

**Product Information:**

# Wood Glue PU Dark 422

**Water resistant D4 for wood, metal, rigid plastic etc.****General description and application:**

Wood Glue PU Dark 422 is a one-component moisture-curing polyurethane adhesive, especially for bonding of wood with a high moisture content and for bonding of metals, rigid plastics, expanded polystyrene, ceramics etc.

Wood Glue PU Dark 422 is recommended where high strength and water resistance are required. The adhesive is water resistant according to EN204/205, class D4.

**Physical / chemical properties:****Uncured adhesive:**

|                   |  |
|-------------------|--|
| Type:             | 1-component polyurethane adhesive  |
| Colour:           | Brown  |
| Consistency:      | Liquid   |
| Solids content:   | Approx. 100 %  |
| Viscosity:        | Approx. 10,000 cP, Brookfield RVF, 20 rpm, 20 °C   |
| Specific gravity: | Approx. 1.1 kg/L   |
| Shelf life:       | Minimum 12 months in unopened packing if stored cool and dry. The product should be protected from moisture. |

**Packaging:**

| Item no. | Size          |
|----------|---------------|
| 53051    | 250 mL bottle |
| 53031    | 750 mL bottle |

**Cured adhesive:**

|             |                              |
|-------------|------------------------------|
| Colour:     | Light yellow                 |
| Resistance: | Water: Class D4 (EN204/205). |



## Directions for use:

- Preparation:** *The surfaces must be clean, dry and well adjusted. Optimum results are obtained with newly worked wood.*
- Application:** *The adhesive is applied on one surface in a thin even layer. When bonding hard woods, two-sided application is recommended, as well as increasing assembly time and pressing time. We recommend that protective gloves are used.*
- Moisture content of wood:** *The moisture content of the wood must be 12 – 20 %. If the moisture content is too low, additional moisture must be added by spraying. When bonding materials with no natural moisture, additional spraying of water before bonding is necessary.*
- Application temperature:** *15 - 40 °C. The temperature includes wood, adhesive and room.*
- Film thickness:** *Approx. 150 - 170 g/m<sup>2</sup>.*
- Open assembly time:** *Maximum 30 minutes on pine at 20 °C and 50 % RH. When joining, the adhesive must still be wet. Assembly time is increased with two-sided application, hard wood, lower temperature and lower humidity of air and wood. Assembly time is reduced at higher temperatures and higher humidity of air and wood.*
- Pressure:** *Approx. 2 - 10 kg/cm<sup>2</sup>. In case of tensions in the wood a higher pressure should be applied.*
- Pressing time:** *Minimum 3 – 4 hours on pine with approx. 14 % wood moisture at 20 °C. Pressure time should be increased for hard woods, two-sided application, lower temperature, lower humidity of the air and lower moisture content of the wood. Pressing time can be reduced when heating the wood or using warm press. The adhesive cures in a reaction with the moisture of the wood and air, which causes the adhesive to “foam”. It is essential that the surfaces are kept in the press during the complete curing process, as foam-formation in the joint will reduce the strength.*
- After treatment:** *Adhesive joints which are exposed to the weather, must always be treated with an efficiently covering surface treatment.*
- Cleaning:** *Adhesive on the skin is removed with water and soap. Tools are cleaned with acetone while the adhesive is still wet. Cured adhesive can only be removed mechanically.*
- 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 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. 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**