

## Propellerleim Super W-IW

Art.-No.: A 1138

### Application area:

Propellerleim Super W-IW is a special development for window- and window scantling construction. This glue meets the quality level according to DIN EN 204/D 3 as a one-component glue. Can be used together with hardener I (hardener addition 5 %). After the hardener was added, the glue achieves standard D 4. Tested according to WATT 91 with excellent tear strength (>7 N / mm<sup>2</sup> at 80° C). For professional use.

### Advantages:

Even without addition of the hardener, the system has a high resistance to thermal distortion. After the hardener was added, the pot-life is about 4-8 hours even though – the system sets very fast. Thanks to the long pot-life, an efficient processing is possible and cleaning becomes easy.

### Recommended conditions of use:

Application amount	: ca. 120 - 150 g/m <sup>2</sup> , depending on type of wood
Processing	: Cold- and hot application by hand or machine
Processing temperature	: 15 - 20 °C
Wood moisture	: 10 - 12 %
Press pressure	: 2 - 5 kp/cm <sup>2</sup>
Open time	: 5 - 8 minutes (depending on room temperature)
Illuminant	: 4 - 5 °C

### Press times: (guidelines without addition of hardener)

Time in minutes	cold gluing		hot gluing	
	ca. 20 °C	40 °C	70 °C	80 °C
Joint gluing	8 - 18	7	5	4
Veneering	8 - 18	7	4	3
Face gluing (DKS-boards)	15 - 20	7 - 10	5 - 7	3

### Further processing:

Cold gluing	: after 30 - 60 minutes
Hot gluing	: after cooling

### Processing hint:

The indicated press and setting times are only approximate. The final strength will be achieved after 7 days according to DIN. We recommend conducting your own test series. Prior to adding hardener please check hardener for flawless condition. Hardener must be dissolved without deposit. Alternatively the hardener can be pre-diluted (water addition max. 50% with hardener) to ensure that the mixing works well. The mixture of glue and hardener cannot be stored in closed containers. The mixture can cause a foam formation. Thereby the special reactivity of the hardener can be shown and no disadvantage of the adhesion occurs.

### Frost resistance:

One time freezing is possible up to -30°C. After defrosting, usually ready for use after well stirring!

**Problems with discoloration:**

Rhenocoll cold wood glues do usually not show any discolorations. But, due to different wood ingredients (e.g. tannic acid, resin), reactions cannot be fully excluded. These reactions may lead to color changes on the wood. Wood discolorations may also result from lacquers and wood glue. That is why we always recommend a preliminary test.

**Storage:**

12 months, protect from frost. Do not bring into contact with iron.

**Danger class:**

none

**Labeling:**

Does not require labeling according to the regulation for hazardous working materials.

**Supply units:**

12 kg pail  
32 kg hobbock  
150kg barrel  
1000kg container

**Service:**

Our service team for application technology is available to you at any time without obligation.

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