



Timber Inspired, Quality Driven

J53 General Grade D3 polyvinyl acetate adhesive

Data Sheet

Xylo J53 D3 is a one part D3 PVA emulsion adhesive, specially formulated for bonding wood. It has a fast set, high bond strength and excellent water resistance. It will bond virtually all woods, wood veneers and high pressure decorative laminates. Xylo J53 D3 can also be used with either hot or cold presses and is also suitable for use with a radio frequency press. It is easily applied by either brush, roller or serrated glue spreader. This adhesive should be tested before use on Fire Retardant wood based panels.

Application and Assembly

Bonding conditions: The adhesive substrate and ambient temperature should ideally be at a minimum of 20°C. The moisture content of wood materials should be uniform and should not exceed 12%.

Spreading: Xylo J53 D3 can be applied by serrated glue spreader, roller or brush. Application is normally to one surface at a rate of 150g/m².

Open assembly times: Maximum of 15 minutes depending on the materials to be bonded. Assembly times are dependent on ambient conditions and substrates used.

Pressing: Pressure must be applied whilst the adhesive is still wet and should be a minimum of 30 psi (2Kg/cm²) depending on the type of wood and structure.

Press times: Press times required depend on adhesive coating and upon substrates. Typical figures are:

Hot Press: Decorative laminate/plywood 80°C / 1mins

Cold Press: Decorative laminate/plywood 20°C / 20 mins



Technical Data

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|-----------------------------------|-----------------------|
| Colour: | White, clear when dry |
| Viscosity: | Medium |
| Minimum film forming temperature: | 2°C |
| Specific gravity: | approx. 1.06 |
| pH: | approx. 3 |

Cleaning

Equipment should be cleaned with warm or cold water whilst the adhesive is still wet.

Storage and Shelf Life

The adhesive should be stored in a cool, dry area at temperatures between 5°C and 30°C. Under these conditions the product has a shelf life of 12 months when stored in the original, unopened container.

Conforms to British Standard 4071 in respect of bond strength resistance to sustained load.

Conforms to the water resistance requirements of BS EN204 to category D3.

DO NOT ALLOW THE PRODUCT TO FREEZE

IMPORTANT NOTE:

All the information in the Data Sheet is based on practical experience and is published in good faith. However, because we have no control over the manner or conditions in which our products are used, or over work undertaken or end product manufactured by the purchaser, we cannot accept liability for results. Responsibility for ascertaining the suitability of products for his purposes rests with the purchaser. All conditions, representations, statements, warranties or guarantees whatsoever, whether express, implied or statutory, in respect of any goods manufactured, sold or supplied by us are hereby expressly excluded and we accept no liability in respect of any claim for damage or consequential loss caused to any property arising directly or indirectly out of the use of our products or goods.

Xylo is a Toolfix Joinery & Construction Supplies Ltd brand.

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(Page 1 of 1)