

## Special Characteristics

High bond strength  
 Water-resistant bonding  
 Heat resistance tested to Watt 91>7N/mm<sup>2</sup>  
 Transparent glue joint  
 Resistant to ageing  
 Almost unlimited use, even for critical wood types

## Technical Data

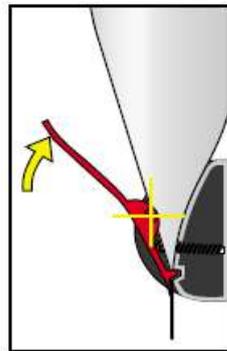
**pH value:** approx. 3  
**Bond strength:** Ponal Super 3 complies with DIN EN 204, class D3  
**Density (spec. gravity):** Ponal Super 3: approx. 1.1 g/cm<sup>3</sup>  
**Adhesive joint:** elastic, gently treating of tools, resistant to ageing, colourless  
**Application temperature:** not less than +5°C  
**Consumption:** approx. 150 g/m<sup>2</sup> depending on absorbency of ground  
**Open time:** max. 12 minutes at room temperature (+20°C)



Available with nozzle-set DS 20



**NEW**



## Ponal Adhesive Filling Station Super 3

Sturdy tool for professional use. ABS-reinforced for dispensing Ponal Super 3 adhesive from 5 kg bags (PN 4 SB). For filling Ponal Super 3 adhesive bottles and manual adhesive rollers.

## Notes on Application

### Material preparation

The surfaces to be bonded should be prepared for fitting and clean. If necessary, clean special types of wood (e.g. teak) with standard-type solvents such as acetone. The moisture content of the wood should be between 8 and 12%.

### Adhesive application

Apply Ponal Super 3 with brush, plastic glue comb (Ponal comb), manual roller or adhesive-application machine. Do not use tools containing iron (risk of discolouration)

### Open time

The application time depends on the ambient temperature, the air humidity, the moisture content of the wood and the quantity of the adhesive applied. At an ambient temperature of 20°C, the maximum open time is 12 minutes. Join the parts while the adhesive is still wet.

### Storage

Store Ponal Super 3 tightly closed in a dry environment. Do not expose it to sub-zero temperatures. Adhesive which has thickened through cold should be thawed at room temperature and then stirred vigorously to attain its original quality.

### Pressure force

Dependent on structure, shape and thickness of material. Minimum force: 0.2 N/mm<sup>2</sup>, for assembly and hardwood bonding, 0.3 - 0.7 N/mm<sup>2</sup>.

### Pressing time

Dependant on temperature, type and moisture content of wood and quantity of adhesive applied. Under normal conditions, the minimum pressing times are as follows:

1. Wood  
 Approx. 25 - 30 minutes at +10°C  
 Approx. 15 - 20 minutes at +20°C

2. HPL board  
 Approx. 40 minutes at +20°C  
 Approx. 25 minutes at +40°C  
 Approx. 15 minutes at +60°C

If warm pressing is being used, do not continue processing the work pieces until they have cooled.