

Product Information:

Wood Glue D3 Outdoor 430

Moisture resistant D3, for all wood type.

General description and application:

Wood Glue D3 Outdoor 430 is a strong 1-component moisture resistant adhesive in class D3, according to EN204/205.

The adhesive is suitable for where a high resistance to humidity is required, e.g. laminating of panel board for furniture, kitchen tables and assembling of frame wood for wet rooms etc. Wood Glue D3 Outdoor 430 is also suitable for edge bonding and veneering.

The adhesive can be used in cold-, hot- and high frequency (HF) press.

Water resistance class D4 is obtained by adding 5 % DANA Dark Hardener or 5 % DANAFIX 921.

Approved for indirect food contact in accordance with FDA 21CFR175.105.

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



Physical / chemical properties:

Adhesive:

- Type: Moisture resistant PVAc dispersion
- Colour: White
- Consistency: Liquid
- Solids content: Approx. 51 %
- Viscosity: 10,000 - 14,000 cP, Brookfield RVF, 20 rpm, 20 °C
- Density: Approx. 1.1 kg/L
- Shelf life: Minimum 24 months in unopened packing if stored cool and dry.
- Packaging:

| Item no | Size |
|---------|---------------|
| 2131 | 250 mL bottle |
| 2129 | 750 mL bottle |
| 21221 | 5 kg can |
| 2123 | 10 kg bucket |
| 21241 | 20 kg bucket |

Cured adhesive:

- Colour: Matt translucent
- Resistance: Temperature: Up to approx. 80 °C, depending on demands for the strength. The adhesive is thermoplastic, and strength will decrease with rising temperature.
- Water: Class D3 (EN204/205).
Class D4 by adding 5 % DANA Dark Hardener or 5 % DANAFIX 921.



Directions for use:

- Preparation:** Both surfaces must be clean, dry and well adjusted. Optimum results are obtained with newly worked wood. When bonding some types of wood (e.g. oak), a test should be carried out, as certain substances in the wood may react with the adhesive, causing discolorations.
- 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:** +3 °C to +40 °C. The temperature includes wood, adhesive and room.
- Film thickness:** Approx. 120 - 200 g/m².
- Open assembly time:** Maximum 5 minutes on pine at 20 °C and 50 % RH.
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:** Approx. 1 - 5 kg/cm². In case of tensions in the wood a higher pressure should be applied.
- Pressing time:** Minimum 5 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.
Pressing time can be reduced when heating the wood or using warm press.
Full strength is usually obtained after 24 hours at 20 °C and full water resistance is obtained after approx. 5 - 7 days.
- After treatment:** Adhesive joints which are exposed to the weather, must always be coated with water resistant paints or lacquers.
- Cleaning:** Uncured adhesive is removed with wipes or hot water.
Cured adhesive can only be dissolved with ethanol.
Wash skin with water and soap.
- 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 the 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.

**DANA LIM A/S - KØBENHAVNSVEJ 220 - DK-4600 KØGE – DENMARK – INFO@DANALIM.DK
PH. (+45) 56 64 00 70 - TECHNICAL SERVICE PH. (+45) 56 64 00 75**