



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 WORKING ADHESIVES

Classification EN 204/205

Classification of thermoplastic wood glues according to their water resistance (EN 204/205)		
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 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 mPa.s (@23°C)	Certificate
Euroflex 6207	EN 204/205 D2 Requirements	43-49	4,0-6,0	7000-14000 (5/20)	Yes
Euroflex 6209	EN 204/205 D2 Requirements	46-52	4,0-6,0	7000-14000 (5/20)	Yes
Euroflex 7950	EN 204/205 D2 Requirements	47-53	4,0-6,0	7000-14000 (5/20)	Yes
Euroflex 7630	EN 204/205 D3 Requirements	46-52	2,5-5,0	6000-14000 (5/20)	Yes
Euroflex 7645	EN 204/205 D3 Requirements	43-49	2,5-5,0	6000-14000 (5/20)	Yes
Euroflex 7756	EN 204/205 D3 Requirements	47-53	2,5-5,0	6000-12000 (5/20)	Yes
Euroflex 7856	EN 204/205 D4 Requirements	44-50	2,5-5,0	4000-10000 (4/20)	Yes
Euroflex 6559	Foil lamination	66-70	6,0-7,5	7500-8500 (4/20)	NAP
Euroflex 6201	Doweling Adhesive – Low pressure application	33-39	4,0-6,0	200-300 (2/20)	NAP
Euroflex 6202	Doweling Adhesive – Low pressure application	37-43	4,0-6,0	900-1000 (2/20)	NAP
Euroflex 6207	Doweling Adhesive – High pressure application	43-49	4,0-6,0	7000-14000 (5/20)	NAP

All our wood working adhesives are **formaldehyde free**

Wood Glue – EN 204/205 D4 requirements

Our Euroflex 7856 is a one component EN 204/205 **D4** wood glue.

Our EN 204/205 **D3** wood glues can meet EN 204/205 **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).

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