



Timber Inspired, Quality Driven

J54 External Grade D4 polyvinyl acetate adhesive

Data Sheet

Xylo J54 D4 is a one part D4 PVA emulsion adhesive, specially formulated for bonding wood. It has a fast set, high bond strength and excellent water resistance. It has a short press time and transparent glue line and can be used for the bonding of windows and doors, for stair bonding, for surface bonding of partitions and parts, bonding of tenon and finger joints, hard and exotic timbers and HPL sheets.

Xylo J54 D4 can be used with either hot or cold presses. It is easily applied by either brush, roller or serrated glue spreader or by spray. Application tools must be made from stainless steel or plastic.

Application and Assembly

Bonding conditions: The adhesive substrate and ambient temperature should ideally be between 18°C and 20°C. The moisture content of wood materials should be uniform and should be between 8% and 12%. Do not process below 15°C.

Spreading: Xylo J54 D4 can be applied by serrated glue spreader, roller, brush or by spray. Application is normally to one surface at a rate of 150g/m² when applied manually, 100g/m² when applied by machine, depending on the substrate. Double sided application is recommended for hard woods.

Open assembly times: Maximum of 4-7 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. 0.2 - 0.4 N/mm² for flat bonding, 0.7 - 1.0 N/mm² for laminating and chip board bonding.

Technical Data

Colour:	White, clear when dry
Viscosity:	Medium
Specific gravity:	approx. 1.06 g/cm ³
pH: approx.	3
Open Time:	4-7 minutes @ 20°C
Chalk point:	approx. 10°C

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 6 months when stored in the original, unopened container.

**Conforms to the water resistance requirements of BS EN204 to category D4
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.

