Technical Data Sheet

Wisacoll® WL 530

High-quality D3 white glue for all types of wood, parquet and window construction

Application areas

Ready-to-use adhesive for wood-based materials and other absorbent substrates. Typical areas of application are:

- window and door construction, especially for gluing the corner joints of window and door frames (slot and tenon bonding)
- surface gluing of HPL, MDF and plywood boards
- surface gluing in the production of partition walls and elements
- gluing of laminate panels
- finger joint bonding
- stair construction and parquet flooring
- hardwoods and exotic woods
- paper and cardboard craftwork
- suitable for the interior zone and in outdoor areas protected from moisture

Product benefits

- outstanding proccessing
- humidity resistant acc. to cat. D3 acc. to EN 204
- high mechanical strenght properties
- transparent (when dry)
- sandable
- recoatable
- water-based
- no labelling obligation
- solvent-free (VOC-free)
- almost odourless
- for indoor and outdoor use (without direct exposure to weathering)
- suitable for cold, hot and high-frequency gluing

Base

PVAC-dispersion (physically drying)

Restrictions

Not suitable for oil and bitumen-containing substrates, PE, PP, PTFE (Teflon®), glass, acrylic glass, waxy substrates, use in standing water. Not recommended for untreated metals (may cause corrosion). Some types of wood may have discolouration due to the content of the wood. Our range of products offers you a choice.

Cleaning agents

Wisatyp TL 16 for cleaning non-absorbent adhesive surfaces and fresh product residues. Fresh adhesive can also be removed with a damp cloth or water. To wash your hands, please use water and soap.

Processing

The bonding surfaces must be sound, dry and free of dust and grease.
Clean non-absorbent surfaces with Wisatyp TL 16.
Check treated and non-absorbent surfaces with an adhesion test.

- Stir or shake the product well before use to ensure a homogeneous mixture.
- To ensure that the adhesive can dry quickly, at least one bonding surface should be absorbent.

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- Apply the product to one side. For this purpose, the following tools are suitable e.g. roller, roller, toothed spatula, glue applicators etc. The applicators must be made of chrome steel or plastic.
- The parts to be bonded should then be brought together as quickly as possible, with any necessary adjustments.
- Press the parts until sufficient functional strength is achieved. Only a high pressing pressure gives a high final strength.
- The pressing pressure should be >1 N/mm^2. Experience has shown that the final strength increases with the level of pressing pressure.
- When gluing wood, the wood moisture content must not exceed 15 % or fall below 8 %.
- Precise fit is absolutely essential.
- Provide the exterior wood with a suitable surface protection and protect it structurally.
- For window construction, we recommend observing the guidelines of Institut für Fenstertechnik «Bonding to wooden windows».

Density

ca. 1.1 g/ml

Consistency

liquid, paintable

Film properties

tough-elastic

pH-value

ca. 3

Dry content

ca. 50 %

Viscosity

ca. 14‘000 mPa*s

Tensile strength

>14 N/mm^2	after 7 d
12 - 14 N/mm^2	after 24 h
7 - 9 N/mm^2	after 1h

Open time

max. 10 min under normal conditions (+23 °C, 60% rel. humidity)

Pressing time by temperature

Application	Pressing time	Temperature
Assembly press	from 15 min	23 °C
Hot plates	2 - 4 min	70 - 90 °C
High frequency bonding	0.5 - 4 min	23 °C

The above values are indicative. Pressing time, time to functional strength and through-hardening are largely dependent on temperature, application quantity and substrate. The processor must add appropriate safety margins to the specified guide values.

Recoatability

After complete drying, good coatability with most water-based and synthetic paints (excluding mineral colours).
It is advisable to test the compatibility with the colours concerned before application.

Temperature resistance

from -20 °C up to +80 °C (after complete cross-linking)

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Substrates	Wood, wood-based materials, wooden components, hardwoods and exotic woods, parquet floors, HPL, MDF and plywood boards, cardboard, paper and other absorbent substrates. For further surfaces, you will need to carry out your own tests.
Processing temperature	from +5 °C up to +35 °C (frost susceptible)
Further information	More information about this product (current technical data sheet, safety data sheet, certificates, product variants, etc.) can be found via the adjacent QR code.
Colour	**transparent** (when dry) resp. **white** (when still wet)
Consumption	ca. 100 - 250 g/m^2
Item no. / Delivery form	**WL 530.750** PE bottles of 750 g (PU of 9 PE bottles) **WL 530.10.** PE cans of 10 kg **WL 530.1000.** IBC of 1000 kg
Shelf life	In closed original packaging, protected from direct sunlight and stored in a dry place between +15 °C and +25 °C, the official shelf life is at least 24 months from date of production (the printed expiry date is decisive).

Safety and disposal: Familiarise yourself with the valid Safety Data Sheets (SDS) for the products used. All applicable safety regulations and disposal instructions must be observed.