



Excellence is our Passion

PT. Henkel Adhesive Technologies

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**IMMERSION TEST
(JAS Revised 2003)**

Report code : STR
Date : December 29, 2016

Test Specimen : Face Gluing , Flooring
Glue : Aquence SL 8463 ID + Aquence Catalyst 72-7357 M
Test number : 322/AWL/53/16
Tested by :

Wiji utomo
WW Technician

Checked by :

Farid Bahtiar
Senior PD TCS – AIC

Entries : *Immersion test,*
Face gluing

**Sampling is not carried out by
This certificate refers to the tested sample only**



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1. Execution of the test

Preparation of test specimen

Pieces of test specimens, measuring 75.0 mm in length with their end cross sectional dimensions left as they are.

Method of testing

- Immersed in room temperature water for 6 hour
- Dried at $40 \pm 3^{\circ}\text{C}$ in thermostat drier at least for 18 hours

Additional Treatment

- Store at -10°C in the freezer at least for 3 hours
- Dried at 60°C in thermostat drier at least for 3 hours
- Dried at 70°C in thermostat drier at least for 3 hours


Standard Requirement

Maximum delamination should be not more than 10 %

$$\text{Ratio of delamination (\%)} = \frac{\text{Total length of delamination on both ends}}{\text{Total length of glue line on both ends}} \times 100$$

2. Result of the test


Oak wood to Plywood core

Method of Testing	IMMERSION TEST				
Test Specimen Code	1	2	3	4	5
Total glue line(mm)	140	140	140	140	140
Total delamination(mm)	10	6	0	4	0
Delamination (%)	7.1	4.3	0	2.8	0
Average	2.8 %				
Judgment	Passed				
	ADDITIONAL TREATMENT				
Oven 60°C for 3 hours	No changed	No changed	No changed	No changed	No changed
Oven 70°C for 3 hours	No changed	No changed	No changed	No changed	No changed
Note	NO DELAMINATION OCCURRED AFTER GETTING ADDITIONAL TREATMENTS				
Figure of specimen after treatment					



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Oak wood to Gemelina wood core

Method of Testing	IMMERSION TEST		
Test Specimen Code	1	2	3
Total glue line(mm)	46	46	46
Total delamination(mm)	0	1	2
Delamination (%)	0	2.2	0
Average	0.7 %		
Judgment	Passed		
	ADDITIONAL TREATMENT		
Oven 60 °C for 3 hours	No changed	No changed	No changed
Oven 70 °C for 3 hours	No changed	No changed	No changed
Note	NO DELAMINATION OCCURRED AFTER GETTING ADDITIONAL TREATMENTS		
Figure of specimen after treatment			

3. Remark

Overall performance of the specimen in good condition and Passed of Immersion Test & Additional treatment