



Never compromise on quality!



# D4 WOOD GLUE

## Premium Water Resistant D4 Wood Adhesive



### GLUES & ADHESIVES RANGE

#### Description:

*A ready to use, solvent-free industrial grade PVA timber adhesive which is suitable for use in damp and humid conditions, inside and out, and gives a high strength, water, impact and temperature resistant bond that is usually stronger than the wood itself.*

#### Benefits:

- ♦ *Excellent water resistance, suitable for water immersion.*
- ♦ *Fast setting.*
- ♦ *Short press time.*
- ♦ *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).*

Provides the user with a waterproof D4 grade wood adhesive with none of the safety issues associated with conventional isocyanate containing (polyurethane) D4 grades.

#### 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.

#### 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 - 20°C.

#### Minimum Pressing Times

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

#### 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.
- 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.

#### 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>).

#### Container Size

1L plastic bottle.



**Colour**  
Off-white liquid.

**Shelf Life**  
9 months from date of manufacture when stored in 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 15-23°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 material safety data sheet for full handling, use and storage instructions. Keep out of reach of children. It is the users 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. It is recommended that users make their own tests to determine suitability.*

**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)
pH	3.5
Open Time @ 150g/m²	Approx. 10 mins
Chalk Point	Approx. 8°C
Press pressure for stress free workpieces	0.1 - 0.5 N/mm²
Viscosity @ 20°C Brookfield HB spindle 2 20 rpm	Approx. 5,500 mPas
Density	ca. 1.07g/cm³
Solid Content	ca. 45%
Solubility in Water	Miscible

Product Details:

Colour:	White
Code:	BDA018
Size:	1L
Barcode:	5056437400864

The data presented in this leaflet are in accordance with the present state of our knowledge, but do 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.



Part of the Bond It Glues & Adhesives Range

Certificate Number: 6152  
ISO 9001; ISO 14001;  
ISO 45001



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**bond it**  
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