



*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 WA40

**Water resistant PVA adhesive**

## Product Description

Tradebond WA40 is a one part PVA emulsion adhesive, specially formulated for wood bonding where a fast set, high bond strengths and excellent water resistance is required. WA40 adhesive bonds virtually all woods, wood veneers, and mouldings and high pressure decorative laminates (i.e. Formica). WA40 is also suitable for use with a radio frequency press.

## Characteristics

- Fast setting.
- High bond strength.
- May be used with hot or cold presses.
- Easy to apply by brush, roller or serrated glue spreader.
- Conforms to British Standard BS 4071 in respect of bond strength and resistance to sustained load.
- Conforms to the water resistance requirements of British Standards BS EN204 to category D3.

## Application

### *Bonding conditions*

The adhesive, substrate and ambient temperature should ideally be a minimum of 20°C. The moisture content of the wood materials should be uniform and should not exceed 12%.

### *Spreading*

Tradebond WA40 can be applied by serrated glue spreader, roller or brush. Application is normally to one surface only at a rate of 150g/m<sup>2</sup>

### *Open assembly times*

Maximum 15 minutes depending on the materials to be bonded. Assembly times are dependant on ambient conditions and substrates used.

### *Pressing*

Pressure must be applied whilst the adhesive is still wet and should be a minimum of 30psi (2kg/cm<sup>2</sup>) depending on type of wood and structure.

### *Press times*

Press times required depend on adhesive coating and substrates. Typical figures are:

Hot press:	Decorative laminate / plywood	70°C / 3-5 minutes
Cold press:	Decorative laminate / plywood	20°C / 15-20 minutes

Pressure should be between 30 and 100 psi.

## Application Examples

- Furniture assembly.
- Shop fitting / Bar fitting applications.
- Internal marine applications.
- General joinery applications.
- Window / Door frame construction.

## Shelflife

12 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +30°C.

**PROTECT FROM FROST.**

**Technical Data**

<b>Base:</b>	PVA emulsion adhesive
<b>Consistency:</b>	Medium viscosity
<b>Viscosity @ 23°C:</b>	115 ± 35 (Spindle 6, Speed 20).
<b>Curing System:</b>	Moisture Cure / RF Cure
<b>Colour:</b>	White, Clear when dried
<b>Min. film forming temperature:</b>	8-11°C
<b>Solids content:</b>	46 ± 1%
<b>Specific gravity:</b>	1.09
<b>pH value:</b>	2.5 – 3.5
<b>Cleaning:</b>	Equipment should be cleaned with warm or cold water while the adhesive is still wet.
<b>Packaging:</b>	500g / 1kg / 5kg / 25kg plastic container / 200kg metal drum / 1000kg plastic polybin.

**Transport Information**

<b>Road:</b>	ADR	Free
<b>Maritime:</b>	IMDG	Free
<b>Air:</b>	ICAO/IATA-DGR	Free
<b>UN Number:</b>	None	Does not apply

**Labelling**

No danger labelling required.

**Information**

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 WA40.