

PRODUCT DATA SHEET

SikaBond® PVA Wood Adhesive Ultra

D4 Industrial Grade Cross-Linked PVA Wood Adhesive

PRODUCT DESCRIPTION

SikaBond® PVA Wood Adhesive Ultra is an industrial grade waterproof D4 wood adhesive, suitable for applications under constant water submersion.

Based on the hybrid technology, it contains none of the safety issues associated with conventional isocyanate containing (polyurethane) D4 grades. It can be used internally and externally and provides a high strength, impact and temperature resistant bond that is usually stronger than the wood itself. It dries clear and is ideal for all general woodworking and joinery uses, furniture assembly and household DIY use.

USES

- Woodworking and joinery.
- Furniture assembly.
- Assembly line work.
- Wood on wood laminating.
- Household DIY use.
- As a weatherproof/ creep resistant wood adhesive.
- Interior and exterior use.
- Radio Frequency /High Frequency cure systems.

PRODUCT INFORMATION

Chemical Base	Waterbased Polymer
Packaging	1 L Bottle and 25 L Jerry Can
Colour	White, Dries Clear
Shelf Life	6 months from date of manufacture when stored according to manufacturer's instructions.

CHARACTERISTICS / ADVANTAGES

- Fast bond strength development.
- Suitable for constant water immersion – D4 classification water resistance.
- Will not stain timber.
- Dries clear.
- Water based for easy clean up.
- Suitable for radio frequency cure.

APPROVALS / STANDARDS

Conforms to EN204 class D4 and WATT 91.

Storage Conditions

Store in cool, dry conditions between +15 °C to +23 °C. Ensure containers are well sealed and out of direct sunlight. During storage, slight separation may occur (thin layer above thicker layer). This is an aesthetic rather than technical problem. In this case, mix well before applying. PROTECT FROM FROST.

Density	Approx. 1.07 g/cm ³
pH-Value	Approx. 3
Viscosity	Approx. 5500 cP at +23 °C

TECHNICAL INFORMATION

Thermal resistance	Stable (1 week @ +50 °C)
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APPLICATION INFORMATION

Yield	150 – 180 g/m ² (assembly gluing)
Open Time	8 – 9 mins @ +20 °C and 150 g/m ²

VALUE BASE

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

LIMITATIONS

- Ensure wood doesn't contain excessive moisture (<15 %).
- Not suitable for load bearing applications.
- Do not use at temperatures below +10 °C. Glue will dry to a chalky white finish with poor strength.
- Drying time is extended at low temperatures.
- Clean excess adhesive off glue line after clamping before adhesive dries with a damp cloth.
- Before staining / varnishing, sand off any excess adhesive from the wood.
- Ensure sufficient clamping pressure, especially important with radio frequency bonding.
- Use on Laminates: Only suitable for bonding small porous laminate strips. Do not use on non-porous or large areas of laminate – use Stick2 Contact Adhesive.
- Because of the varied nature of wood components, e.g. area of growth, type of pre-treatment etc., unpredictable discolouration may occur on different types of wood such as cherry, beech and others. In certain oaks, iron and tannin can also give this effect. We recommend you test compatibility before carrying out large scale manufacture.
- Highest levels of water resistance will be achieved not earlier than 7 days after bonding. Avoid water contact until this point.

It is the user's responsibility to determine suitability of use. If in doubt, please contact Technical

Services department for advice.

ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

All surfaces must be clean, dry and free from grease.

APPLICATION METHOD / TOOLS

- Apply adhesive thinly to both surfaces (150-180 g/m²). Do not over apply as this will slow down cure.
- Moisture content of wood must be within 8-15 % w/w.
- Do not use below +10 °C (room or wood temperature).
- Remove excess adhesive with a damp cloth immediately.
- Clamp surfaces together until adhesive dries and support afterwards (initial set in 10 minutes).
- Support until fully cured (Full strength within 8 hours at +20 °C).
- When fitting dowels, the adhesive should be applied to the holes.
- Suitable for radio frequency curing.

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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