

## TYTEX D3 WATER RESISTANT PVA ADHESIVE



### PRODUCT DESCRIPTION.

**Tytex D3 PVA Adhesive is a ready to use, fast setting, single part curing polyvinyl acetate based emulsion. Tytex D3 PVA is a multi-purpose, water resistant adhesive which conforms to the D3 requirements of EN204. It also meets the requirements of BS4071 Part 5, sustained load resistance. Tytex D3 PVA is suitable for general assembly and lamination on particleboard and MDF.**

### DIRECTIONS FOR USE.

Materials to be bonded should be clean, dry and free from dust and grease. For laminations, surfaces should be homogenous and flat. Assemblies should be precise in order to avoid thick adhesive lines (0.2-0.3mm max). Wood should be allowed to condition for several days in the workshop atmosphere (15-20°C) before bonding. It's relative humidity should be approx. 10-20%.

For laminations, apply an even coat of adhesive to one of the substrates by roller coater, brush or spatula.

For assembly applications we recommend that both surfaces should be coated. Coating weight depends on the substrate, porosity, open time and ambient temperature.

The parts to be bonded should be brought together immediately after application whilst the adhesive is still wet. The maximum open time depends on the substrate porosity, ambient temperature and coating weight.

### BENEFITS.



Sets within 10-15 minutes



For interior and exterior use



Bonds stronger than wood

### PRESSING.

#### 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 15-20 mins  
Laminates on Wood at 80°C 3-4 mins

#### Stabilisation:

Before machining 2 hours (minimum)  
Complete setting of adhesive at least 24 hours  
D3 water resistance at least 1 week

### TECHNICAL DATA.

<b>Base</b>	Polyvinyl Acetate	<b>Shelf Life</b>	12 months 5-30°C
<b>Solids</b>	100%	<b>Coverage</b>	
<b>Viscosity at 23%</b>	12000mPas	Flat lamination paper	20-70g/m <sup>2</sup>
<b>Specific Gravity</b>	1.10	Flat lamination, HPL, thick foils	100-200g/m <sup>2</sup>
<b>Colour</b>	White	Panelling/edge jointing	200-350g/m <sup>2</sup>
<b>Tack Life</b>	N/A	Assembly	150-200g/m <sup>2</sup>
<b>Cleaner</b>	Warm water (while uncured)		

## **PRESSING CONTINUED...**

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 its 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.

## **PACKAGING.**

Available in 1kg, 5kg and 25kg.

## **STORAGE.**

Store in original packaging between 5°C and 30°C.

Protect from frost.

After prolonged storage, stir well before use.

Under the above storage conditions, the adhesive has a shelf life of 12 months.