



TECHNICAL INFORMATION DORUS EXPRESS

PVA DISPERSION GLUE FOR ASSEMBLY

CHARACTERISTICS

- Medium viscosity
- Fast setting
- Gap filling
- Provides tough-elastic glue joints
- Workable glue joints
- Highest bond strength with wood and furniture gluing
- High moisture resistance in compliance with D2 as per EN 204
- High water resistance through the addition of Dorus R. 397 hardener = Durability class D3 or D4 as per EN 204

FIELDS OF APPLICATION

- Gluing solid wood
- Gluing of block board cores and composed solid wood panels
- Assembly and carcass gluing
- Dowel insertion as well as mortise and tenon gluing
- Gluing of laminate sheets to chipboard, block board and the like
- Edgebanding of veneer, solid wood or HPL edges in stationary presses, either cold or using heating elements

Viscosity @ 20-25°C	approx. 12,500		
pH value	approx. 5		
Minimum Film Formation Temperature (MFFT)	approx. +3°C		
Quantity applied 100 g / m ²	approx. 7 min		
Quantity applied 200 g / m ²	approx. 12 min		
	20°C (68°F)	40°C (104°F)	70°C (158°F)
	from 7 min	from 4 min	from 2 min
Quantity applied 150 g / m ²	from 13 min		
Carcass bonding			
Quantity applied 150 g / m ²	from 8 min		



The data applies to room temperature of 20 °C (68 °F), wood moisture of 8-12 %, relative humidity of 60-70 % and a pressure of 0.5 N/mm² in the press.

The actual open and set times will depend heavily on the working conditions such as temperature, humidity and absorption of the wood, surface characteristics, stresses in the material and application thickness of the glue, etc.

The glue is supplied ready for use. If required, it can be thinned with water up to 3%. The working temperature of the work-piece should be at least +10°C. Ensure that the parts to be bonded are close fitting and free from dust and grease. DORUS dispersion glues themselves do not give rise to discolouration of the wood. Metal parts, however, may cause discolouration, due to their interaction with the tannin of the wood (especially Oak). Usually, application of the glue to one side only is sufficient. Applying to both sides, however, is recommended when the gluing difficult-to-bond woods and hardwood, in order to improve bonding strength; in this case the open time is increased.

DORUS EXPRESS plus 3% R. 397 hardener = durability class D3 according to EN 204

DORUS EXPRESS plus 6% R. 397 hardener = durability class D4 according to EN 204

Above mentioned setting and pressing times are prolonged by approx. 2-3 min upon adding hardener. Glue and hardener should be mixed well and used within approximately 7 hours (pot life).

STORAGE

Shelf life is up to 12 months, if stored cool and dry in the original container. Protect against freezing. Stir well before use.

CLEANING

Wet glue may be removed with water preferably containing a dishwashing agent. Dry glue must be removed mechanically.

PRECAUTIONS

Refer to the Material Safety Data Sheet (MSDS) before handling the product. Follow instructions for safe handling.

DISCLAIMER

Any information given is, to the best of our knowledge, the best currently available, with respect to our products and their use, but it is subject to revision as additional knowledge and experience is gained. Such information is offered as a guideline for experimentation only and is not to be construed as a representation that the material is suitable for any particular purpose or use. Customers are encouraged to make their own enquiries as to the material's characteristics and, where appropriate, to conduct their own tests in the specific context of the material's intended use. This information is not a license to operate under nor is it intended to suggest infringement of any patent. We guarantee a uniform quality standard for this product. The only conditions and warranties accepted by Henkel in relation to this product or process are those implied by either Commonwealth or State statutes.