

PROTODUR 303 HF/E1 Self Hardening

Powdered self-hardening urea-formaldehyde adhesive with medium reactivity. Designed for the bonding with high frequency systems or hot presses. Low tenor of formaldehyde in compliance with standards E1 (stated according to EN 717-2/94 CATAS Certification enclosed).

Chemical-physical features and optimum conditions for use:

- Condensation product : urea – formaldehyde
- Colour : white - beige
- Aspect : powder
- Pot-Life at 45°C : 75 ± 25 minutes
- Gel time at 100°C : 55 ± 10 seconds
- pH at 20°C : 5 – 5,5
- Volatile substances : max. 2%
- Mixing ratio : 2:1 (kg. 10 Protodur 303 HF/E1; kg.5 of water)
- Suggested weight : 100 – 180 gr./m²
- Material humidity : 8 – 12%
- Gluing pressure : 2 – 8 kg./cm² (according the application)
- Minimum temperature of use : + 5°C

Method of use

In case of particularly difficult veneer elements to be glued, we suggest to modify Protodur 303 HF/E1, with 10% of our Protovil VP 420. In this case a much more plastic gluing is obtained.

Uses:

Suitable for gluing: veneer, rotary cut veneers, sandwich elements by means of hot and high frequency systems in compliance with standard E1.

The final conformity certification of the glued panels in compliance with the standard E1, must be carried out through a laboratory exam.

Examples of hardening time depending on temperature.

Temperature (°C)	20	30	90	100	110
Freezing time	8 hours	3 hours	2 minutes	60 seconds	40 seconds

Biologic effect

Protodur 303 HF/E1 as well as all urea – formaldehyde condensing products can cause skin allergy to hypersensitive persons.

Avoid direct contact of the hands with the glue using latex gloves. It is necessary to provide to an adequate ventilation in the work ambient in order to reduce mucous irritation due to formaldehyde.



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Warnings

The product, as well as all the self-hardening ureic bonding agents, has a validity, from a technical applicative point of view, of 6 months of the manufacturing date, if kept in the original, well closed packing, in a dry and cool place, away from any heat source. After expiry date stated on the packaging, we will not assume ourselves any eventual responsibility which could happen. Once the bonding agent has expired, becomes lumpy and difficult to dissolve.

BEST USED: within 6 months of the manufacturing date

Specifications sheet updated: March 2005

This product's safety sheet is available upon request.

All information and recommendations in this bulletin are based upon practical experience and they don't exempt our customers to make tests when they receive the goods. We can bring changes to our characteristic details of our products in according with the technical and productive development. All information in this bulletin request some tests, because there are many details which are not verifiable during the working from us, particularly when you use raw materials of other suppliers. Our suggestions don't exempt you to check and in any case to resolve the problem when there is a possible violation of patents of other suppliers.



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