



Product code : 086301

EMFIBOIS 863

Water resistant according to standard
EN 204-D3
Water resistant according to standard
EN 204-D4 with hardener

DESCRIPTION

EMFIBOIS 863 is a polyvinyl acetate water-based adhesive.
EMFIBOIS 863 is cold water resistant according to standard EN 204-D3 and hot water resistant with 5 % HARDENER DA according to standard EN 204-D4.

AREAS OF APPLICATION

EMFIBOIS 863 is a fast, highly water resistant wood adhesive providing a clear film.

TECHNICAL DATA

Colour	White (film : transparent colourless* / light yellowish with hardener)
Viscosity	Brookfield RVT / spindle 6 / 20 rpm : 13,000 ± 3,000 mPa.s
Density at 20 °C	Ca 1.10
pH	Ca 3
White point	Ca 5 °C
Cold resistance	Down to -30 °C
Open time at 20 °C	6 to 10 min
Final setting at 20 °C	7 d
Cleaner	Water before drying
Specific data	Pressing time without hardener : minimum 15 min at 20 °C Pressing time with hardener : minimum 25 min at 20 °C Pot life with 5 % HARDENER DA : 24 h

*colouring may happen with some woods, especially with woods containing tannin (eg oak)

ADVICE

See material safety data sheet of each component used.



INSTRUCTIONS FOR USE

Substrates preparation :

The substrates to be assembled must be dry, dust free and not have any traces of grease or other contaminants that could adversely affect the bonding performance.

If necessary, rub down surfaces beforehand.

Wood humidity should be between 8 and 12 % for optimal bonding.

The temperature of adhesive and materials must be between 10 and 30 °C, preferentially between 18 and 20 °C.

Application :

If used with hardener, mix carefully until homogenization.

Apply an even layer with a notched spreader, a brush or a roller.

Tools must be in stainless steel or in plastic matter (brush handles may also be of wood).
A layer on one of both surfaces is usually sufficient.
For hard or exotic woods, a layer on both surfaces is recommended.
Assemble as soon as possible and clamp with a pressure between 7 and 10 daN/cm².
Pressure and pressing time depend on type of wood, moisture, temperature and coating weight.

Cleaning :

Wet excess adhesive, smudges and tools can be cleaned with water.

CONSUMPTION

Veneer : 100 to 130 g/m²
Massive wood : 150 to 200 g/m²

STORAGE AND SHELF LIFE

12 months in closed original packaging stored between - 30 and 25 °C

PACKAGING

750 g bottles
5 and 25 kg plastic buckets

SAFETY

EMFIBOIS 863 is not classified as hazardous.
HARDENER DA (code number D0008A) is irritating.
Read material safety data sheets before use.

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