

# PRODUCT DATA SHEET

## EVERBUILD® D4 Wood Adhesive

AN INDUSTRIAL GRADE D4 WOOD ADHESIVE BASED ON HYBRID RESIN TECHNOLOGY

### PRODUCT DESCRIPTION

EVERBUILD® D4 Wood Adhesive is an industrial grade D4 wood adhesive based on the latest hybrid resin technology. EVERBUILD® D4 Wood Adhesive provides the user with a waterproof D4 grade wood adhesive with none of the safety issues associated with conventional isocyanate containing (polyurethane) D4 grades.

EVERBUILD® D4 Wood Adhesive can be used internally and externally and gives a high strength, water, impact and temperature resistant bond that is usually stronger than the wood itself.

### USES

- As a general woodworking/joinery adhesive.
- General assembly line work.
- RF/HF cure systems, wood on wood laminating, furniture assembly and household DIY use.
- Interior/exterior use.

### CHARACTERISTICS / ADVANTAGES

- Excellent rate of bond strength development.
- D4 water resistance, suitable for constant water immersion.
- Low timber staining characteristics.
- Water based - environmentally friendly/easy clean up.
- Suitable for radio frequency cure.

|                                            |                |
|--------------------------------------------|----------------|
| Viscosity @ 23°C                           | 5000 - 6000 cP |
| pH                                         | ca. 3.5        |
| Chalk point (°C)                           | Approx 8       |
| High Temperature Stability (1 week @ 50°C) | Stable         |

### APPROVALS / STANDARDS

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

### PRODUCT INFORMATION

|                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
|--------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Chemical Base      | Hybrid resin                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
| Packaging          | 1L bottle and 25L plastic container                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |
| Colour             | White (dries clear)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |
| Shelf Life         | 6 months from date of manufacture in original unopened containers.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| Storage Conditions | To ensure safe storage of product, containers should be well sealed to prevent evaporation of water and the formation of skin on the surface. The emulsion must be stored at a temperature above freezing. A temperature of 15-23°C for not more than six months is recommended. 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.<br>If these conditions cannot be met, please refer to our Technical Service Department who will advise on storage stability. |

Density 1.07 g/cm<sup>3</sup>

Solid content by weight 40 – 48%

## APPLICATION INFORMATION

Yield 150-180g/m<sup>2</sup> (assembly gluing)

Open Time 8 – 9 mins @ 20° and 150g/m<sup>2</sup>

## APPLICATION INSTRUCTIONS

### SUBSTRATE PREPARATION

All surfaces must be clean, dry and free from grease.

### APPLICATION METHOD / TOOLS

Apply adhesive thinly to both surfaces. 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). When fitting dowels, the adhesive should be applied to the holes.

## LIMITATIONS

- Ensure wood doesn't contain excessive moisture (<15%)
- Not suitable for load bearing applications.
- Do not use at temperatures below 10°C.
- Note: drying time is extended at low temperatures.
- Clean excess adhesive off glue line after clamping before adhesive dries with a damp cloth.
- Sand off any excess adhesive before staining the wood.
- 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.

## VALUE BASE

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for the exact product data and uses.

## ECOLOGY, HEALTH AND SAFETY

Consult MSDS for full list of hazards.

## LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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