

# HOUTLIJM 1KD4

## PRODUCT DESCRIPTION

Is a single component weather and seawater proof wood glue with a PVAc base. It satisfies the following standards NEN EN 204 D4 and WATT 91

## DIRECTIONS FOR USE

1KD4 is intended for the waterproof adhesion of amongst other things finger joints, lamination and angle joints of hard, soft and exotic woods using warm, cold, high frequency or upstroke presses. For edge sealing of multiplex and the gluing of many other materials including HPL, PU foam and suchlike onto wooden bases. 1KD4 has been approved for finger joining of all sorts of wood, the laminating of pinewood, meranti and sidings of pinewood, meranti and merbau. 1KD4 can also be used to adhere various sorts of metals to wood.

## PROCESSING

Ensure clean, dry, dust-free, grease-free and well-fitting materials. Apply 1KD4 to one side. The temperature of the glue, the materials and the environment must be the same (approximately +15°C and +20°C) to ensure optimal results. The moisture content of the wood should be between 8% and 14% and there should be no difference between the centre and the outside of the wood. The waiting time before contact is approximately 8 minutes at a temperature of +20°C. The recommended amount of glue is 120- 250 gr/m<sup>2</sup>. Setting times are very much dependant on the moisture content and absorption capacity of the materials to be glued, the temperature and the thickness of the layer of glue. The glue should never be thinned down with water. The final strength of the glued joint is achieved after approximately 7 days. The pressure required is 0,2 – 1,0 N/mm<sup>2</sup>, depending on the sort of wood. Be aware: because of the low pH value of the glue it is advisable to use acid proof parts in pumps and other components that may come into contact with the glue. The properties of the glue can be disadvantageously influenced if a pump pressure of 6 bars is exceeded. Wet glue can be removed immediately with warm water. Dried glue can be removed using thinner or VERDUNNER.

## TECHNICAL INFORMATION

Basic material	: polyvinyl acetate
Colour	: white, transparent when dry.
Water resistance	: Excellent, D4
Minimum film forming temp.	: approx. +8 °C
Processing temperature	: 10-30 °C
Solids	: approx. 49%
Viscosity at 20°C	: approx. 7500 mPa.s
PH valua	: approx. 3,0

## CLEANING

Equipment used for the application of the glue should be cleaned with warm water, before they dry.

## SHELF LIFE

The glue must never freeze. The recommended storage temperature is +10°C and +20°C. At these storage temperature 1KD4 has a shelf life of 6 – 8 months. Higher storage temperatures shorten the shelf life of the glue (storage indications: +25°C max. 4 months, +30°C max. 3 months). Opened packages must be well sealed after use.

## PACKAGING

Container 1050 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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