

Product Information

Adhesive E390

The system is developed to have an extremely fast pressing time in applications like general assembly and solid wood lamination.

Product Specification

E390		
Product	PVAc adhesive	
Delivery Form	Liquid	
Colour	Grey	
Viscosity (at time of production)	10 000 - 20 000 mPas (Brookfield LVT, sp. 4, 6 rpm, 25°C / 77°F)	
Density	Appr. 1150 kg/m ³	
Dry Content	55 - 58%	
pH (at time of production)	4,0 - 7,0 (at 25°C / 77°F)	
Storage Life (months from time of production)	20°C/68°F	30°C/86°F
	12	6
Storage Condition	<p>Recommended storage temperature; 15°C to 20°C / 59°F to 68°F. Only short term exposure to temp below 5°C / 41°F or above 30°C / 86°F is allowed.</p> <p>Frozen and thawed product cannot be used due to irreversible reactions in the product.</p> <p>The product can form a skin on the surface if the container is not properly closed. The products shall always be stored in closed packaging.</p>	
Formaldehyde Info	Contains no formaldehyde, the system fulfils F****	
Glue Line Properties	<p>Light coloured glue lines.</p> <p>High degree of heat, creep resistance.</p> <p>Gives elastic glue lines.</p> <p>EN204 Class D1</p>	
Approvals	This system is classified as F**** with the JAIA registration number 007109 (Japan Adhesives Industry Association).	
Discolouration	The product does not discolor the wood. However, iron which might come from the glue spreader can together with the tannic acids in some wood species, especially oak, give a discolouration.	

Contact Information

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www.woodadhesives.akzonobel.com

Version: 01 (2022-12-28)

Reason for changes: New

Gluing Operation Information

Applications	Edge Glued Panels Solid wood lamination Doors Veneering Foliating Board on Frame	
Press Type	Cold Press High Frequency Hot Press Clamp Carrier Continuous Press	
Glue line temperature	10°C to 70°C / 50°F to 158°F	
Press Time, 20°C / 68°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	5 min	
Press Time, 30°C / 86°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	--	
Pressure	0,1 - 1,0 MPa	
Assembly Time, 20°C / 68°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	Open: 4 min	Closed: 5 min
Assembly Time, 30°C / 86°F (pine-pine, 65% RH, 150 g/m ² , 15 g/ft ²)	Open: 1,5 min	Closed: 2 min
Glue Spread	Solid wood lamination: 150 - 250 g/m ² , 15 - 25 g/ft ² Edge glued panels: 120 - 150 g/m ² , 12 - 15 g/ft ² Veneering: 90 - 150 g/m ² , 9 - 15 g/ft ² Board on frame: 120 - 180 g/m ² , 12 - 18 g/ft ² Block gluing: 60 - 200 g/m ² , 6 - 20 g/ft ² .	
	While gluing hard and oily wood species the material should be newly planed and the adhesive should be spread on both surfaces to be glued.	
Moisture content of wood	5 - 14%, preferably 7 - 10%.	
Preparation of wood	For best result the wood must be smoothly planed. For optimum bond strength the bonding operation shall take place within 24 hours after preparation.	
Temperature of wood	In order to meet the given press times the temperature of the wood must not be below 20°C / 68°F.	
Gluing of impregnated wood	Can in most cases be used but must be evaluated in each case.	

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Post curing	Can be processed further after 2-6 hours, but best result is achieved if samples are left 24 hours
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Machinery

Applicator	Toothed trowel Brush Hand roller 6231- Ribbon spreader Roller spreaders may be ordered through our technical representative
Mixer	N/A, 1 component system
Accessories	N/A

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Handling and HSE info

Handling	Always use gloves and goggles when handling the product.
Cleaning	Use lukewarm water for glue on skin and machinery. Cleaning should start before the system dries.
Waste handling - of the products	Normally not to be considered as hazardous waste. Leave residues to dry before sending it off for disposal. For 2 component systems the hardener may be considered as hazardous waste, check the SDS (section 13). NOTE! There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.
Waste water treatment - of the waste water	<u>Chemical precipitation → drain*</u> Please contact Environmental Advisor at the Environmental Department for further information regarding chemical precipitation. * municipal sewage with biological treatment For more info, see General Information. NOTE! There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.
Health and Safety	For more information, see respective SDS.

Legal clause

The information is based on laboratory tests and practical experience. It is introductory and intended to help the user find the most suitable method of working. Since the user's production conditions are beyond our control, we cannot be held responsible for the results of the work which is affected by local circumstances. In each particular case testing and continuous control are recommended.

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