

Adhesive Bonding of SWISSCDF with:	Syncoll® 102.76 / 102.83	Jowacoll® 103.10 / 103.30	Jowacoll® 119.60	Jowatherm® 280.50	Jowat® 444.00	Jowatherm- Reaktant® 607.60/61	Jowapur® 685.17 / 685.32	Jowapur® 685.33	Jowat-PowerPUR® 687.40	Jowapur® 688.30 / 688.60	Jowat® 2K SE 690.00 / 690.20	Jowat® 696.31	Jowat® 950.21 / 40
Synthetic resin panels HPL	●	●			●		●	●	●	●	●	●	●
Wood veneer	●	●			●			●	●	●			●
Solid wood	●	●			●				●	●	●	●	
PE coated SWISSCDF-panels			○				●		●		●		
Aluminium									●	●	●	●	
Galvanized steel sheet	●				●				●	●	●	●	
Ceramic tiles							●					●	
SWISSCDF surface	●	●					●	●	●	●	●	●	
SWISSCDF joints							●	○	○		●		
Synthetic resin edges (HPL, ABS)				●		●	●					●	
PVC-coating		(x.30)			○				●	●	●		

Bonding	Adhesive	Base	Processing data	Remarks
Coating of synthetic resin panels on SWISSCDF	Jowat® 444.00	Contact adhesive CR	Evaporate time: ca. 10 min. Pressing temp.: 15 - 25 °C Pressing time: some sec.	Apply contact adhesive on both sides
	Jowacoll® 103.10 / 103.30	PVAc-dispersion	Open time: 5 - 8 min. Pressing temp.: 20 - 90 °C Pressing time: 30 - 1.5 min.	Waterproof (complied DIN EN 204 D3)
	Jowapur® 685.33 / Jowat-PowerPUR® 687.40	1C PUR	Open time: 35 - 40 min. Pressing temp.: 20 °C Pressing time: 60 - 120 min.	Cooking water proof (DIN EN 204 D4) - recommended use of Jowat® separating agent (901.10)
Veneer of SWISSCDF	Jowacoll® 103.30	PVAc-dispersion	Open time: 5 - 8 min. Pressing temp.: 20 - 90 °C Pressing time: 30 - 1.5 min.	Waterproof (complied DIN EN 204 D3)
Metal bonding with SWISSCDF	Jowat® 690.00 Jowat® 690.20	2C SE-polymer	Processing temp.: 15 - 25 °C Processing time.: 8 - 30 min.	
Universal	Jowat-PowerPUR® 687.40	1C PUR	Open time: 30 - 40 min. Pressing temp.: 20 °C Pressing time: 105 - 120 min.	Cooking water proof (DIN EN 204 D4) - recommended use of Jowat® separating agent (901.10)
Butt bonding with SWISSCDF	Jowapur® 685.17 / 685.32	1C PUR paste	Open time: 14 - 32 min. Pressing temp.: 20 - 40 °C Pressing time: 80 - 15 min.	Cooking water proof (DIN EN 204 D4) - recommended use of Jowat® separating agent (901.10)
Surface bonding with SWISSCDF	Jowat-PowerPUR® 687.40	1C PUR	Open time: 30 - 40 min. Pressing temp.: 20 °C Pressing time: 105 - 120 min.	Cooking water proof (DIN EN 204 D4) - recommended use of Jowat® separating agent (901.10)
Edge with SWISSCDF	Jowatherm® 280.50 Jowatherm® 607.60	EVA hot melt PUR hot melt	Processing temp.: 140 - 200 °C	Pre-treat panel edges with Jowat® Primer 23 409.15

Remark: Please refer to our technical data sheets, which are available in our Webshop (shop.jowat.ch)

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Recommended adhesives for SWISSCDF

Application	Adhesive type	
Bonding with high pressure laminates (CPL/HPL)	Placol 4506	Powder adhesive for veneer for hot gluing starting from +50°C, heat resistance >+150°C, moisture resistance according to EN 204-D3, formaldehyde emissions E1
	Mirapur 9520 Standard	Reactive liquid PUR adhesive with long open time. Water resistance according to EN 204-D4, heat resistance >+150°C
	Mirapur 9696 2K-PUR	Easy-to-spread 2C pasty adhesive. Heat resistance: 7N/mm ² (EN 14257, WATT91). Water resistance: EN 204-D4
Bonding with metal	Mirapur 9696 2K-PUR	Easy-to-spread 2C pasty adhesive. Heat resistance: 7N/mm ² (EN 14257, WATT91). Water resistance: EN 204-D4
Veneering	Placol 4506	Powder adhesive for veneer for hot gluing starting from +50°C, heat resistance >+150°C, moisture resistance according to EN 204-D3, formaldehyde emission E1
Joints (SWISSCDF butt joint onto SWISSCDF surfaces)	Mirapur 9520 Standard	Reactive liquid PUR adhesive with long open time. Water resistance according to EN 204-D4, heat resistance >+150°C
	Mirapur 9521 Standard	Strong reactive PUR adhesive with long open time. Water resistance according to EN 204-D4, heat resistance >+150°C
	Mirapur 9522 Rapid	Strong reactive PUR adhesive with short pressing time. Water resistance according to EN 204-D4, heat resistance >+125°C
Surfaces (SWISSCDF onto SWISSCDF)	Mirapur 9515 Rapid	Reactive liquid PUR adhesive with short pressing. Water resistance according to EN 204-D4, heat resistance >+70°C
	Mirapur 9520 Standard	Reactive liquid PUR adhesive with long open time. Water resistance according to EN 204-D4, heat resistance >+150°C
	Mirapur 9696 2K-PUR	Easy-to-spread 2C pasty adhesive. Heat resistance: 7N/mm ² (EN 14257, WATT91) Water resistance: EN 204-D4
Butt joint - PVC edges (with hotmelt glue)	Miratherm 5107 natural / Miratherm 5108 white	Granula hotmelt EVA adhesive for butt joints, heat resistance +90°C approx., processing temperature between +180°C and +200°C
	Miratherm 5187 transparent / Miratherm 5188 white	Filler-free granular EVA adhesive for joints, heat resistance +90°C approx., processing temperature between +180°C and +200°C
	Miratherm 5139 natural / Miratherm 5137 white	Solid or granular EVA hotmelt PUR adhesive for butt joints, heat resistance +150°C approx., processing temperature between +120°C and +140°C

Recommendations

Adhesive processing specifications are illustrated in our data sheets (ligamenta.ch)

Refer to the data sheets and recommendations of SWISSCDF suppliers.

SWISSCDF must be taken to room temperature before bonding, so that wood moisture matches the moisture level in the final destination. Compared to conventional wood-based panels, SWISSCDF requires much longer pressing time, due to higher moisture levels and slower water absorption. Pressing time shall be doubled at least, as specified in the data sheets. After pressing, allow to rest for a suitable period (min. 24h). In any case, it is recommended to carry out your own tests to identify suitable pressing time and resting time until the subsequent operation.

Adhesive information represent the state of the art and are based on the practical experience. When new materials are used, it is necessary to carry out bonding tests. Our recommendations shall be considered as general directives. Refer to the processing methods described in the adhesive and primer data sheet, available for download from ligamenta.ch. Our technical consulting service is ready to support you to select the most suitable adhesive.

Recommended adhesives for SWISSCDF

Application	Product	Type	Properties / Destination	Processing specifications
Bonding with laminate * HPL 1,3 mm	Collano FL 330	1C dispersion	Universal PVAc joints and veneering, water resistance D3	Applied quantity 100–200 g/m ²
				Open time at 20 °C 8–10 min.
				Pressing time at 20 °C > 90 min. Pressing time at 60 °C > 15 min.
	Collano DW 2040	1C dispersion	Water and heat resistant wood adhesive (D3, Watt 91) with Collano HR 910 hardener, resistance class D4	Applied quantity 100–200 g/m ²
				Open time at 20 °C 8–12 min.
				Pressing time at 20 °C > 90 min. Pressing time at 60 °C > 15 min.
Bonding with aluminum * EN AW 505, 1,5 mm, P100 sanding, clean	Collano DW 2040	1C dispersion	Water and heat resistant wood adhesive (D3, Watt 91) with Collano HR 910 hardener, resistance class D4	Applied quantity 100–200 g/m ²
				Open time at 20 °C 8–12 min.
				Pressing time at 20 °C > 90 min. Pressing time at 60 °C > 10 min.
Veneer * Oak 0.6 mm	Collano FL 330	1C dispersion	Universal PVAc for joints and veneering, water resistance D3	Applied quantity 100–200 g/m ²
				Open time at 20 °C 8–10 min.
				Pressing time at 20 °C > 30 min. Pressing time at 60 °C > 10 min.
	Sempadur P 8	Powder urea	Powder adhesive for veneer, low formaldehyde emissions, ideal for E1 bonding	Applied quantity 120–160 g/m ²
				Open time 10–15 min.
				Pressing temperature > 80 °C Pressing time > 10 min.
Matched SWISSCDF	Semparoc I 12 NV	1C PUR	PUR adhesive	Applied quantity 100–200 g/m ²
				Open time at 20 °C 10–15 min.
				Pressing time > 90 min.
Mounting	Collano BM 866	1C Silan	High Tack - High-resistance adhesive with excellent grip	Bead width 5–10 mm
				Bead distance 10–12 cm
				Filming time 10–15 Min.
				Crosslinking speed 2–3 mm/24 h
Edges * ABS plastic	Collano KE 540/541	Hotmelt EVA	To glue edges of solid wood, veneer, PVC, ABS, polyester and melamine resin	Processing temperature 200–240 °C

* Material description and finishing

Recommendations

The range of adhesives and applications are indicative. Collano offers a number of products for the materials listed in the tabel.

Gluing surface must be flat, clean and dry. To spread out adhesive properly, we recommend using Collano putties. Our technical consultants are available to select and commission adhesive application equipment.

The values in the table refer to tests in standard climate conditions with 20°C temperature and 65% relative humidity, for the described materials and applications. Therefore, deviations from the data sheet may occur.

Data and values are based on Collano's experience. However, materials and processing conditions can affect adhesive behavior and are not subject to our control, therefore the company declines any responsibility and recommends to execute practical tests. For applications and materials other than those included in the table, please contact our technical consultants. Detailed product information can be found in the corresponding data sheet.

Data sheets: www.collano.com

Recommendation for edge treatments

For SWISSCDF with Rubio Monocoat Oil Plus 2C A

Description

Rubio Monocoat Oil Plus 2C A or Oil Plus 2C A+B is the newest state-of-the-art product for both painting and protecting your wood with a single coating. The bonding of the molecules of natural oil and wood fibres creates a particularly high resistance against liquids and household chemicals and increases abrasion resistance. The combination of wood protection oil (A) and accelerator (B) ensures quick drying.

Specific characteristics:

- 0% VOC, solvent-free
- Low consumption - 1 litre covers 30 to 50 m²
- Simple, completely smooth application at the first attempt
- Simple cleaning; can be applied to virtually all types of wood as well as to veneers and MDF, HDF and CDF
- Long-lasting
- Heat-resistant up to 100 °C
- Quick hard-drying

Technical characteristics

RMC Oil Plus 2C (A):

- Physical condition at 20 °C: liquid
- Colour: light yellow
- Odour: natural oil
- Flash point: > 99 °C

RMC Accelerator (B):

- Physical condition at 20 °C: liquid
- Colour: transparent
- Flash point: > 160 °C (closed)

Instructions for use

1. For treating the edges, they need to be dry and free from dust and grease. If necessary, remove remaining dust with RMC Cleaner.
2. As soon as the cleaned edges are dry, apply a small amount of **RMC Oil Plus 2C A** with a sponge or a cotton cloth (shake oil thoroughly).
- 2a. If you use component B (accelerator), carefully mix components A and B with a ratio of 3 to 1 for about 1-2 minutes.
3. Leave on for some minutes. Remove excessive oil with a cotton cloth within 15 minutes.
4. Remove liquid oil residues on the coated surface with a cotton cloth immediately.
5. The oil is 80 % dry after 24-36 hours and the product is then ready for use.

After 5 days (Oil Plus 2C A+B) or 14 days (Oil Plus 2C A) of crystallisation, the surface is capable of bearing the full load. Protect against intense moisture for the first days.

Dried oil on the coated surface

- Dried oil residues on the coated surface can be removed with the **RMC Oil Remover**.
- Apply the **RMC Oil Remover** with a cotton cloth or a sponge, leave on for a few minutes, then remove the oil stain. Repeat, if necessary.
- Refrain from excessive pressure to avoid shiny spots or abrasions.



CAUTION

Rubio Monocoat must not be diluted!
Cloths impregnated with the product are self-flammable and must be neutralised in water after use.

For further information visit www.rubiomonocoat.com