



Product code : 086301

EMFIBOIS 863

D3 classified according to EN 204 standard

DESCRIPTION

EMFIBOIS 863 is a fast, ready-to-use wood adhesive, based on vinyl aqueous dispersion. The joint formed after drying is colorless transparent.

Wood to wood bonding performed with EMFIBOIS 863 present an excellent cold-water resistance (D3 classification according to EN 204 standard).



AREAS OF APPLICATIONS

EMFIBOIS 863 is mainly intended for bonding doors, windows and laminated panels, for the manufacturing of partitions and sandwich panels.

Thanks to its high bond strength, EMFIBOIS 863 allows the bonding of hard and exotic woods for stairs manufacturing.

EMFIBOIS 863 is also suitable for surface bonding (veneer).

TECHNICAL DATA

Color	White (after drying: colorless transparent)
Viscosity	Brookfield RVT 6 / 20rpm: 12 000 \pm 3 000 mPa.s
Density at 20°C	Approx. 1.10
pH	Approx. 3
White point	Approx. +5°C
Application temperature	10 to 30°C
Cold resistance	Down to -30°C
Open time at 20°C	6 to 10 min *
Pressing time (for information purposes, for a 10% wood moisture)	<p>At 20°C:</p> <ul style="list-style-type: none">- Joints bonding: min. 15 min- Surfaces bonding (laminated panels): 15 to 20 min <p>At 50°C:</p> <ul style="list-style-type: none">- Joints bonding (preheated): min. 5 min- Surfaces bonding (laminated panels): approx. 5 min <p>At 80°C:</p> <ul style="list-style-type: none">- Joints bonding: min. 2 min- Surfaces bonding: 1 to 2 min
Pressing	0,7 to 1 N/mm ² for glulam or laminates bonding
Final setting time at 20°C	7 days
Cleaner	Water before drying

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* this time depends on hygrometry (wood and air) and ambient temperature, but also application quantity and absorbability of the substrates.

INSTRUCTIONS FOR USE

Substrates preparation:

The woods to be bonded must be clean, dry, dust free and not have any traces of grease or other contaminants that could harm bonding.

It is recommended to plan or sand the parts to be bonded. Clean them again after sanding.

Bonding:

EMFIBOIS 863 is generally to apply single-sided with a brush, a notched spatula or with a roller.

Automated application systems such as frame presses, dove-tailing machines or automatic spreading machines can also be used, provided that they are made of stainless steel or plastic.

For the bonding of hard or exotic woods, it is recommended to apply EMFIBOIS 863 double-sided.

Distribute evenly over the entire surface, assemble as soon as possible and press, with a pressure of 7 to 10 daN / cm².

Pressure and pressing time depend on the nature of the substrates, their moisture content, temperature and applied quantity of adhesive. The pressing time is at least 15 minutes at 20°C.

Final bonding strength is obtained after approximately 7 days.

Cleaning:

Tools, overflows or stains of fresh adhesive can be cleaned with water. After drying, abrasion is necessary.

LIMITATIONS

In order to obtain optimal bonding, moisture content from woods should be from 8 to 10% for indoor use and from 10 to 14% for outdoor use.

Temperature of adhesive and substrates must be between 10 and 30°C, preferably between 18 and 20°C.

Do not work below 10°C.

Colorations of the joint (or alteration of its color) are likely to appear with certain wood species (beech, cherry, maple), as well as with woods containing tannin (oak).

CONSUMPTION

100 to 200 g/m² depending on application method and materials to be bonded:

- 100 to 130 g/m² for surface bonding (veneer)
- 150 to 200 g/m² for solid wood

STORAGE AND SHELF LIFE

12 months in closed original packaging stored at a temperature between 10 and 25°C.

Not frost sensitive (resistance down to -30°C). Before use, gradually bring to room temperature and stir well.

PACKAGING

500 g plastic bottles.

5 and 25 kg plastic buckets.

Contact us for other packaging options.

SAFETY

Read material safety data sheet before use.

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