



LINKBOND III

SELF-CROSSLINKING D3 PVA

12 May 2015

YOUR SMART ADVANTAGES

- Superior heat resistance
- Excellent water resistance
- Extremely fast grab and bond strength development
- Low viscosity suits all application methods
- Non flammable
- Non toxic.
- Responds well to RF heating
- Meets European exposure group BS EN 204 (D3)
- High solids content

USES

- Wood
- Paper
- Leather
- Cardboard
- HPL flat lamination and post forming

PRODUCT CHARACTERISTICS

Colour	White, dries clear
Viscosity	Thick liquid
Composition	Crosslinking PVA
Solids content	Approx. 50%
Application temperature	10 to 30°C
Open time	7 - 10 minutes
Full cure	High strength after 24 hours, final bond strength can take up to 7 days
Coverage	75 to 100 g/m ² (gsm)
Product codes	
4kg Jerry can/4 per carton	30804040
21kg Jerry can/24 per pallet	30804041
210KG plastic drum/4 per pallet	30804042
1100kg IBC	30804103

TYPICAL PERFORMANCE DATA (APPROX)

Shear strength (Jarrah)	Approx. 100Kg/cm ²
Water resistance BS EN 204	D3

DIRECTIONS FOR USE

It is recommended that this product is fully evaluated as suitable for the application methods to be employed and for suitability of performance both initially and for the expected life of your product under the condition it is expected to withstand.

A controlled temperature environment will aid consistent application. Best performance is seen at 20°C, although 15°C is also acceptable.

SURFACE PREPARATION

Ensure all surfaces are clean and dry. The timber must be dried to its equilibrium moisture levels (about 10 - 14%).

APPLICATION

- Linkbond III can be used with a Hot press, RF cure, and standard Cold press set ups.
- Stir well before use.
- Apply using a powered roll glue spreader or air assisted/ airless spray equipment.
- **Wood to wood bonding** (assembly): Apply Linkbond III at 100 to 200 gsm. Normal application is adhesive applied to both sides of the timber to be bonded.
- Bring both surfaces together while the adhesive is still wet or tacky. Apply even pressure to ensure a good bond.
- Immediately wipe off excess using a damp cloth.
- When bonding soft woods (pine), clamp lightly immediately after bonding for a minimum of 30 minutes.
- When bonding hard woods (Rimu), clamp lightly immediately after bonding for a minimum of 1 hour.
- **Veneer bonding:** Apply approximately 100 gsm to one side and press at high pressure, at 70°C for 1 minute.
- Alternatively apply approximately 75 gsm to one side and press at high pressure, at 100°C for 80 seconds.
- Pressing pressures can range from 40 to 115Psi (3 - 8kg/m²).
- Adhesion starts to build as soon as the glue line starts to dry out.
- Heat cured bonds are more resistant to water than cold cured but all the requirements of D3 are passed after drying at 20°C for 7 days.

LIMITATIONS

- Not suitable for polyethylene, polypropylene or Teflon.
- LINKBOND III is a CLOSE CONTACT adhesive. This means it gives best bonds on tight fitting joints. It will not adhere well if the joints are of wide tolerance.

CLEANING

Clean with damp cloth immediately after use.
Wash hands with soap and water.
Dried adhesive is best removed by scraping or sanding.

STORAGE AND SHELF LIFE

Store in cool, dry conditions out of direct sunlight below 25°C. Protect from frost and freezing. Shelf life is 12 months if stored in cool, dry conditions in original, unopened containers. The product is chemically reactive and therefore containers must be kept filled or skinning will result which can ruin good product.

DISPOSAL

Empty containers, once dry, may be disposed of via local landfill.
If spilt, absorb product with clay, sand or earth. Collect in properly labelled metal containers. Dispose of according to local authority regulations. Do not dispose of down drains or into waterways. Fully dried material is not hazardous.

PRECAUTIONS IN USE

Complete details on each of the products mentioned are available on the product Safety Data Sheets. To ensure no harm is caused to persons using Bostik products, it is recommended that all concerned read the appropriate Safety Data Sheets. Visit www.bostik.co.nz for copies.

FIRST AID

- Swallowed:** Do not induce vomiting, give a glass of water and contact a doctor immediately.
- Skin:** Remove contaminated clothing, wash with warm soapy water. Cooking oil may aid removal. Do not scrub.
- Inhaled:** Remove person to fresh air. Get medical advice if breathing becomes difficult. If inhaled to excess, remove from contaminated area – apply artificial respiration if not breathing.
- Eyes:** Hold open and flood gently with water for at least 15 minutes. Get medical advice.

For emergency information contact the National Poisons Information Centre, phone 0800 764 766 (0800 POISON) or CHEMCALL, phone 0800 243 622.



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