

TECHNICAL INFORMATION DORUS MD 044-1 YELLOW

PVA Dispersion Glue for Assembly

DESCRIPTION

- Fast setting
- Provides hard-elastic film allowing sanding with minimum gumming of the sanding paper
- Excellent adhesion to all commonly used woods
- Good water resistance (D2)
- Superior water resistance upon adding hardener **DORUS R. 397**
- Durability group according to standard EN 204:
 - DORUS MD 044-1** plus 3 % hardener R. 397 = high water resistance
 - DORUS MD 044-1** plus 6 % hardener R. 397 = excellent water resistance

FIELDS OF APPLICATION

- General-purpose glue for carpenters, joiners and glaziers
- Assembly and carcass gluing
- Cabinet making
- Finger jointing
- Edge gluing of solid wood in clamp carriers or through feed panel composers
- Face gluing of plywood or laminate to particle board
- Edge banding of veneer, solid wood or HPL strips with or without heating bars
- Assembly and dowel & tongue gluing
- Surface gluing of plywood and hardboard where a long open time is required
- Dowel insertion

TECHNICAL DATA

Viscosity @ 20-25°C : approx. 12,500 cps
pH value: 5-8

of the mixture

Viscosity:
plus 3 % hardener R. 397 approx. 15,000 cps
plus 6 % hardener R. 397 approx. 18,000 cps



INSTRUCTIONS FOR USE

Working temperature of glue and material should be above 10 °C (50 °F).

Method of application:

Brush, hand or machine roller

Open time*

approx. 100 g / m²:
approx. 200 g / m²:

approx. 6 min
approx. 10 min

Pressure time*

20 °C (68 °F) 40 °C (104 °F) 70 °C (158 °F)

Face gluing (chipboard / HPL)

approx. 100 g l m²
approx. 200 g / m²

> 7 min
> 12 min

> 4 min

> 2 min

Join gluing (beech / beech)

approx. 150 g / m²
approx. 200 g / m²

> 20 min
> 25 min

Carcass gluing

approx. 150 g l m²

> 12 min

* The data apply 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.

for DORUS MD 044/1 together with R. 397

Pot life of the 2-component mixture: approx 7 hours

** Above mentioned setting and pressing times are prolonged by approx. 2-3 min upon adding hardener.

PACKAGING

Supplied in 20 Lt plastic containers.

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 or with the help of ethyl acetate solvent. If the solvent is used, the application equipment must be resistant to solvents.

LABELLING

Hazardous warning label according to NOHSC not required. For DORUS R. 397 see its datasheet.

PRECAUTIONS

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

TECHNICAL SERVICE

Henkel Adhesives maintains a strong technical support group, to investigate and advise on all adhesion matters. Please contact your local Sales Office.

DISCLAIMER

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