

# Timbond D4 Waterproof PVA



 **Waterproof to EN204 D4**

 **Premium wood adhesive**

 **Fast setting**

## Benefits

- Easy to apply
- Suitable for use with RF equipment, both cold and hot pressing
- Conforms to the D4 requirements of EN204

## Typical applications:

- Woodworking applications
- High quality joinery
- Doors
- Windows
- Bonding high pressure decorative laminates and timber veneers
- Finger jointing, edge to edge gluing, solid wood bonding, doweling and high (radio) frequency applications

**NB. Not suitable for the production of permanently stressed joints.**

**Timbond D4 PVA is a specially formulated cross linking single component PVA adhesive.**

It is used for bonding the most commonly used types of timber for external use or where very high water resistance is required. It is certified to EN204 Group D4 and it is tested according to WATT 91 and reaches a high thermal resistance  $>7\text{N/mm}^2$  to standard EN14257. Ideal for all general woodworking assembly and joinery use, including laminations on MDF and other particleboard substrates. Can be used for in both hot and cold presses.

## Directions for use

### Surface preparation

- Substrates to be bonded should be clean, dry and free from grease and dust. For laminations, surfaces should be flat.
- Avoid thick adhesive lines.
- Wood should condition for several days in the factory before bonding (15-20°C). The relative humidity of the wood should be approx. 10-20%.

## Application

- For general assembly applications, both surfaces should be coated.
- For laminations, apply an even coat of adhesive to one substrate by roller coater, brush or spatula.
- Bring the parts to be bonded together immediately after application whilst the adhesive is still wet. Open time depends on the substrate porosity, ambient temperature and coating weight.

## Pressure

Wood on wood	2-5 bar (kgf/cm <sup>2</sup> )
Laminates on wood	1-2 bar (kgf/cm <sup>2</sup> )

## Pressing Times

Wood on wood at 20°C	10-15 mins
Assemblies with one face preheated	2-3 mins
Laminates on wood at 20°C	15-20mins
Laminates on wood at 80°C	3-4 mins

## Stabilisation

Before machining	2 hours (minimum)
Complete setting of adhesive	at least 24 hours
D4 waterproof	at least 1 week

After assembly pressure should be maintained during the adhesive's initial setting period, using conventional pressing methods such as presses, vices, jigs, clamps or dead loads. Refer to the pressure values given above. This is not necessary for finger joints.

Pressing time depends on such variables as ambient temperature and humidity, coating and weight, the porosity of substrates and dimensions of assemblies. Reference values are given above, but a test specimen will allow this to be calculated.

Pressing time can be reduced by heating one substrate to be bonded before pressing at room temperature. We recommend pre-heating of the surface (1-2 minutes at 80°C). Hot pressing should only be recommended for double sided flat lamination.

**Special precautions**

Minimum recommended working temperature is 12°C. Ambient temperature for the warehouse, wood laminates and adhesives should be 18-20°C and the humidity of wooden substrates should be 8-12%. Do not add anything to the adhesive to modify it's properties. Provided contact with iron is avoided, the adhesive should not cause staining. After each use, close the container tightly to avoid skin formation. For health, safety and disposal please refer to the material safety data sheet.

**Storage**

Store in original packaging between 5°C and 30°C. Protect from freezing. Rotate stock using oldest batch first. Keep covered to prevent contamination and drying out. Shelf life - up to six months if stored correctly.

**Packaging**

Available in: 1kg, 5kg, 25kg, 1000kg (IBC).

**Cleaning**

Equipment should be cleaned with warm or cold water while adhesive is still wet and MEK when the adhesive is dry.

**Technical data**

<b>Base</b>	Polyvinyl Acetate	<b>Colour</b>	White
<b>Solids</b>	50 + 2 %	<b>Cleaner</b>	Warm water (while uncured)
<b>Viscosity</b>	5500 + 1500 [mPas]	<b>Shelf Life</b>	6 months - 5-30°C
<b>Specific gravity</b>	1.05g /cm3	<b>Coverage</b>	150grms – 250grms per M2

IMPORTANT NOTICE: This datasheet is for general guidance only and may contain inappropriate information under particular conditions of use. All recommendations and suggestions are therefore made without guarantee. Samples will be provided on request to enable customers to satisfy themselves as to the suitability of the product for any specific purpose and to assess the product under their own working conditions.