

Product Information:

Wood Glue Winter 465

Indoor wood glue for bonding down to -10 °C**General description and application:**

Wood Glue Winter 465 is an all-round indoor PVAc wood adhesive, suitable for gluing in temperatures down to -10 °C.

The glue can be stored at temperatures down to -40 °C.

The product is registered in the database for construction products that can be included in the Nordic Ecolabelled construction.

**Physical / chemical properties:****Adhesive:**

Type: Waterbased PVAc dispersion
 Colour: White
 Consistency: Liquid
 Solids content: Approx. 51 %
 Viscosity: Approx. 14,500 cP, Brookfield RVF, 20 rpm, 20 °C
 Specific gravity: Approx. 1.1 kg/L
 Shelf life: Minimum 24 months in unopened packing if stored between -40 °C and +30 °C.
 Frozen adhesive should be heated slowly.

Packaging:

Item no	Size
2107	100 mL
2109	750 mL
21121	5 kg can

Cured adhesive:

Colour: Matt translucent
 Resistance: Temperature: Max. approx. 80 °C, depending on demands for the strength. The adhesive is thermoplastic, and strength will decrease with rising temperature.
 Water: Resistant to humidity, but not to water.



Directions for use:

- Preparation:** Both surfaces must be clean, dry and well adjusted. Optimum results are obtained with newly worked wood.
- Application:** The adhesive is applied on one surface. When bonding hard woods, two-sided application is recommended, as well as increasing assembly time and pressing time.
- Moisture content of wood:** 7 - 15 %
- Application temperature:** Minimum -10 °C. The temperature includes wood, adhesive and room.
- Film thickness:** Approx. 120 - 200 g/m².
- Open assembly time:** Maximum 6 minutes on pine at 20 °C and 50 % RH. When joining, the adhesive must still be wet. If assembly time is "closed", it can be increased 1 - 2 minutes.
- Assembly time is increased with two-sided application, hard wood, lower temperature and higher humidity of air and wood.
Assembly time is reduced at higher temperatures and lower humidity of air and wood.
- Pressure:** App. 1 - 5 kg/cm². In case of tensions in the wood a higher pressure should be applied.
- Pressing time:** Minimum 10 minutes on pine with approx. 9 % wood moisture at 20 °C.
Pressure time should be increased for hard woods, two-sided application, lower temperature, higher humidity of the air and higher moisture content of the wood.
E.g. pressing time is 24 hours at -10 °C.
Pressing time can be reduced when heating the wood or using warm press.
- Full strength is usually obtained after 24 hours at 20 °C.
- Cleaning:** Adhesive on the skin is removed with water and soap. Tools are cleaned with water while the adhesive is still wet. Cured adhesive can only be dissolved with ethanol.

All stated times are meant as a guideline. Sufficient tests should be carried out to establish final working conditions.

**For more detailed information on wood bonding we refer to the brochure
» WOOD GLUE – Product Guide «.**

Health and safety:

For further information on safety, refer to product safety data sheet.

The information and data contained in this Product Information sheet are based on extensive laboratory testing and our practical experiences and are meant for helping the user to find optimum working methods. As the conditions at the user are beyond our control, we make no warranties concerning the results, achieved by the products. The information's in this Product Information sheet are typical values, intended as a guideline. They should not be regarded as product specifications. Please also refer to our standard sales conditions and terms of delivery.

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