



**CHARACTERISTICS**

- White wood glue
- Transparent when dry
- One-component glue on the base of polyvinyl acetate
- Exceptional adhesion strength
- High water resistance. The water and temperature resistance can be raised by using high process temperature (e.g. +70°C).
- The adhesive conforms to the D4 standard according to DIN/EN 204-D4 and to EN14257 (Watt '91)

**APPLICATIONS**

- Bonding of wooden constructions such as window frames...
- Excellent for the bonding of (tropical) wood, paper, cardboard and other porous materials.
- Bonding of difficult wood types, such as larch and oak.

TECHNICAL CHARACTERISTICS	
Basis	Polyvinyl acetate dispersion
Colour	White - after drying: transparent
pH	± 3
Temperature of the glue, environment and material	Ideal between 18°C - 20°C
Moisture content of wood	8 - 10%
Application quantity for assembling gluing	150 - 180 g/m <sup>2</sup>
Open time (at 23°C and 50% R.H.)	±10 min.
Pressing time	Assembly gluing: 8 - 15 min. Boards and block gluing: 20 - 40 min. Window frames soft wood: From 15 min. onwards Window frames hard wood : +/- 2 hours
Press pressure	Stress free work pieces : 0,1 - 0,5 N/mm <sup>2</sup> Soft wood : 0,1 - 0,3 N/mm <sup>2</sup> Hard wood : 0,5 - 0,8 N/mm <sup>2</sup>
Viscosity (Brookfield spindle 2, 20 RPM)	3.500 mPa.s
Temperature resistance	-20°C - +70°C
Shelf life, in the original packing in dry conditions at room temperature (between + 10°C - + 30°C)	6 months

PACKING
12 squeeze bottles of 750 g/box - 40 boxes/pallet
Bucket 5 kg - 60 buckets/pallet
Bucket 10 kg - 33 buckets/pallet: Not available in stock - available upon request
Bucket 25 kg - 12 buckets/pallet: Not available in stock - available upon request

**METHOD OF USE**

**Preparation**

All parts should mate well and must be free from dust and grease. If the parts do not fit, the setting time will be longer and the bond strength will be lower. The joints should be processed shortly before bonding. It is recommended that adhesion tests be carried out to determine the suitability of the product for its application. When in doubt, contact our technical support service.

This technical data sheet replaces all previous editions. The data on this sheet have been compiled according to the last laboratory report. Technical characteristics can be changed or adapted. We are not responsible for any incomplete information. Before use, one needs to ensure that the product is suitable for his application. Therefore, tests are necessary. Our general conditions apply.

## Application

- The glue must be stirred well before use. Apply thinly and evenly to one side (150-180 g/m<sup>2</sup>). If a high degree of water resistance is required, apply the glue to both sides, using a spreading machine, glue roller, serrated trowel, glue brush or another suitable device.
- Lay the items to be bonded together within 8 to 9 minutes and press them for as long as needed to achieve the required initial firmness upon release. The open time and setting time depend strongly on working conditions such as temperature, humidity, absorbency of the materials being worked.
- In order to obtain a good result, please take into account the technical characteristics:

## Cleaning

Clean machines and tools with water before the adhesive dries.

## WOOD DISCOLORATION

Because of the varied nature of wood components, unpredictable discoloration may in some cases appear on different types of wood, such as beech or cherry. In addition, it is possible that iron together with the tannin in the wood can cause discoloration, especially in the case of oak. We recommend to carry out preliminary tests.

## SAFETY

Safety data sheet available on request.

## TECHNICAL APPROVALS



\* Information sur le niveau d'émission de substances volatiles dans l'air intérieur, présentant un risque de toxicité par inhalation, sur une échelle de classe allant de A+ (très faibles émissions) à C (fortes émissions).

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