Technical data sheet

PARACOL WOOD D4

CHARACTERISTICS

- One-component, white wood glue
- Extremely high bonding capacity
- The water and temperature resistance can be raised by using high process temperature (e.g. +70°C)
- Rapid curing
- Dries transparently
- No discolouration of the adhesive joint due to process heat (e.g. in HF press)
- Excellent water resistance (durability class D4 according to EN 204)
- Short press times
- Excellent adhesion on difficult wood species (oak, larch)
- Resistant to high temperatures (tested according to EN 14257 - WATT'91)

APPLICATIONS

- Suitable for the most common types of wood and particularly suitable for problematic woods such as beech, maple and bamboo.
- Gluing dowels, dovetails, mortise and tenon joints,...
- Tongue and groove bonding in floating parquet, softwood, chipboard...
- Bonding of wooden window and door frames for interior and exterior use
- Applications complying with durability class D4 according to EN 204. Suitable for interior use with frequent moisture exposure and exterior use exposed to weathering.
- Suitable for the most common and difficult wood species
- Bonding of (tropical) solid wood and wood-based materials
- Furniture production

TECHNICAL CHARACTERISTICS

Type of product	PVA dispersion
Density (g/ml)	1.1
Number of components	1
Viscosity	5500 mPa.s (Brookfield 20 rpm spindle 2, 20°C.)
Application temperature	+15°C - +35°C
Temperature resistance	-20°C - +70°C
pH	± 3.5
Minimum film formation temperature (MFFT)	+ 8°C
Working time at 23 degrees C and 50% R.H.	8–9 minutes (at 150 g/m²)
Temperature product when applying	+18 - +20°C
Dry matter content	50%
Shelf life of unopened product	6 months
Storage conditions	Store in a dry, cool place at +5°C to +25°C. Keep out of direct sunlight.

PACKING AND COLOURS

bucket 5kg - 60 pieces/pallet
White

12 x flacon 750GR/box - 480 pieces/pallet
White

DL CHEMICALS Since 1936 Manufacturer of Sealants

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METHOD OF USE

Preparation

- The user needs to make sure that the product is suitable for the application. Consult our technical service if necessary.
- All parts should mate well and must be free from dust and grease. If the parts do not fit, the setting time will be longer and the bond strength will be lower. The joints should be processed shortly before bonding.
- Stir the product well.

Application

- Apply the product in a thin layer on one side or, in case of high water resistance requirements, on both sides using a brush, roller, spatula, fine notched trowel or glue spreading machine
- Assemble the parts and then press them together. In case of bleeding wood, increase the press time to 20–30 minutes
- Minimum press times for window frames made of softwood (e.g. softwood species): > 15 min; for window frames made of hardwood (e.g. oak, beech): ± 2 h; for assembly joints: 8–15 min; for tongue and groove joints: 15–30 min; in a continuous press (short-cycle press) at 70°C: ± 1 min
- Respect the open time and press time. These depend strongly on working conditions such as temperature, relative humidity, porosity of the material, glue quantity and moisture content of the wood. Recommended conditions:
  - Substrate and ambient temperature: 18°C - 20°C
  - Wood moisture content: 8 - 10%
  - Relative humidity: 40 - 60%

Consumption

150-180 g/m²

Cleaning

- Before curing: Tools, surfaces and uncured residues can be removed with water.

SAFETY

Consult the safety information on the packaging and the safety data sheet for more information.

POINTS OF ATTENTION

- Do not dilute the product.
- In some cases, discolouration may occur on certain wood species (beech or cherry). Iron in combination with tannins may also cause discolouration (e.g. oak). It is therefore recommended to carry out a test beforehand
- Prolonged storage and high temperatures may lead to an increase in viscosity, but do not affect the adhesive properties of the glue. Stir the adhesive well before use.

TECHNICAL APPROVALS AND QUALITY LABELS

- French VOC emission class A+

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