

# WOOD GLUE

Technical data					
Product	Cold Wood Glue D3/D4	Cold Wood Glue D2	Quick Hardening Glue	Veneer Glue	1-Comp. Cold Wood Glue D4
Base	Polyvinyl acetate dispersion	Polyvinyl acetate dispersion	Polyvinyl acetate dispersion	Polyvinyl acetate dispersion	Polyvinyl acetate dispersion
Color	White	White	White	White	White
pH value	approx. 3	approx. 5	approx. 5	approx. 5	approx. 3
Viscosity	approx. 12,000 mPa.s (Brookfield)	approx. 13,000 mPa.s (Brookfield)	approx. 10,500 mPa.s (Brookfield)	9,000 mPa.s (Brookfield)	approx. 7,000 mPa.s (Brookfield)
Density	1.08 g/cm <sup>3</sup>	1.07 g/cm <sup>3</sup>	1.09 g/cm <sup>3</sup>	1.10 g/cm <sup>3</sup>	1.10 g/cm <sup>3</sup>
Solid particle contents	approx. 50%	approx. 50%	approx. 53%	approx. 45 %	approx. 50%
Minimum film-formation temperature (white point)	approx. +6 °C	approx. +6 °C	approx. +7 °C	approx. +5 °C	approx. +7 °C
Temperature resistance after hardening (material-dependent)	80 °C	80 °C	70 °C	80 °C	80 °C
Shelf life (store cool and dry)	12 months	12 months	12 months	12 months	9 months
Pot life	After adding hardener 24 hours at max. +20 °C	-	-	-	-
Ideal application conditions					
Room, material and glue temperature	18 - 20 °C	18 - 20 °C	15 - 20 °C	18 - 20 °C	18 - 20 °C
Wood moisture	8 - 10 % outdoors 13 % ± 2 %	8 - 10 %	8 - 12 %	8 - 12 %	8 - 10 % outdoors 13 % ± 2 %
Relative humidity	60 - 70 %	60 - 70 %	55 %	60 - 70 %	60 - 70 %
Glue application quantity: for surface gluing for assembly gluing	approx. 100-160 g/m <sup>2</sup> approx. 120-180 g/m <sup>2</sup>	approx. 100-160 g/m <sup>2</sup> approx. 120-180 g/m <sup>2</sup>	approx. 120 g/m <sup>2</sup> approx. 150 g/m <sup>2</sup>	approx. 100-300 g/m <sup>2</sup> approx. 120-160 g/m <sup>2</sup>	approx. 100-160 g/m <sup>2</sup> approx. 120-180 g/m <sup>2</sup>
Open time for 150 g/m <sup>2</sup> /+20 °C	approx. 8 - 10 min.	approx. 7 min.	approx. 5 - 10 min.	approx. 10 - 14 min.	approx. 8 - 10 Min.
Pressing pressure, depending on gluing type	0.1 - 0.8 N/mm <sup>2</sup>	0.1 - 0.8 N/mm <sup>2</sup>	0.2 - 0.7 N/mm <sup>2</sup>	0.5 N/mm <sup>2</sup>	0.1 - 0.8 N/mm <sup>2</sup>
Minimum pressing times*					
for assembly gluing at 20 °C	6 - 12 min.	8 - 15 min.	from 12 min.	-	20 - 25 min.
for board and block gluing at 20 °C	from 20 min.	from 20 min.	from 12 min.	-	from 20 min.
for surface gluing at 20 °C at 50 °C at 80 °C	30 - 40 min. 5 - 8 min. 1 - 5 min.	30 - 40 min. 5 - 10 min. 1 - 8 min.	from 15 min. from 10 min. from 5 min. (70 °C)	15 - 20 min. 5 - 10 min. 1 - 5 min.	30 - 40 min. 8 - 10 min. 2 - 8 min.
for veneer gluing at 20 °C at 50 °C at 80 °C	** 20 - 30 min. 5 - 10 min. 1 - 3 min.	15 - 20 min. 5 - 10 min. 1 - 5 min.	5 - 10 min. 3 - 10 min. 1 - 5 min.	10 - 15 min. 5 - 10 min. 1 - 5 min.	** 20 - 30 min. 8 - 10 min. 2 - 8 min.

\* The minimum pressing times are for the application conditions specified above.  
Deviations from the application conditions may decrease or increase the pressing time.

\*\* Due to the low pH, veneer discolorations are possible.