will lead to considerably shorter shelf life.

The different composition of the wood ingredients, depending on e.g. the wood species, origin, logging time, and treatment, may lead to (possibly delayed) discolouring. For instance, due to the reaction between iron and tannic acid. Avoid contact with alkaline substrates.

Min. temp. for materials, glue and room air [°C]:	15 (not identical with minimum film-forming temperature)
Appearance of the glue film:	colourless translucent
Classification according to EN 204:	D4
Density at 20 °C [g/cm ³]:	approx. 1.05 ± 0.05 (Jowat test method)
Application amount [g/m ²]:	approx. 150 ± 50
Glue application:	one- or two-sided
Open assembly time at RT [min]:	approx. 10 ± 1 (Jowat test method)
Pressure [N/mm ²]:	> 0.5
Minimum pressing time at RT [min]:	
at RT:	approx. 20
at 50 °C:	approx. 3
at 90 °C:	approx. 1

Tested at 6 – 10 % wood moisture following the standard EN 204/205 (20 °C / 65 % RH), with a glue application of approx. 150 g/m²

Specification:	Viscosity at 20 °C [mPas]:	5,000 ± 2,000
	(Brookfield, RV, spindle 5, 20 rpm)	
	Solids content, 2 h at 90 °C [%]:	49 ± 2
	(Jowat test method)	
	pH value at 20 °C:	3.0 ± 0.5
	(Jowat test method)	

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03/17 All data indicated are characteristics represented as average values. Our technical data sheets are constantly revised to represent the latest state of technology. This edition is replacing all previous ones, and is valid on the date of compilation.
Please refer to the last page of this technical data sheet for additional information.



Cleaning: Machines and equipment may be cleaned after use with warm or cold water, using Jowat® Cleaner Concentrate 192.40.

Storage: In properly closed original containers, cool and dry (15 – 25 °C). Storage temperatures below +10 °C and above +30 °C lead to drastic change in viscosity, may alter the adhesive properties and must be avoided! Best-before date, please refer to label on the packaging unit. Protect against frost!

Packaging: Types of packaging and units upon request.

Remarks: **For further information concerning safety, handling, transport and disposal, please refer to the Safety Data Sheet.**

Our information on this data sheet is based on test results from our laboratories as well as on experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding for us. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from these indications nor from the recommendations made by our free technical advisory service.

Jowat Information

Gluing as one of the most efficient methods of bonding is constantly gaining importance and expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are developed.

The in-house R & D departments of Jowat are responding with intensive efforts to keep pace with these constant changes. A highly qualified team of chemists and engineers is using the latest techniques and brightest ideas to provide the utmost in advice our customers and to make sure that they get the adhesive which meets their needs.

Our information is based on test results from our laboratories as well as on experience gained in the field by our customers. This advice, however, cannot cover all eventualities for each specific application and as such is not binding for us. Please, contact our technical service department in each case to find out what the actual technical state of development for the respective product is, and request the latest data sheet. Any use of our product without this precautionary measure would be your sole responsibility.

The processing company itself must therefore test the adhesives manufactured by us for suitability in each individual case. This applies to the first use of a sample as well as to modifications during an ongoing production.

We are therefore requesting all our new customers to test our adhesives for suitability on original parts at conditions equal to normal processing conditions. The bond has then to be subjected to the actual stress which it would undergo when in use and has to be assessed. This test is absolutely necessary.

Customers who undertake modifications during a running production are requested to pass this information on to us. Please notify us when machines are set to new parameters as well as when the substrates to be bonded are changed. Only then will Jowat be able to provide our most up-to-date information to the processor using our adhesives.

The information given in this leaflet is based on practical experience and on results of tests in our laboratory, and does in no way constitute any guarantee of properties. No liability may be derived from these indications nor from the recommendations made by our technical advisory service.