

# PRO WOOD GLUE D4

## Description

Formulated crosslinking emulsion adhesive.

## Appearance

White liquid.

## Technical Characteristics

Brookfield Viscosity  
(Spindle 6, speed 20 rpm)

Solids (1 hour at 105°C)

## Typical Data

14,000 Mpas @ 23°C.

46%

## Typical Applications

- \* Wood to wood in general assembly and joinery applications - hot and cold pressing.

## Typical Properties

### Features

- \* One component.
- \* Fast setting.
- \* High bond strengths.

### Benefits

- \* No need for mixing of catalyst.
- \* Rapid production throughput.
- \* Bond security.

## Application Guide

Temperature of substrates, environment & adhesive	-	15 - 20°C
Moisture content in the wood.	-	8 - 12%
Coat Weight	-	100 - 160 gsm
Glue line pressure	-	2 - 8 kg/cm <sup>2</sup> (dependent on type of wood and stress in the construction).
Open Time	-	Up to 5 minutes.
Closed assembly time	-	Up to 20 minutes.
Press time at 20°C	-	Minimum of 15 minutes (softwood) Minimum of 25 minutes (hardwood).
Radio frequency press time	-	45 seconds to 2 minutes. Cooling time depends on wood & shape of substrate.
Minimum film forming temperature	-	4°C

Full water resistance is not achieved until 7 days after bonding.

## Packaging

Consult local sales office.

## Storage & Handling

Rotate stock using oldest material first.

Keep covered to prevent contamination and drying out.

Do not mix with other adhesives.

Protect from freezing.

Shelf life : For best results use within 6 months from day of delivery.

## HEALTH & SAFETY

**Users should familiarise themselves with the safety data sheet before using or handling this product.**