TIMBOND professional

Timbond D3 Water Resistant PVA Adhesive

Timbond D3 PVA is a ready to use, high quality quick setting single part wood adhesive.

A water resistant, multipurpose PVA adhesive which conforms to the EN204 D3 Rating. It meets the requirements of BS4071 Part 5, sustained load resistance. Ideal for all general woodworking assembly and joinery use including laminations on MDF and other particleboard substrates. Timbond D3 is cross linking and can be used with RF equipment and is suitable for both cold and hot pressing (see curing times).

Meets EN204 D3 & BS4071

Bonds wood & veneers

Fast setting

Benefits

- Easy to apply
- Cross linking
- Suitable for use with RF equipment, both cold and hot pressing
- Conforms to the D3 requirements of EN204

Typical applications:

- Woodworking applications
- High quality joinery
- Doors
- Windows
- Bonding high pressure laminates and timber veneers

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/cm2)
Laminates on wood	1-2 bar (kgf/cm2)

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
D3 water resistance	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.

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Strength behind the glue.

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 frost. After prolonged storage, stir well before use. Rotate stock using oldest batch first. Under the above storage conditions, the adhesive has a shelf life of 12 months.

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

Base	Polyvinyl Acetate
Solid content	50 +_ 2 [%]
Viscosity at 23%	13000 +_ 2000 [mPas]
Specific gravity	1.05 g /cm3
Colour	White
Tack life	N/A
Cleaner	Warm water (while uncured)

Shelf Life	12 months 5-30°C
Coverage	
Flat lamination paper	20-70g/m^2
Flat lamination, HPL, thick foils	100-200g/m^2
Panelling/edge jointing	200-350g/m^2
Assembly	150-200g/m^2
Amount of adhesive spread	90 ÷ 180 [g/m^2]

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.