



The Glue People

Trade Grade Products Ltd
Unit 2, Thorne Way
Woolsbridge Industrial Park
Three Legged Cross
Wimborne, Dorset, BH21 6FB

Tel 01202 820177
Fax 01202 814011

Tradebond D132

Quick setting, versatile PVA adhesive

General Description

Tradebond D132 is a high quality PVA adhesive, which sets quickly under heat application or at normal temperatures even when applied thickly, e.g. joints rough from the saw. The glue will run off only a little on vertical joints. Glue that is pressed out can be removed easily with a lathe tool. The joints after setting are firm, but still sufficiently flexible to permit cores to be transported. Tradebond D132 meets British Standard Requirements DIN EN 204 - D 1.

Uses

- Gluing of block and strip cores.
- Surface gluing of HPL and CPL in short cycle presses.
- Carcase and assembly gluing when short pressing times are required, particularly when the parts are pre-heated.
- Edge banding in stationary presses with veneers, plastic laminates and solid wood strips.
- Gluing joints in boards and block gluing of softwood and chipboard.
- Manual doweled gluing of box furniture.

Application

Wood preparation:	All parts should fit well and be free from dust, grease or any other contaminants. In the case of cores, generally saw-rough core strips are used, but these should be as straight as possible and cut exactly to size.
Glue spreading:	Apply Tradebond D132 evenly to one surface using a glue spreading machine, serrated spatula or any other suitable device.
Pressing:	Lay the items to be bonded together within the open time and press for as long as is required to obtain sufficient initial strength.
Wood discolouration:	Tradebond D132 does not cause discolouration of the wood. Iron in combination with the tannic acid of veneer can however lead to changes in colour, particularly in the case of oak.
Cleaning:	Clean tools with water before the adhesive dries.

The open time and the setting time are strongly influenced by the working conditions, e.g. temperature, humidity, absorbency of the materials, tension of the material and the quantity applied. Good results will be achieved under the following conditions:

Room/material/glue temperature: 18 – 20°C

Moisture content of wood: 8 – 10%

Relative humidity: 60 – 70%

Glue spread guide.

Gluing cores:	35 – 45g/m ²
Surface gluing in short cycle press:	80 – 100g/m ²
Carcase and assembly gluing:	160 – 180g/m ²

Pressing times.*Cores:*

Pressing times depend on temperature conditions and throughput speed, which in turn depends on the strip width.

Surface gluing of HPL sheets – minimum pressing times:

Amount applied (g/m ²)	Guide value for pressing time (min)			Using pressing method
	20°C	40°C	60°C	
80	- - -	1,0	0,7	Short cycle press.
100	From 6,3	1,5	1,1	Short cycle and multi stage press.
120	From 8,4	2,5	- - -	Multi stage press.
140	From 12,0	4,0	- - -	Stacking press.

Carcase and assembly gluing:

At normal temperatures:	from 3 minutes.
Pre-heated on one side:	from 45 seconds.

Physical Data

Base	Polyvinyl Acetate dispersion (PVA)
Colour	White
Viscosity Brookfield HBT Spindle 3, 20rpm	14.000 mPa.s (approx.)
White point	+3°C (approx.)
pH value	7 (approx.)

General*Hazards:*

Tradebond D132 is not classed as hazardous for transport or carriage according to EU regulations.

Storage:

Store in tightly closed, original container. **Protect from frost.**

Important Notice

Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheet, Tradebond D132.