



# D4 WOOD GLUE

## Premium Water Resistant D4 Wood Adhesive

### Technical Data Sheet



### GLUES & ADHESIVES RANGE

CLASS  
EN204 D4

#### Description:

*A ready to use, industrial grade PVA timber adhesive which is suitable for use in damp and humid conditions. Gives a high strength, water, impact and temperature resistant bond that is usually stronger than the wood itself. Provides the user with a waterproof D4 grade wood adhesive with none of the safety issues associated with conventional diisocyanate containing (polyurethane) D4 grades.*

#### Features & Benefits:

- ◆ Solvent-free and diisocyanate-free - safer to use.
- ◆ Suitable for areas under constant water immersion.
- ◆ Short press time, fast setting.
- ◆ It is possible to process wood species like pine or spruce with pressing times of minimum 12 minutes.
- ◆ Improved adhesion on difficult wood species (eg. oak, larch).
- ◆ Low timber staining characteristics; no discolouration of the glue line due to the influence of process heat (eg. HF-press).
- ◆ Improved heat and water resistance when using high process temperatures (eg. +70°C).
- ◆ For internal and external use.
- ◆ Conforms to EN204 D4.

#### Uses

This is a universal system and is applicable for furniture production, parquet flooring, window frames, window scantling, door manufacturing and solid wood bonding.

As a general woodworking/ joinery adhesive. General assembly line work. Radio Frequency/ HF cure systems, wood on wood laminating, and household DIY use.

#### Limitations

- Ensure wood doesn't contain excessive moisture (<10%)
- Not suitable for load bearing applications.
- Do not use at temperatures below +10°C.
- Clean excess adhesive off glue line after clamping before adhesive dries with a damp cloth.
- Before staining any wood sand off any excess adhesive.
- Ensure sufficient clamping pressure, especially important with radio frequency bonding.
- Use on Laminates: Only suitable for bonding small porous laminate strips. Do not use on non-porous or large areas of laminate. Use CONTACT ADHESIVE or CONTACT ADHESIVE SF.



- Because of the varied nature of wood components, e.g. area of growth, type of pre-treatment etc, unpredictable discolouration may occur on different types of wood such as cherry, beech and others. In certain oaks, iron and tannin can also give this effect. We recommend you test compatibility before carrying out large scale manufacture. Ensure adhesive has fully dried before water exposure (approx. 1 week).

#### Preparation

Surfaces to be bonded must be clean, dry and free from dust, grease or contaminants that may hinder adhesion. Mis-machined parts may require longer setting times and could produce a weaker bond. Note: drying time is extended at low temperatures and high humidity.

#### Application

Apply this adhesive thinly and evenly to one side or, if a high degree of water resistance is required, to both sides, using a spreading machine, glue roller, serrated trowel, glue brush and another suitable device. Do not over apply as this will slow down cure. Clamp surfaces together until adhesive dries. (off in <1 hour: full strength 8 hours). Support until fully cured (8 hours at +20°C). Ensure product is fully dried before water exposure (approx. 1 week). When fitting dowels, the adhesive should be applied to the holes. Best results will be achieved when room, material and adhesive temperature is between +18 to +20°C.

#### Minimum Pressing Times

- Assembly gluing: 8 to 15 min.
- Short cycle press at +70°C: approx. 60 sec.
- Boards and block gluing: 15 to 30 min.
- Window scantlings, depending on type of wood:
  - Softwood (eg. spruce): from 15 min.
  - Hardwood (eg. oak, beech): approx. 2 hours.

#### Cleaning

Clean any excess or tools after use with warm soapy water.

## Coverage

Surface bonding 70-150g/m<sup>2</sup> (1L will cover 6m<sup>2</sup>-14m<sup>2</sup>).  
Assembly bonding 150-180g/m<sup>2</sup> (1L will cover 6m<sup>2</sup>-7m<sup>2</sup>).

## Size

1L plastic bottle.

## Colour

Off white liquid.

## Shelf Life

Minimum 9 months from date of manufacture when stored in original, unopened bottles

## Storage Conditions

Store in well sealed containers to avoid evaporation of water and the formation of skin on the surface of the product. The emulsion must be stored at a temperature between +15 to +23°C. Do not allow to freeze. Higher temperatures will affect quality and cause the formation of crusts and skins, especially if the containers are not tightly closed or subjected to direct sunlight for long periods.

## Disposal of Containers

Do not leave empty containers where residue could be harmful to children, animals or the environment. Replace lids and remove any containers to a central disposal point in accordance with local regulations. Any spilt material should be mopped up immediately with an inert absorbent material, such as sand.

## Health & Safety

Please refer to separate safety data sheet (SDS) for full handling, use and storage instructions. Keep out of reach of children. It is the user's responsibility to determine suitability for use. If in doubt, contact our Technical Department for advice.

**Note: this information is for general guidance only, since site conditions and labour are beyond our control.**

## Approvals/ Standards

Conforms to the international standards EN 204 (D4) and WATT 91. Independent test certification is available on request.

## Specification Summary

Chemical Composition	PVA dispersion
Colour	Off white (dries clear)
Application Temperature	+18°C to +20°C for best results
pH	3.5
Open Time @ 150g/m <sup>2</sup>	Approx. 10 mins
Chalk Point	Approx. +8°C
Press pressure for stress free workpieces	0.1 - 0.5 N/mm <sup>2</sup>
Viscosity @ +20°C Brookfield HB spindle 2 20 rpm	Approx. 5,500 mPa.s
Density	ca. 1.07g/cm <sup>3</sup>
Solid Content	ca. 45%
Solubility in Water	Miscible
Commodity Code	3214900000

## Product / Order Details

Code	Colour	Size	Barcode	UFI
BDA018	White	1L	5056437400864	-



## Part of the Bond It Glues & Adhesives Range

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**Note:** The data presented in this leaflet is in accordance with the present state of our knowledge, but does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies raw materials are also being used. The recommendations do not absolve the user from the obligation of investigating the possibility of infringement of third parties rights and, if necessary clarifying the position. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the products for a particular purpose.



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