

BIJLARD HOUTLIJM 1KD3 SPRAY®



PRODUCT DESCRIPTION

Water-resistant white PVAc wood glue for indoor and outdoor use, if not exposed to climatic influences. Conforms to NEN-EN 204 D3 standard. Dries transparently.

DIRECTIONS FOR USE

1. Assembly of well-fitting non-load bearing wooden constructions and connections of hard, soft and exotic sorts of wood (for example, finger joints, dovetails, tenon and mortise joints, dowels and springs).
2. Surface gluing of wood, soft and hard board, chipboard, multiplex, MDF, paper, cardboard and board.
3. Veneer work.
4. Gluing (laminating) hard plastic sheets (HPL; Formica, Duropal, Resopal) to wooden materials with the help of cold or hot presses.

D3: Suitable for indoor use, when the glued joint may regularly be exposed briefly to water and condensation and/or high relative humidity. Also suitable for outdoor use, if not exposed to climatic influences.

Preparation of base: The parts to be glued must be clean, dry, grease and dust free and fit together well.

Clean tools with hot water, directly after usage. Preparation of glue: Stir the glue before use if necessary.

Tools: Use a brush, glue comb, pressure vessel, roller or a glue gun.

Processing conditions: The temperature of the workplace, the glue and the material must be no lower than +5°C.

The relative humidity may be a maximum of 65%. The moisture content of the wood must lie between 8% and 12%.

Open time¹ : approx. 8 minutes

Use : 5-7 m²/kg, applied to one side.

Pressure : 0.5 - 5 kg/cm².

Pressure time at 20°C : Depending on the amount of glue used, wood moisture content, temperature, as well as structure and the porosity of the material.

¹ Depending on the applied amount of glue, wood moisture content, temperature as well as the structure and porosity of the material.

	Pressing temperature	+20°C	+50°C	+80°C
application				
Solid wood on wood		20 min.	10 min.	n.a.
veneer on wood (chipboard / plywood)		10 min.	6 min.	4 min.
HPL on wood (chipboard / plywood)		20 min.	10 min.	6 min.

PROPERTIES

Moisture resistance : really good (waterresistent, conform NEN-EN 204 D3).

Dilutability : don't dilute with water, unless it is aimed at reaching the original viscosity

Frost resistance : good. In case of slightly frozen glue, slowly defrost in a well heated room (never close to a source of heat). Stir thoroughly. The glue can be used again once it reaches its normal thickness. It is recommended to perform a small gluetest at first. Confirms to NEN-EN 204 D3.

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TECHNICAL INFORMATION

Glue type	: aqueous dispersion
Basic Material	: polyvinylacetate dispersion
Color	: white, dries transparent.
Solids content	: approx 52%
Density	: 1090 kg/m ³
Viscosity	: 15000 (+ or - 2) mPa.s, at +20°C
Flash point	: K3 >55°C. Wet glue is not flammable.
White point	: approx +5°C
PH	: 3.
Temperature resistance	: from -20°C to +60°C

SHELF LIFE

1KD3 SPRAY may be used up until 24 months after production, if stored in well-sealed packaging at a temperature between +10°C and +20°C. Keep frost-free. Always work in order of receiving (FIFO).

CLEANING

Rinse wet glue stains immediately and solely with water. Dry glue stains are only removable mechanically. Remove dried glue residues with a VERDUNNER.

PACKAGING

Bottles of 5 and 10kg.
Jerrycan of 25 kg.
Containers of 1.150 kg.

Our processing advice is based on extensive research and practical experience. We can accept no liability for the results obtained and / or any damage resulting from the use of this product because of the wide range of materials and circumstances in which the glue is used. Nevertheless we would be pleased to advise you.

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