

TYTEX D4 WATERPROOF PVA ADHESIVE



PRODUCT DESCRIPTION.

Tytex D4 PVA Adhesive is a high quality single component pva wood adhesive. It is a 100% waterproof adhesive. Tytex D4 PVA meets the requirements of BS EN204 D4 testing. Tytex D4 PVA is suitable for external joinery and demanding bonding applications including jointing and laminations.

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. Its 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 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.

PRESSING.

Pressure:

Wood on Wood	2-5 bar (kgf/cm ²)
Laminates on Wood	1-2 bar (kgf/cm ²)

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
D4 water proof	at least 1 week

BENEFITS.

-  Waterproof
-  For exterior use
-  Bonds stronger than wood

TECHNICAL DATA.

Base	Polyvinyl Acetate	Cleaner	Warm water (while uncured)
Solids	49-53%	Shelf Life	12 months 5-30°C
Viscosity at 23%	4500 – 6500cps	Coverage	150grms – 250grms per M ²
Specific Gravity	1.1		
Colour	White		

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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 commend 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.

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.

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