

Fila-Fix* D4 wood glue

Data sheet

Physical state: viscous liquid.

Colour: white.

Odour: weak acetic acid.

Water resistance: according to DIN EN 204-D4.

Strength force: > 10 MPa, according to DIN EN 302-2.

Delamination resistance: according to DIN EN 302-2.

Initial time: 1-2 minutes, when glued parts may be put aside.

Precuring dwell time, allowed before joining gluing parts: 12 minutes.

Full strength (hard woods: oak, beech) after 48 hours.

Thermal dilation: < 10^{-6} K⁻¹ at 25 °C.

Also suitable for gluing of rough surfaces.

The optimal results in wood humidity of about 7 %. For dry woods wetting is desirable.

Enhanced resistance to temperature and humidity up to 110 °C.

Recommended layer thickness: 120-160 g/m².

Recommended pressure exerted to gluing parts: 0.2-0.6 N/cm².

Creeping: 2×10^{-8} m/day at 12.5 MPa and 38 °C, according to DIN EN 302-1.

Viscosity: 20-25 000 cP (mPas) (Brookfield SC4-29). Adjustable on request.

pH: 4.2

Vapour pressure: < 0.8 Pa at 35 °C.

Other properties:

IKEA certificate in furniture manufacture process, data available on request.

Contains no toxic substances, including also isocyanate.

Suitable for gluing hard woods (oak, beech) in out-door application, down to – 45 °C.