

# BIJLARD HOUTLIJM 1KD3 Blue + ®

## 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.

## AREA OF USE

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.

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.

## PROCESSING

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

**Preparation of glue:** Stir the glue before use if necessary.

**Tools:** Use a brush, glue comb, pressure vessel, roller or a glue gun. During small work, one can apply the glue directly from the squeeze bottle. Clean tools with hot water, directly after usage.

**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 time<sup>1</sup>** : approx. 10 minutes

**Use:** 5-7 m<sup>2</sup>/kg, applied to one side.

**Usage:** Apply the glue even and sparsely on one of the parts. Leave to infuse for several minutes, but clamp or press both parts together within the open time of 10 minutes.

**Pressure:** 0.5 - 5 kg/cm<sup>2</sup>.

	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.

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

## 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.

**BIJLARD**®  
**PROFESSIONAL ADHESIVES**

#### TECHNICAL DATA

Glue type	: aqueous dispersion
Basic Material	: polyvinylacetate dispersion
Color	: blue (color in consultation with customer).
Solids content	: approx 52%
Density	: 1090 kg/m <sup>3</sup>
Viscosity	: approx 15.000 mPa.s, at +20°C
Flash point	: K3 >55°C. Wet glue is not flammable.
White point	: approx 0°C
pH	: 3
Temperature resistance	: from -15°C to +60°C

#### STORAGE STABILITY

Bijlard Houtlijm 1KD3 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).

#### GLUE STAINS

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

#### PACKAGING

- Bucket of 25 kg
- Containers of 1150 kg.

**Our brochure is based on extensive research. Due to the wide variety of materials and conditions are bonded, we can not accept responsibility for the results obtained and / or any damage that would result from the use of the product. We are ready with advise.**

**BIJLARD**®  
**PROFESSIONAL ADHESIVES**