

Product Information:

RAW Wood Glue Outside

Moisture resistant D3, for all wood types.

General description and typical applications:

RAW Wood Glue Outside is a strong 1-component moisture resistant adhesive in class D3, according to EN 204/205.

The adhesive is suitable where 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. RAW Wood Glue Outside is also suitable for edge bonding and veneering.

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

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

Physical / chemical properties:**Adhesive:**

Type:	Moisture resistant PVAc dispersion
Colour:	White
Consistency:	Liquid
Solids content:	App. 51 %
Viscosity:	App. 13.000 cP, Brookfield RVF, 20 rpm, 20 °C
Specific gravity:	App. 1,1 kg/l
Shelf life:	Minimum 24 months in unopened packing if stored cool and dry.

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 (EN 204/205).

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:** Minimum +3 °C. The temperature includes wood, adhesive and room.
- Film thickness:** App. 120 - 200 g/m².
- Open assembly time:** Maximum 5 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 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 obtained after approx. 24 hours at 20 °C. Full water resistance is obtained after approx. 7 days.
- After treatment:** Adhesive joints which are exposed to the weather, must always be coated with water resistant paints or lacquers.
- 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.**

Health and safety:

For further information concerning safety, refer to 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.