Technical Datasheet

AkzoNobel

Adhesive system 1711/2622

Version: 07 (2024-07-01)

PRF system for laminated beams and finger joints in load bearing timber structures

Adhesive system 1711 with 2622 can also be used in door production, lamination, finger jointing and other applications in the woodworking industry, where there is demand for high water and weather resistance of the joints. Even at lower temperatures short pressing times are reached when hardener 2622 is used.

Hardener 2622 consists of two parts, 2622A and 2622B. Both are powders which should be mixed first, and then mixed into the adhesive.

Product Specification

	Adhesive 1711	Hardener 2622A	Hardener 2622B
Product Type	PRF Adhesive	Hardener	Hardener
Delivery Form	Liquid	Powder	Powder
Color	Red brown	White	Light brown
Viscosity at time of production	3000 - 8000 mPa·s , Brookfield LVT , sp. 4 , 12 rpm , 25ºC/77ºF		
pH at time of production	7.0 - 9.0, 25ºC/77ºF		
Dry Content	53.0 - 56.0 %	Max: 100 %	Max: 100 %
Density (average)	Appr. 1150 kg/m³	Appr. 500 kg/m³	
Density (interval)			480 - 560kg/m³

Glue Line Properties

High water and weather resistance. Bonded wood constructions will pass JAS MAFF 1587 class A.

Formaldehyde Info

The system fulfills F****

Approvals Note

Adhesive 1711 with hardener 2622 is approved by Norsk Treteknisk Institutt (NTI), Norway, Materialprüfungsanstalt Universität Stuttgart – Otto-Graf-Institut (MPA), Germany and SKH/KOMO (DHBC 32389), Holland for the production of load-bearing timber structures.

1711 with hardener 2622 is approved by NTI for use in glulam production according to JAS 1587, exposure classes A, B and C.

1711 with hardener 2622 fulfils the requirements according EN 301 for glue type I for service classes 1, 2, 3 in EN 386 as well as the requirements in DIN 68141 for the production of load-bearing timber structures according DIN 1052.

Contact Information

Stockholm, Sweden +46 8 743 40 00
Amata, Vietnam +84 8 844 5743
High Point, USA +1 336 841 5111
Medellin, Colombia +57 4 3618888

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Storage Conditions and Storage Life

	Adhesive 1711	Hardener 2622A	Hardener 2622B
Storage Life 20°C/68°F, from time of production	12 months	36 months	24 months
Recommended Storage Temperature	Min: 10°C / 50°F Max: 20°C / 68°F	Max: 30°C / 86°F	Max: 30°C / 86°F
Short Term Temperature Exposure	Only short time exposure to temperatures above 30°C / 86°F is acceptable.		
Storage Conditions Info	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. The product shall always be stored in closed packaging.	The product is sensitive to moisture and should be stored in a sealed container.	The product is sensitive to moisture and should be stored in a sealed container.

Processing Instructions

Applications
Duo- and triobeams, Building products, Exterior doors, Fingerjointed solid timber, I-beams/I-joist, Laminated beams curved, Laminated beams straight, Solid wood lamination

Press Type
Cold Press, Continuous Press, Hot Press

Processing Instructions
Mixing instructions for hardener 2622: Premix 2622A: 2622B hardeners in ratio 56:44 by weight.

In a well ventilated area, mix hardener 2622 part A and B, according to mixing ratio above. Then mix adhesive with hardener mixture. Please take care and follow SDS for the respective component. 2622A is paraformaldehyde which should be handled carefully, and not be put in contact with skin, or inhalated. Always use gloves and safety glasses, and preferably breathing masks.

For gluing use a hand or a roller applicator for spreading the adhesive.

Mixing Ratio

	Adhesive 1711	Hardener 2622A	Hardener 2622B
Mixing ratio per weight	100	8.4	6.6

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Pot Life

Mixing Ratio	10°C/50°F	15°C/59°F	20°C/68°F	30°C/86°F
100:15	4 h 30 min	2 h	1 h 15 min	20 min

Assembly Time

Conditions	100:15, 400 g/m²
Closed, 20°C	≤ 40 min

Pressing

Glue Line Temperature Min: 20 °C , 68 °F

Pressing Time

At mixing ratio 100:15 the following pressing times are recommended:
Glue joint temperature 10°C / 50°F: 20 hours
Glue joint temperature 15°C / 59°F: 8 hours
Glue joint temperature 20°C / 68°F: 4 hours
Glue joint temperature 30°C / 86°F: 2 hours

Pressure
Minimum 0,5 MPa for softwood.
Minimum 1,0 MPa for hardwood.

In laminated beam production:
Minimum 0,7 MPa for 33 mm lamellas.
Minimum 0,9 MPa for 45 mm lamellas.

Preparation of Material

Moisture Content of Wood 8 - 15% , Preferably 10 - 12%

Temperature of wood In order to meet the given press times the temperature of the wood must not be below 20°C / 68°F.

Preparation of Material For best result the wood must be smoothly planed. For optimum bond strength the bonding operation shall take place within 24 hours after preparation.

Post Curing

1 day at 20°C / 68°F.

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Handling and Environmental Information

Handling
Avoid direct contact with the products. Always wear protective gloves and protective goggles.
In case of skin contact, clean the affected skin area immediately with soap and lukewarm water.

Cleaning
For cleaning of equipment and tools, use lukewarm water.
Cleaning must start before the system cures. Cured adhesive must be removed mechanically.

Waste Handling
Adhesive: Classified as hazardous waste (contains free phenol and resorcinol).
Hardener: Depending on classification the hardener may be considered as hazardous waste, check the SDS (section 13).
Adhesive/hardener mixture: Can normally be treated as non-hazardous waste when fully cured.
Attention! National and/or regional differences in regulations may prevail. Please contact the responsible authorities.

Waste Water Treatment
Regarding incineration of waste and pollution prevention, please refer to Directive 2010/75/EU .

Health And Safety
The Safety Data Sheet provides information regarding health and safety. Study this information carefully.

The information is based on laboratory tests and practical experience. It is a guideline 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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