



D3 SUPER WOOD GLUE

1 – DESCRIPTION

D3 is a formulated cross-linking synthetic emulsion. Its fast setting and water resistance are suitable for rapid production and bond security even under damp conditions.

2 – PROPERTIES

- Fast curing.
- Low press time.
- Extremely high bond strength on numerous substrates.
- Conforms to D3 according to DIN EN 204.
- Very good resistance to chemicals.
- Excellent resistance to moisture and weather conditions.
- Nonshrinking.
- Low odour.

3 - APPLICATIONS

D3 Adhesive can be used in lamination of HPL to wood based substrates and wood to wood when a good water resistance is required.

D3 is vinyl acetate homopolymer dispersion with reactive groups with an acidic pH range.

It is used to adhere all kinds of wooden pieces to each other, and used to adhere all kinds of laminate and plates to wooden pieces. Because of the water resistant, it is used in windows having resistance to vapor and moisture, woodworks, doors, external door frames, production of stairs and wooden furniture, high frequency adhering applications, delicacy processes, surface covering of DKS Plates, mounting processes, to adhere decorative papers to surfaces and hard-soft fiberboards to each other.

D3 exhibits a rapid increase of bond strength when being pressed at temperatures of approx. 20 °C as well as at higher levels of temperature between 50 and 100 °C. Particularly on hot presses (60-80 °C) the accelerated increase of bond strength makes D3 most suitable for the lamination of panels with formica finishing and for post-forming finishing of panel edges and profiles. The resulting water proof bonds exhibit an outstanding heat resistance.

Dry films of D3 only absorb a very low amount of water. Even after prolonged water immersion the films show no agabeylity reemulsify, exhibiting therefore a good water-proof performance of the dried bond.

4 - INSTRUCTIONS

D3 Adhesive can be applied using mechanical glue spreader, brush or hand roller and air activate glue gun.



5- PACKAGING

| Product | Weight | Package |
|---------|--------|---------|
| D3 | 500 gr | 12 |
| D3 | 3 Kg | 4 |
| D3 | 10 Kg | 4 |
| D3 | 30 Kg | 1 |

6- STORAGE AND SHELF LIFE

The emulsion must be stored between 5-25°C for a maximum of 12 months from production date.

7- RESTRICTIONS

Full water resistance is achieved after 7 days. The product should be thoroughly mixed before use.

Addition of water to D3 Adhesive is not recommended.

Rotate stock using oldest material first. Do not mix with other adhesives. Protect from freezing.

8- TECHNICAL PROPERTIES

| | | | |
|---|--|------------------------------------|--|
| Basis | : Vinyl Acetate polymer | | |
| Appearance | : White paste | | |
| Density | : 1.05 g/mL | | |
| Solids % | : 54 ± 1 | | |
| Filming Time | : Min. 10 minutes | (20°C) | |
| Viscosity | : 14400 ± 800 cps | cps at 20°C (Spindle No 6, 20 rpm) | |
| Moisture content in wood | : 8 - 12 %, Increase press time for higher moisture content. | | |
| pH | : 5-6 | | |
| Glue line pressure for hard wood | : 9 - 12 kg/cm ² | | |
| Water resistant | : Good | (D3-DIN EN204) | |
| Consumption | : 70-130gr/m ² | | |

| Material | Press Heat | | |
|-------------------------|------------|--------|--------|
| | +20 °C | +50 °C | +80 °C |
| Wood to wood | 30 min. | 8 min. | 4 min. |
| Coating to wood | 20 min. | 4 min. | 2 min. |
| Synthetic wood coatings | 30 min. | 6 min. | 3 min. |