



EOC GROUP Adhesive Division has a very wide range of **high-quality industrial adhesives** based on synthetic and natural polymers specially developed to meet customer expectations.

Thanks to the constant level of quality of the products and the reputable service, EOC Group Adhesive Division has enjoyed a spectacular growth resulting in **several production sites worldwide** coordinated from headquarters in Belgium.

EOC Group Adhesive Division continuously works to improve quality and service to give an **economical and technical advantage** to its customers.

EOC Group Adhesive Division has developed a wide range of **wood glues for lamination applications**.

WOOD GLUES

Classification EN-204

Classification of thermoplastic wood glues according to their water resistance (EN 204)		
Stress Class	Requirements	Required bond strength
D1	D1-1 storage 7 days at standard ambient conditions*	> 10 N/mm ²
D2	D2-1 storage 7 days at standard ambient conditions* D2-2 storage 7 days at standard ambient conditions* storage of test specimen in cold water (ca. 20°C) for 3 hours storage 7 days at standard ambient conditions*	> 10 N/mm ² > 8 N/mm ²
D3	D3-1 storage 7 days at standard ambient conditions* D3-3 storage 7 days at standard ambient conditions* storage of test specimen in cold water (ca. 20°C) for 4 days D3-4 storage 7 days at standard ambient conditions* storage of test specimen in cold water (ca. 20°C) for 4 days storage 7 days at ambient conditions*	> 10 N/mm ² > 2 N/mm ² > 8 N/mm ²
D4	D4-1 storage 7 days at standard ambient conditions* D4-3 storage 7 days at standard ambient conditions* storage of test specimen in cold water (ca. 20°C) for 4 days D4-5 storage 7 days at ambient conditions* storage of test specimen in boiling water (ca. 20°C) for 6 hours storage of test specimen in cold water (ca.20°C) for 2 hours	> 10 N/mm ² > 4 N/mm ² >4 N/mm ²

*standard ambient conditions: 23°C/50% rel. humidity (or 20°C, 65 % rel. humidity)



Technical Overview

Product name	Classification	Solids%	pH	Viscosity (5/20 @23°C)	Certificate
Euroflex 620700	EN-204 D2 Requirements	46-50	4,0-6,0	6000-10000	Yes
Euroflex 620900	EN-204 D2 Requirements	48-52	4,0-6,0	12000-16000	Yes
Euroflex 621000	EN-204 D2 Requirements	47-51	4,0-6,0	8000-12000	Yes
Euroflex 795000	EN-204 D2 Requirements	48-52	4,0-6,0	10000-15000	Yes
Euroflex 760000	EN-204 D3 Requirements	49-51	3,5-5,0	8000-15000	Yes
Euroflex 764300	EN-204 D3 Requirements	41-45	2,5-4,0	2500-3500	Yes
Euroflex 764500	EN-204 D3 Requirements	44-46	2,5-5,0	15000-25000	Yes
Euroflex 764600	EN-204 D3 Requirements	43-47	2,5-5,0	8000-15000	Yes
Euroflex 765000	EN-204 D3 Requirements	49-51	3,5-5,0	8000-15000	Yes
Euroflex 765100	EN-204 D3 Requirements	49-51	3,5-5,0	14000-20000	on request
Euroflex 765500	EN-204 D3 Requirements	53-56	3,5-5,0	8000-12000	Yes
Euroflex 765600	EN-204 D3 Requirements	48-52	2,5-5,0	7000-12000	Yes
Euroflex 775600	EN-204 D3 Requirements	48-52	2,5-5,0	7000-12000	Yes
Euroflex 780000	EN-204 D4 Requirements	46-50	2,8-3,2	3000-9000	Yes

Wood Glue – EN-204 D4 requirements

Our Euroflex 780000 is a one component EN-204 **D4** wood glue.

Our EN-204 **D3** wood glues can meet EN-204 **D4** class requirement (very high water resistance) by adding 5% di-isocyanate hardener.

The hardener can be ordered as well (ca. 50 kg per 1 IBC). |