

## Product Information

### Adhesive system - LignuPro® Zero A201/H201

Mix-in system with long pot life



H201 is a medium fast mix-in hardener with long pot life to be used with our amino adhesive LignuPro® Zero A201.

The system has low tool wear and can be used in hot presses and in high frequency presses.

### Product Specification

	LignuPro® Zero Adhesive A201			Hardener H201	
<b>Product</b>	Amino adhesive			Mix-in hardener	
<b>Delivery Form</b>	Liquid			Liquid	
<b>Colour</b>	White			Light grey	
<b>Viscosity</b> (at time of production)	1500 - 4000 mPas (Brookfield LVT sp3, 12 rpm at 25°C/77°F)			2000 - 10000 mPas (Brookfield LVT sp3, 12 rpm at 25°C/77°F)	
<b>Density</b>	Appr. 1300 kg/m <sup>3</sup>			Appr. 1230 kg/m <sup>3</sup>	
<b>pH</b> (at time of production)	8.0 – 10 (at 25°C / 77°F)			2.0 – 5.0 (at 25°C / 77°F)	
<b>Storage Life</b> (months from time of production)	<b>15°C/68°F</b>	<b>20°C/68°F</b>	<b>30°C/86°F</b>	<b>20°C/68°F</b>	<b>30°C/86°F</b>
	2.5	2.5	0.5	4	2
<b>Storage Condition</b>	Recommended storage temperature 15°C to 20°C / 59°F to 68°F. Only short term exposure to temp above 30°C / 86°F is acceptable. The product cannot be frozen. During storage the glue will mature and the viscosity can increase.			Recommended storage temperature 15°C to 25°C / 59°F to 77°F. Only short term exposure to temp above 30°C / 86°F is acceptable. The product can be frozen but it must be thawed, raised to room temperature and homogenized before usage. The product can form a skin on the surface if the container is not properly closed.	

#### Contact Information

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[www.akzonobel.com/adhesives](http://www.akzonobel.com/adhesives)

**Version:** 03 (2018-01-23)

**Reason for changes:** Changes in product specification.

## Gluing Operation Information

<b>Applications</b>	Flooring			
<b>Press Type</b>	High Frequency Hot Press			
<b>Glue Line Temperature</b>	Not below 70°C / 122°F			
<b>Press Time</b> (For mixing ratio 100:20)		<b>70°C/158°F</b>	<b>90°C/194°F</b>	<b>110°C/230°F</b>
	<b>0.6 mm</b>	6'00"	2'30"	1'00"
	<b>3.6 mm</b>	-	5'00"	4'00"
	<b>6.0 mm</b>	-	-	-
<b>Pot Life</b> For mixing ratio:	<b>15°C/59°F</b>	<b>20°C/68°F</b>	<b>30°C/86°F</b>	
		100:15 4h 100:20 2h 50 min		
<b>Pressure</b>	Not below 0,3 MPa			
<b>Assembly Time</b> (120 g/m <sup>2</sup> /12 g/ft <sup>2</sup> , 20°C/68°F)	Open: <10 min		Closed: <10 min	
<b>Mixing Ratio</b> (by weight)	100:15 – 100:25, adhesive: hardener			
<b>Glue Spread</b>	Flooring: 90 - 175 g/m <sup>2</sup> , 9-17 g/ft <sup>2</sup>			
<b>Moisture content of wood</b>	Preferable 5 - 9%.			
<b>Preparation of wood</b>	For best result the wood must be smoothly planed. For optimum bond strength the bonding operation shall take place within 24 hours after preparation.			
<b>Temperature of wood</b>	In order to meet the given press times the temperature of the wood must not be below 20°C / 68°F.			
<b>Post curing</b>	Needs no after curing time, can be processed directly after pressing.			

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## Machinery

<b>Applicator</b>	7230- Eco Flex Separate ribbon spreader
<b>Mixer</b>	6201- Mixing system for UF, PRF, MUF 6203- Mixing system for UF, PRF, MUF 6204- Mixing system for EPI
<b>Accessories</b>	6282- Control unit 6284- Tank monitoring system 6289- Day tanks

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## Handling and HSE info

<b>Handling</b>	Always use gloves and goggles when handling the product.
<b>Cleaning</b>	Glue on skin should be washed with soap and water. For the equipment, use lukewarm water with addition of Glue wash 4450 or Washing agent 2704 (for more info see General Info). Cleaning must start before the system cures.
<b>Waste handling - of the products</b>	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).  <b>NOTE!</b> There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.
<b>Waste water treatment - of the waste water</b>	Chemical precipitation → drain* Biological treatment → drain* Mechanical precipitation → drain* * municipal sewage with biological treatment  <b>For more info, see General Information.</b>  <b>NOTE!</b> There might be national and/or local regulatory differences, therefore always keep a dialogue with the local authorities.
<b>Health and Safety</b>	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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