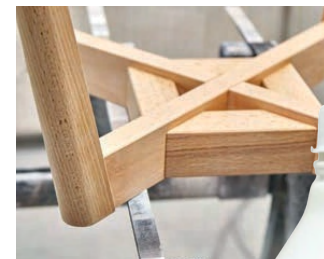
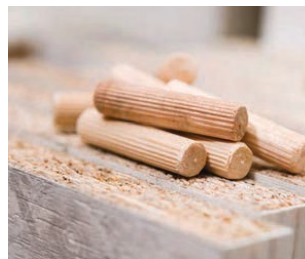
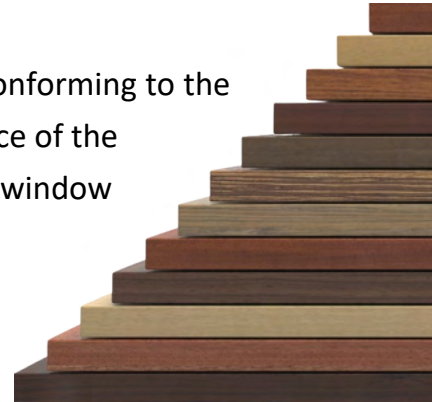


Product Information Sheet

Protak 603

Protak 603 is a high quality one component water resistant PVA adhesive conforming to the EN204 standard D3. The addition of Protak CL2 increases the water resistance of the glue line to conform to group D4 if required. Protak 603 is used for bonding window frames, stairs, doors, Radio Frequency gluing, bonding of laminated panels, carcass/assembly gluing and any other surface gluing of veneers and laminate material (High Pressure Laminates) onto different substrates.



Glue Spread

Wood Laminates	120 - 160 g/m ²
Flat Surfaces	100 - 150 g/m ²
Assembly	100 - 200 g/m ²
Wood Flooring	15 - 20m ² /1 litre bottle

Features

- High Creep Resistance
- High Heat Resistance
- Fast Setting Time
- Water-Based
- Flexible Bonds



Application Data

Packaging	1kg bottles, 5kg and 25kg cans, and 1125kg IBC
Storage Temperature	Store in a cool and dry place between 15°C and 25°C (59°F - 77°F). Protect against frost
Storage Life	The product may be stored for up to 12 months in original, unopened containers
Application Conditions	Room temperature and materials to be bonded between 18°C - 20°C (64°F - 68°F), humidity of wood between 8 - 12%. Bonding must be carried out at temperatures above the minimum film forming temperature, we suggest at least 5°C - 8°C (41°F - 46°F)

Product Information Sheet

Protak 603

Application Instructions

- Protak 603 must be spread uniformly on the surfaces to be bonded, using a spatula, glue roller/spreader or any other suitable equipment
- Machining of the wood and the bonding thereof, must be done, as much as is practical, on the same day (some types of wood eg. IROKO, need to be bonded within a few hours)
- The surfaces to be bonded must be assembled before the maximum open time has expired, and pressed until sufficient bond strength is achieved
- When bonding high-pressure laminates, take care that on the reverse side of the laminates, there are no anti-adhesive substances that can influence the bonding characteristics
- During the hot season, the viscosity of the adhesive on the glue spreader could increase; if this is the case, 1-3% water should be enough to bring the viscosity to the original value
- Care must be taken with some species of wood with high contents of resin, tannin and other substances, which can cause discoloration
- Clean all working tools and equipment immediately after use with water

The pressing time is greatly influenced by the ambient conditions, types of wood, amount of adhesive spread and the structure of the materials to be bonded.

Decorative paper foils @ 176 - 212°F	5 seconds
High pressure laminate and veneers at @ 176 - 194°F	50 - 70 seconds
High pressure laminate and veneers at room temperature @ 64 - 68°F	20 - 40 minutes
Solid wood at room temperature	20 - 25 minutes
Solid wood at @ 122 - 158°F	8 - 10 minutes
Solid wood with RF	2 - 3 minutes

Technical Data

Chemical Base	Polyvinyl Acetate (PVAc)
Solid Content	45%
Viscosity	11.500 mPa.s at 20°C (68°F)
pH	2.5 -3.5
Color	White
Moisture Content of Wood	8 - 10%
Open Time (150g/m² glue coat)	Up to 12 minutes

Please consult the Protak 603 Material Health & Safety Data Sheets for safety regulation information.