

Type PVAc

Product description **ProFect® 2417** is a 1-component water based PVAc dispersion adhesive for industrial wood production. *It is Rosenheim certified for water resistance durability class D4 according to EN204/205 as well as for heat resistance according to WATT91. (Test is ongoing)*

Area of use **ProFect® 2417** is suitable for almost all types of laminating and jointing, especially for finger jointing, where transparent joints and D4 water resistance are required. With a view to interior use, **ProFect® 2417** is recommended for glue joints which must tolerate fluctuations in temperature and humidity like the atmosphere in kitchen and bathroom.

ProFect® 2417 can be used for products of exterior use, but only if the glue-lines are protected against exposure to the weather, for example by paint, etc.

ProFect® 2417 can be used to bond certain metals, such as aluminium and iron to wood.

Technical data

Adhesive:	
Colour:	White
Viscosity:	4.000 – 6.000 mPas
Dry content:	47 – 49%
Density:	1,01 – 1,12 kg/L
Minimum film forming temperature	6 °C
pH	2,5 – 3,5
Glue Joint:	
Colour:	Transparent
Water resistance class	D4, EN 204/205
Temperature resistance	>7 N/mm ² , WATT91
Tool wear:	Very low

Processing

Wood moisture	6 – 15 %	
Coat weight,	100 – 250 g/m²*	
Working temperature	6 – 45°C	
Pressure*		
- Side pressure	8 – 10 kg/cm² Soft wood 13 – 15 kg/cm² hard wood	
- Top pressure	1 – 1,2 kg/cm²	
Assembly time	8 – 10 minutes*	
If assembly time is “closed”, it can be increased 1 – 2 minutes.		
Assembly time is increased with two sided application, hard wood, lower temperature and higher humidity of air and wood.		
Assembly time is reduced at higher temperatures and lower humidity of air and wood.		
Pressing time*:		
	Lamella size 15 mm	Lamella size 43 mm
20°C	6 min	12 min
40°C	5 min	9 min
60°C	3 min	7 min

**Guidelines. Sufficient tests should be carried out to establish final working conditions.*

Pressing time should be increased for hard woods, two sided application, higher humidity of the air and higher moisture content of the wood. Pressing times can be reduced by e.g. pre-heating of the wood.

Full water resistance is usually obtained after 7 days.

The product is ready-to-use. But can be diluted with water.

Treatment: Joints, which are exposed to the weather, should always be treated with an efficiently covering surface treatment.

Version: RHN/02/2025

DANA LIM A/S | Københavnsvej 220 | DK-4600 Køge | Tlf. +45 56 64 00 70 | Industry@danalim.dk



Cleaning

Uncured adhesive can be removed with water. Cured adhesive can only be removed mechanically.

Storage

The shelf life of **ProFect® 2417** is 6 months when it is stored at 10°C - 22°C in the closed original container. Protect from frost.

Packaging

Please contact the sales department in order to obtain further information.

Disclaimer

The instructions and data included in the actual product data sheet are to provide information concerning the application and selection of our products. Therefore we do not provide any guarantee and shall not be held liable for any damages resulting from the use of our products, including any discolouring, influences etc. We strongly recommend the users to conduct the necessary tests prior to initiating production, in order to determine the usability of a particular product for a given purpose. This should be conducted in accordance to the user's manufacturing guidelines. When assessing the usability of a product please consider the type of material, condition and age/lifetime of the material, as should the tests be repeated when the materials and/or production conditions change, also when the material provider changes.