

Marches Ironmongery D4 Wood Glue Technical Datasheet

Description

Formulated crosslinking emulsion adhesive.

Appearance

White liquid.

Technical Characteristics

Brookfield Viscosity
(Spindle 6, speed 20 rpm)

Solids (1 hour at 105°C)

Typical Data

14,000 Mpas @ 23°C.

46%

Typical Applications

- * Wood to wood in general assembly and joinery applications - hot and cold pressing.

Typical Properties

Features

- * One component.
- * Fast setting.
- * High bond strengths.

Benefits

- * No need for mixing of catalyst.
- * Rapid production throughput.
- * Bond security.

Application Guide

Temperature of substrates, environment & adhesive	15 - 20°C
Moisture content in the wood.	8 - 12%
Coat Weight:	100 - 160 gsm
Glue line pressure:	2 - 8 kg/cm ² (dependent on type of wood and stress in the construction).
Open Time:	Up to 5 minutes.
Closed assembly time	Up to 20 minutes.
Press time at 20°C:	Minimum of 15 minutes. (softwood). Minimum of 25 minutes (hardwood).
Radio frequency press time:	45 seconds to 2 minutes. Cooling time depends on wood & shape of substrate.
Minimum film forming temperature:	4°C.

Full water resistance is not achieved until 7 days after bonding.

Packaging

Consult local sales office.

Storage & Handling

Rotate stock using oldest material first.

Keep covered to prevent contamination and drying out.

Do not mix with other adhesives.

Protect from freezing.

Shelf life: For best results use within 12 months from day of delivery.

HEALTH & SAFETY

Users should familiarise themselves with the safety data sheet before using or handling this product.