

DUVILAX D4 DUPLEX

TWO - COMPONENT WATERPROOF ADHESIVE

Woodworking industry
Furniture industry

Composition:

An adhesive Duvilax® D4 Duplex consists of two components- a dispersed component and hardener. The dispersed component is a special copolymer of vinyl acetate dispersion containing post polymer web. The second component, Hardener D4, is a dilution inorganic aluminous salt in water. Duvilax® D4 Duplex does not pose any health or usage risks (no R-sentences and S-sentences).

Properties:

An adhesive Duvilax® D4 Duplex is a water white- colored dispersion with a characteristic smell. It is non-toxic, incombustible, non-explosive and posing no health or hygienic hazards and biodegradable. The dispersion film is transparent, relatively hard, brittle and non - adhesive.

Usage:

Duvilax® D4 Duplex is waterproof two-component adhesive for wood with speed joint creation. After mixing with Hardener D4 it is used for sticking all types of joint from massive wood (soft and hard), from materials on the base of cellulose (except exotic wood), too. Such a joint can be in exteriors exposed to climactic stress, but with adequate protection of surface, or interior with regular intense influence of water or condensate of air humidity. The joint of this adhesive is determined by methodic given in E 204 in group D4. The dispersion Duvilax® D4 Duplex without hardener is possible to use as usual interior adhesive and its joint is determined by methodic given in EN 204 in group D2.

Adhesive parameters after mixing both components:

Dry matter content	min. 49.0 %	
Viscosity	4 000 – 8 000 mPa.s	(Rheotest)
	10 000 – 20 000 mPa.s	(according to ISO 2555, Brookfield RVT)
pH value	3 – 3.3	
min. film-forming temperature	11°C	
open period	5 – 10 minutes	
joint rigidity in shear (beech-beech) min.	10 MPa	
group of stress EN 204	D4	

Adhesive preparation and fixing conditions:

Adhesive preparation	mix 1 kg Duvilax® D4 Duplex with 50 ml Hardener D4
Adhesive processing after mixing	5 days
Working temperature	min. 15°C, in heating fixing max. 100°C
Adhesive joint type	peg joints, simple barb, ping, on pen-mortise etc.
Adhesive consumption (recommended)	150-200 g/m ²
Way of application	brush, roller, spatula, nozzle
Wood dampness	8 – 12 %
Relative air humidity	65 – 75 %
Press power	min. 0.7 MPa
Press working time	10-30 min. according to type of joint
Drying time at 20°C	cca. 6 hours

Packing:

Packed in 1 kg, 3 kg, 5 kg and 10 kg buckets, 30 kg PE -kegs; 125 kg PE- barrels; 200 kg steel barrels; 1000 kg plastic container

Storage:

Both components of adhesive are stored in original, undamaged, closed packaging at temperature from 5°C to 40°C and must not be exposed to direct sunshine. Longer storage of Hardener D4 at temperature below 10°C can cause creation of white crystals. It is not product defect! In this case, Hardener D4 in bottle put in the water with temperature 50°C and warm very slowly. Be careful, water from bath can not be mixed with Hardener D4.

Guarantee period:

The guaranteed period for the product delivered in packing up to 15 kg gross is 12 month. For the rest of the products it is 6 months, in the case of keeping the storage conditions mentioned above.

The given data are only of an informative character and are not complete. Before each use it is recommended to try an adhesive in concrete conditions. Further information can be obtained at:

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