

**ADBOND 3022-2LV**  
Type II water-based adhesive for finger jointing**DESCRIPTION**

ADBOND 3022-2LV is a pre-catalysed resin adhesive. It was developed for high-quality woodworking. This cross-linking adhesive was designed to give strong, permanent bonds on substrates such as Masonite, wood, MDF, corrugated cardboard, particleboard, mineral-based fire insulation, laminates, etc. ADBOND 3022-2LV is also design for hollow core doors or solid doors.

ADBOND 3022-2LV meets the following bond specifications:

- F04 L75 CFR (indirect contact with food)
- CSA B13.8 M3870 Type II
- BS EN 204: 1992 Class D3
- DIN 68602 Class B1

ADBOND 3022-2LV does not contain urea formaldehyde.

**PHYSICAL PROPERTIES**

Color	Must. W. White Dry. W. Transparent
Viscosity	6000-6500 cP@
pH	7.5 - 8.5
Specific gravity	1.09 g/cm <sup>3</sup>
Solub	18.5 - 20%
Frost stability	Good
Shelf life	3 months
Minimum setting temperature*	80°F (27°C)
COV	1.6%

\*For best results ideal temperature should be from 70°F to 80°F (21°C to 27°C).

**APPLICATION**

ADBOND 3022-2LV can be applied with squeeze bottle, roller, pneumatic gun or mechanical roller coater. For roller coater application, apply 3-4 mil wet film thickness. Typical assembly time should be between 20 to 25 minutes (maximum 30 minutes) depending on temperature and adhesive film thickness. Assembly should be pressed from 20 to 30 minutes. Depending on component type use in assemblies, machining steps can be achieved 200 after press release. Press time can be reduced to 120 seconds with usage of a hot press at a temperature of 320°F (160°C).