

# Strong Glue D4 PVAc

## USE

Strong Glue D4 PVAc is a reactive PVAC-dispersion adhesive, which is well suited for general use in the wood industry. Due to its D4 water resistance durability class, Strong Glue D4 PVAc can be used for exterior applications exposed to weather when covered with an adequate surface covering, or indoors for applications with frequent long-term exposure to running or condensation water. Joints can be pressed in a cold, hot or high frequency press.

Product complies:

- Moisture resistance according to EN 204 D4
- Thermal resistance according to EN 14257 – Watt 91
- M1 Classification of building materials



## TECHNICAL SPECIFICATION

Base:	PVAc
Form:	water dispersion
Color:	White, transparent after drying
Viscosity at 20 ° C: (Brookfield)	5 000 mPa.s (Brookfield, RVT +20 ° C)
pH:	2.7
Temperature resistance when dry:	EN 14257 (WATT 91): 8,3 N/mm <sup>2</sup>

## INSTRUCTION FOR USE

Optimal application temperature of working place, adhesive and materials	18 - 22 °C
MFT:	+6 °C
Aplikation:	disk, wheel, nozzle, brush
Optimal wood moisture:	6 - 15 %
Pressing time:	20 min. (Pine, 12 % wood moisture, temperature 20 °C, 50 % RH)

The adhesive coating affects the length of the open time as follows:  
(pine 12% wood moisture, temperature 20 °C, 50% relative humidity)

Nános (g/m <sup>2</sup> )	Otevřený čas (min)
150	7 min
180	11 min
220	17 min
250	19 min

In order to achieve ideal adhesion, it is necessary to thoroughly clean the bonded materials and follow the recommended processing method. When gluing hardwood, it is necessary to use a material with constant humidity and quality workmanship in order to avoid a reduction in the quality of the joint and the resulting resistance to moisture. To achieve maximum moisture resistance, the adhesive should be applied to both bonded surfaces. Maximum water resistance is achieved after 7 days.

Very low temperatures have a negative effect on the pressing time. Excess wood moisture (> 12%) slows down the curing time of the adhesive, resulting in a longer pressing time.

# TECHNICAL DATA SHEET



The product is ready to use. Subsequent addition of water or other substances may change the characteristics of the adhesive and reduce the quality of the bonded joint.

The structure of the bonded material and the application conditions affect the bonding, therefore it is advisable to perform your own tests. Failure to comply with storage and processing conditions will adversely affect the gluing results.

## CLEANING

Clean fresh and undried adhesive with warm water immediately after use. To prevent undesired settling of the adhesive on the surface of the applicator machines and machine parts, we recommend AGGLU separation paste, AG-CLEAN PVAc can be used to remove the dried adhesive residues.

## STORAGE

Shelf life: min 12 months  
Optimal temperature and storage humidity: 15 - 20 °C (max. 25 °C), humidity max. 50 %

The storage period applies to products in original, undamaged and well-sealed packaging stored in accordance with the stated conditions in covered warehouses, protected from the sun, rain and frost out of reach of the heat source. After removing the glue, the package must be tightly closed again.

## HEALTH AND SAFETY INSTRUCTION

Avoid unnecessary skin contact and exposure with the fresh product, usesafety gloves. Further handling, transport and disposal warnings are provided in the corresponding safety data sheet.

*The data in this technical sheet is based on our practical experience and laboratory test results. As they cannot take into account all possible uses, they are not-binding. The data are neither a guarantee of quality nor assurance of properties. No legal claims can be drawn from these data, as well as from our free technical advisory service. Values are continuously updated according to the latest technology. This edition replaces all previous releases and is valid as of that date.*

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