

PUR D4 63 adhesive

PRODUCT DESCRIPTION

PUR D4 63 is one-component, solvent free polyurethane adhesive. Designed for dry and wet wood bonding, wooden elements in construction industry, window joinery, stairs, for bonding wood with Styrofoam, mineral and glass wool, PUR foam, cardboard, tars, concrete boards and other materials. Adhesive meets the requirements of D4 water resistance class according to PN-EN 204 standard.

TECHNICAL DETAILS

State of matter:	liquid
Colour:	brown
Viscosity in 25 ⁰ C, mPas:	max. 5000
Density in 20 ⁰ C, g/cm ³ :	1.10-1.20

Technological properties

PUR D4 63 polyurethane adhesive cures in reaction to moisture contained in wood and air. Reacts also with some of the natural substances accruing in wood. During the bonding, adhesive weld increases its volume slightly - foams. The foaming degree increases with increasing of curing speed. Adhesive curing times reduce along with temperature rise and increasing of humidity in air and glued materials. After bonding, the adhesive forms a flexible joint, resistant to temperatures from -40 to + 80⁰C.

APPLICATION

Spread adhesive on bonded elements. Consumption of glue should not be less than 150g/m². Consumption of glue increase in case of absorptive materials, e.g. when bonding mineral wool with wood it should be no less than 300g / m².

The amount of used adhesive must ensure wetting with glue both of bonded surfaces. In case of bonding air-tight materials (except of wood), spread glue need to be mist with water to ensure complete cure of the weld. Providing of water ensures simultaneous curing of the adhesive on the entire surface. After application of adhesive, both of glued elements need to be pressed and allowed to stay under the load until curing of adhesive bond.

USE CONDITIONS

Bonded surfaces should be free from impurities, and degreased if needed.

Temperature range	+5 to +40C
Optimal air humidity	50-80 %
Optimal moisture content of wood (Testing is recommended when higher wood moisture)	12-20 %
Adhesive consumption	150-500 g/m ²
Time to achieve full strength of the weld	24 h.

Open time: In indoor conditions, time needed to fold next elements together is around **2-3 minutes**.

Press pressure: Depending on the wood species and technological requirements:
0,2 - 1,5 N/mm² (2-15 kg/cm²).

Pressing time: Determination of the cure time requires testing in every attempt.
Misting with water speeds up the cure of the adhesive.

PACKAGES

PUR D4 63 is available in following packages: 1 kg, 10 kg, 20 kg, 240 kg, 1000 kg

STORAGE AND EXPIRY DATE

Store in original, closed packaging in temperatures between +15 to +25°C.

Shelf life:

Metal packaging (barrel, pails, bottles)	12 months
barrels, canisters and bottles of plastic	12 months
IBC containers	6 months

After opening the package, take required amount of adhesive and close the container tightly.

HAZARD INFORMATION

PUR D4 63 is a harmful substance. Please read Material Safety Data Sheet before use. Use standard protective clothing, when working with adhesive. Fresh stains should be washed with solvent. The cured adhesive can be removed mechanically.

Above information's are the result of our practical experience and have indicative character, they are not guarantee of product properties and cannot be the underline for complaint. For this reason use of adhesive under conditions other than those specified in this sheet does not guarantee obtaining optimum results. Manufacturer is not liable for any damages resulting from non-compliant use.

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