

Ponal

Super 3

Premium PVAC White Glue

**Meets the requirements
of durability classes
D3 and D4
(with Ponal D4 Hardener)**

PROPERTIES

- ▶ Water-resistant bonding in compliance with DIN EN 204 (D3)
- ▶ Heat resistance > 7 N/mm² according to DIN EN 14257 (WATT 91)
- ▶ Elastic glue joint
- ▶ Resistant to ageing
- ▶ Transparent
- ▶ Short curing time

SCOPE OF USE

- Assembly bonding of windows and doors
- Laminating of window scantlings (with D4 Hardener)
- Gluing HPL (high pressure laminates) on wood-based materials
- Gluing of wood and wood-based materials
- Complies with ift guideline "Bonding on Wooden Windows", part 2 (D3) and part 1 (D4) (with Ponal D4 hardener)

APPLICATION

Material preparation:

The surfaces to be glued must be properly prepared to ensure a precise fit and must be clean. If necessary, clean tannin-rich wood species (e.g. teak) with a solvent (e.g. acetone).

Wood moisture should be in the range of 8 to 12 %. Higher moisture contents above 15 % will affect the adhesive strength.

Glue application:

Apply Ponal Super 3 with a paint brush, plastic glue comb (Ponal glue spatula), manual roller or glue application machine. Do not allow contact with tools containing iron.

Press pressure:

Depends on the structure, shape and thickness of the material. Minimum force: 0.2 N/mm²; for hardwood and HPL: 0.3–0.5 N/mm².

When gluing work pieces under tension, choose the higher press pressure.



Press time:

Depends on wood species, wood moisture and temperature (wood and room temperature) as well as on the amount of glue applied. Under normal conditions the minimum press times are as follows:

1. Wood: approx. 15 to 20 minutes at +20 °C
2. HPL boards:
 - approx. 40 minutes at +20 °C
 - approx. 25 minutes at +40 °C
 - approx. 15 minutes at +60 °C

When using the method of hot-press gluing, wait until the work pieces have cooled down before continuing work.

SPECIAL INFORMATION

Short name / Packaging unit

PPL12	12 professional glue bottles	420 g
PN4SN	1 bucket	5 kg
PN3SN	1 bucket	10 kg

PN2S	1 bucket	30 kg
PN2SB	2 sausage bags	2 x 5 kg
PN1LB	glue box	9 kg

IMPORTANT INFORMATION

Open time:

The open time depends on the amount of glue applied, ambient temperature, air humidity, wood moisture and wood species. At a room temperature of 23 °C, the maximum open time is 10 minutes. Join the work pieces while the glue is still wet.

Discoloration of the wood:

Ponal Super 3 has a pH-value of approx. 3. Due to different combinations of wood extractives, which depend e.g. on wood harvest time, wood growing region or wood pretreatment, discoloration may occur. Susceptible wood species are among others maple, beech, pear and cherry wood where the discoloration may also occur with a delay. In these cases, especially when doing veneer work, use Ponal Pressal Hydro Veneer Glue or Ponal Wide-Area Glue. When using the glue for outdoor applications, make sure to provide structural wood protection and protect the glued joint from direct weather exposure. For this purpose, apply a suitable surface protection coat on the wooden work pieces. Tanniferous wood (e.g. oak) may darken after contact with iron-containing tools. This kind of staining can sometimes be removed with an oxalic acid solution (concentration: 2–3 %).

Tool cleaning:

Immediately after use clean the tools with cold water.

Storage:

Store Ponal Super 3 tightly closed in a dry and frost-free place. If the glue has thickened due to low temperatures, allow it to soften at room temperature. After that, stir vigorously. Normally, this does not affect the glue quality.

TECHNICAL DATA

Raw material base:	polyvinyl acetate
Density (spec. gravity):	approx. 1.1 g/cm ³
Viscosity:	approx. 12,000 mPas
Application temperature:	Do not apply below 7 °C material and ambient temperature.
Pot life of the D4 quality:	8 hours
Consumption:	approx. 150 g/m ² depending on the substrate absorbency
Durability class (DIN EN 204):	without hardener: DIN EN 204 D3 with 5 % hardener: DIN EN 204 D4
pH-value:	approx. 3
Glued joint:	elastic, transparent, tool-friendly, resistant to ageing
Open time:	max. 10 minutes at room temperature (+23 °C)
Shelf life:	12 months

Should you need support or advice, please consult our advisory service for craftsmen on 0211/797-6700.

The above information, in particular recommendations for the handling and use of our products, is based on our professional knowledge and experience. As materials and conditions may vary with each intended application and thus are beyond our sphere of influence, we strongly recommend that in each case sufficient tests are conducted to check the suitability of our products for the intended application method and use. Legal liability cannot be accepted on the basis of the contents of this technical data sheet or any verbal advice given unless there is evidence of wilful intent or gross negligence on our part.

This technical data sheet supersedes all previous editions relevant to this product.

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