



*The Glue People*

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# Tradebond D138

**Synthetic high strength resin glue**

## Uses

- Surface bonding (also laminates).
- Joint bonding (hard and exotic woods).

## Advantages

- One component glue.
- Good process ability.
- Favourable open time.
- Short curing times when subjected to heat.
- High bond strength (DIN EN 205).
- Hard elastic glue film.

## Application

### Methods

- Paint brush or spatula.
- Manual gluing devices.
- Glue spreading machines.

### Techniques

The materials to be bonded must be dry, free from dust grease and other contaminants and acclimatised to room temperature. The most favourable working temperature is approximately +20°C, do not process below +10°C. Tradebond D138 is supplied ready to use – Do not dilute.

### Quantity

100 - 150 g/m<sup>2</sup> when applied mechanically.  
150 - 200 g/m<sup>2</sup> when applied with manual gluing devices.

**Open time** 5 - 10 minutes.

The open time is dependant on the absorption properties of the substrates, moisture content of the substrates, the room temperature and the quantity applied.

### Pressing times

Joint bonding	20°C	10 minutes (approx.)
Joint bonding (one side pre-heated)	80°C	5 minutes (approx.)
Surface bonding (HPL boards)	20°C	25 minutes (approx.)
Surface bonding (HPL boards)	50°C	6 minutes (approx.)
Surface bonding (HPL boards)	70°C	2 minutes (approx.)

This data is given without obligation and is based on moisture content of the wood of approximately 10%. As the different bonding processes are influenced by various factors; we recommend that you determine these times for yourself by trials in your own premises and are please to provide a sample upon request.

## Physical Data

<b>Physical state</b>	Polyvinylacetate dispersion
<b>Specific weight</b>	1.19 g/cm <sup>3</sup> (approx)
<b>Colour</b>	White / Cream / Blue
<b>Viscosity @ 20°C</b>	13000 ± 3000 mPa.s (Brookfield RVT)
<b>Consistency</b>	Medium viscosity
<b>Open time @ 20°C</b>	5 - 10 minutes (approx)
<b>Chalk point</b>	+8°C
<b>Shelf life</b>	1 year (approx.)

## General

**For safe handling information on this product, consult the material safety data sheets, (MSDS).**

### Cleaning

Machines, tools and adhesive containers can be cleaned with water.

### Packaging

- 25 Litres plastic drum
- IBC 1000Kg net

### Storage

**\*\*\*PROTECT FROM FROST\*\*\***

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For specific shelf-life information, contact Trade Grade Products at the above address.

### Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.

### 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 D138.