



# DUO "2 IN 1" WOOD GLUE

## Water Resistant D3 Wood Adhesive

### Technical Data Sheet



GLUES & ADHESIVES RANGE

CLASS  
EN204 D3;  
BS4071

#### Description:

A ready to use, PVA timber adhesive which is suitable for use in damp and humid conditions. Meets the requirements of BS4071 Creep Resistance standard and EN204, D3.

#### Features & Benefits:

- ◆ **Fast drying.**
- ◆ **Creep resistant.**
- ◆ **High bond strength.**
- ◆ **For internal and external use.**
- ◆ **Conforms to EN204 D3 and BS4071.**

#### Uses

DUO "2 IN 1" WOOD GLUE can be used as a general purpose, joinery adhesive, or for applications where long term resistance to moisture is a pre-requisite of the adhesive. Suitable for hard and soft woods, decorative laminates, chipboard blockwood and other engineered timber panels. It is also suitable for use with RF bonding machinery. Not suitable for permanent immersion in water.

#### Limitations

Do not use on surfaces below +5°C except with RF heating or on timber with a moisture content of above 12%. Timber, which in use will be permanently wet and stressed, should be glued with a thermosetting adhesive.

#### Preparation

All surfaces must be clean, dry, sound and free from dust, grease or contaminants that may hinder adhesion.

#### Application

Apply the adhesive to one surface only and bring the two surfaces together within 3-4 minutes and clamp for approximately 1 hour. After 1 hour careful handling is permissible. Glued components should be left overnight before machining. Remove excess adhesive whilst wet using a damp cloth. Full bond strength is achieved after approximately 24-48 hours.

When using RF bonding techniques the user must explore the most efficient combination of glue application, power and dwell time as each of these varies with different machinery and constructions.

#### Cleaning

Clean any tools after use with warm soapy water.

#### Coverage

Surface bonding 70-150g/m<sup>2</sup> (1L will cover 6m<sup>2</sup>-14m<sup>2</sup>).  
Assembly bonding 150-190g/m<sup>2</sup> (1L will cover 5m<sup>2</sup>-6m<sup>2</sup>).

#### Shelf Life

White liquid.

#### Shelf Life

Minimum 12 months from date of manufacture when stored in original, unopened bottles

#### Storage Conditions

Store in cool, dry conditions between a temperature of +5°C and +25°C. Protect from frost and direct sunlight.

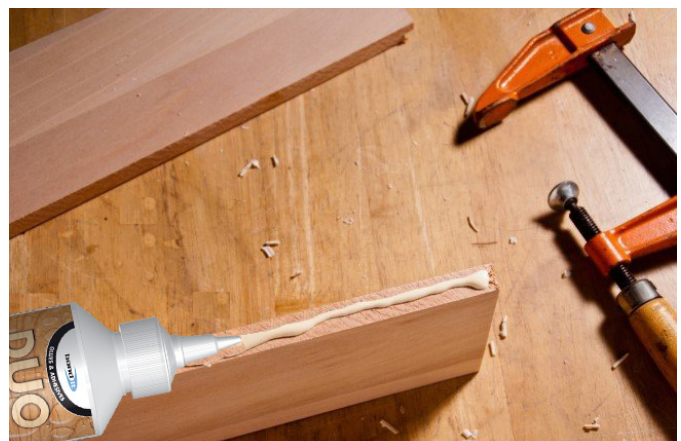
#### Disposal of Containers

Do not leave empty containers where residue could be harmful to children, animals or the environment. Replace lids and remove any containers to a central disposal point in accordance with local regulations. Any spilt material should be mopped up immediately with an inert absorbent material, such as sand.

#### Health & Safety

Please refer to separate safety data sheet (SDS) for full handling, use and storage instructions. Keep out of reach of children. It is the user's responsibility to determine suitability for use. If in doubt, contact our Technical Department for advice.

**Note: this information is for general guidance only, since site conditions and labour are beyond our control.**



## Specification Summary

Appearance	White liquid
Chemical Composition	Aqueous Polyvinyl Acetate Dispersion
Total Solids	50 +/- 1%
Particle Size Range	0.1-2 microns
Solubility in Water	Miscible
pH	2.8-3.6
Viscosity @ +25°C Brookfield RVT spindle 6 20 rpm	9,000 - 15,000 mPas
Minimum Film Forming Temperature	+4°C
Shear Strength (wood to wood)	10N/mm <sup>2</sup>
Full Strength Obtained	24-48 hours after bonding
Density	1.03-1.13g/cm <sup>3</sup>
Commodity Code	3214900000

## Product / Order Details

Code	Colour	Fill	Barcode	UFI
BDA050	White	125ml	5060021364371	-
BDA051	White	250ml	5060021364388	-
BDA052	White	500ml	5060021364395	-
BDA053	White	1L	5060021364401	-
BDA054	White	2.5L	5060021364418	-
BDA055	White	5L	5060021364425	-
BDA056	White	25L	5060021364432	-
BDA057	White	200L	5060021364685	-



## Part of the Bond It Glues & Adhesives Range

**Head Office:** Unit H4, Premier Way, Lowfields Business Park, Elland, West Yorkshire. HX5 9HF.  
**Telephone:** +44 (0)1422 315300 **Email:** salesuk@bonditgroup.com  
**EU Office:** SISL (Bond It) Ireland Limited, 70 Sir John Rogerson's Quay, Dublin 2. **Tel:** +353 1 960 9411  
**Website:** www.bonditgroup.com

**Note:** The data presented in this leaflet is in accordance with the present state of our knowledge, but does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies raw materials are also being used. The recommendations do not absolve the user from the obligation of investigating the possibility of infringement of third parties rights and, if necessary clarifying the position. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the products for a particular purpose.



**Version 6: 08/03/24**  
 Supersedes V5 16/08/22



Certificate Number 6152  
 ISO 9001  
 ISO 14001  
 ISO 45001

**bond it**

An **ASTRAL** Limited Company