



TECHNICAL DATASHEET

DANAFIX

Water resistant D3 wood adhesive

Product:**DANAFIX 434**Date of issue: 12.02.2015
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Product Description and Application:

DANAFIX 434 is a PVAc based adhesive for All-round wood gluing application. It is certificated for water resistant class D3 according to DIN EN 204/205. The adhesive is especially suitable for assembling wood which frequently are exposed to variations in temperature and humidity.

DANAFIX 434 is designed with a suitable pH value which avoids discolouration on glue joints as well as on the surface of some wood species. It is fast setting and can be used with cold, hot and HF press. The adhesive does not contain mineral fillers and tools wear is very low.

Application:**Laminating:**
Furniture:.....

DANAFIX 434
●

Dowel-, tenon- & finger jointing:
Furniture:.....

●

Frame wood:.....

●

Types of wood:
Soft (ex. pine):.....

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Hard (ex. beech, oak, teak):.....

●

MDF:.....

●

Chipboard:.....

●

After treatment:
Cutting tools (low wear):.....

●

Base:.....

●

Article Numbers:
20 l bucket:.....

7255

125 l drum:.....

7256

1000 l container:.....

7257

Physical / Chemical Properties:**Adhesive:**
Type:.....

DANAFIX 434
Water based PVAc-dispersion

Colour:.....

White

Solid content [%]:.....

50 ±1 %

Viscosity (Brookf.RVF, 20 rpm) [cP]:.....

9000 ± 1000

Density [kg/ltr.]:.....

1.1

pH:.....

4.4 – 5.5

Shelf life:.....

Minimum 9 months in unopened package if stored cool.
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Glue joint:
Colour:.....

Mat transparent

Directions for use:

Preparation:	<i>Both surfaces must be clean, dry and well adjusted. Optimum results are obtained with newly worked wood.</i>
Application:	<i>The adhesive is applied on one surface. When bonding hard woods, two-sided application is recommended, as well as increasing assembly time and pressing time.</i>
Wood moisture content:	<i>8 - 14 %</i>
Amount of glue:	<i>150-200 g/m² depending on the surfaces and required open time.</i>
Application temperature:	<i>5 - 100 °C</i>
Open time: 20 °C, 50 % RH pine, 9 % moisture	<i>4-5 min. Absorbent materials, less amount of glue, low moisture content in material and air and ventilation will influence the open time.</i>
Pressure:	<i>Soft wood as e.g. conifer wood 0,6-0,8 MPa (6-8 kp/cm²) Hard wood as e.g. deciduous wood 1,0-1,2 MPa (10-12 kp/cm²)</i>
Pressure times, pine approx. 50 % RH, approx. 9 % moisture content of the wood	<i>4-9 min. at 20 °C with a following resting period before further processing. Pressure times should be increased for hard woods, two-sided application, higher humidity of the air and higher moisture content of the wood. The pressing time can be reduced if the wood is preheated. Full water resistant is obtained after 7 days.</i>
Cleaning:	<i>Wet uncured adhesive can be removed with water. Cured adhesive can only be removed mechanically.</i>
Storage:	<i>Adhesive should be stored cool (max. 20 °C) in tightly closed packing. Better protected from frost.</i>

All information's are meant as a guideline. Sufficient test should be carried out to determine final working condition.

Safety:

Hazard Symbols: None
Risk and Safety phrases: None

For further information concerning safety, refer to safety Datasheet.

Further information:

DANA LIM offers a range of adhesives for professionals:

100-series: Upholstering adhesives

200-series: Flooring adhesives

300-series: Wall adhesives

400-series: Wood adhesives

500-series: Sealants & PU-foams

600-series: Building-additives, fillers etc.

700-series: Paper-, packaging- and newspaper adhesives

800-series: Hot melt

900-series: Cleaning-, release agents and hardeners.

The information and data contained in this data sheet are based on extensive laboratory testing and our practical experiences, and are meant for helping the user to find optimum working methods. As the conditions at the user are beyond our control, we make no warranties concerning the results, achieved by the products. The information's in this technical data sheet are typical values, intended as a guideline. They should not be regarded as product specifications. Please also refer to our standard sales conditions and terms of delivery.