

# WOODLOK 2500 Premium D3 Crosslinking Adhesive

WOODLOK 2500 is an Interior / Exterior Crosslinking PVA that provides superior heat and moisture resistance over PVA and Aliphatic formulations and meets the strict International Standard EN-204 D3 for water resistance. WOODLOK 2500 cures to give high strength resilient bonds on particleboard, MDF, softwoods and hardwoods. WOODLOK 2500 is suitable for finger jointing, veneering, edge & face gluing, doweling, and interior & exterior Joinery. WOODLOK 2500 can also be used for lamination and post forming of High Pressure Laminates (HPL) to MDF & particleboard in hot and cold presses.



## PHYSICAL & CHEMICAL PROPERTIES:

Chemical Description :	Crosslinking PVA Emulsion
Appearance :	White / Wet Clear / Dry
Typical Viscosity:	4,500cps @ 25°C
pH :	3.3
Solids Content	48%
Coverage :	120gm m <sup>2</sup> = 8.3m <sup>2</sup> 240gm m <sup>2</sup> = 4.16m <sup>2</sup>
Open Time @ 20°C	5 minutes *Depending on Substrate
Minimum Use Temperature :	5°C
Shelf Life :	12 Months
Sizes:	500ml Pro Bottle, 5ltr Jerry Bottle 20kg Pour Top Pail, 210kg Drum

## APPLICATION RECOMMENDATIONS :

For best results, temperatures should be above 15°C for both the work area and the stock being used.

## MOISTURE CONTENT :

Moisture content of wood may run as high as 15% but best bonds are obtained when moisture content ranges between 8% and 12%.

## SUBSTRATE PREPARATION :

All surfaces to be glued must be clean and dry. Remove all oil, grease, wax, old glue, finish or other foreign material before gluing. Generally, wood requires no special preliminary treatment, however, the most efficient bonds develop when the wood has been resurfaced just prior to applying glue with sharp blades.

## ADHESIVE SPREAD RATE :

120gm—240gm m<sup>2</sup> of glue line is recommended depending on substrate.

## ASSEMBLY :

Wood surfaces should be smooth and snug fitting. Avoid excessive sanding or handling of the joint surface. Spread glue evenly onto the surface and assemble within 5 minutes and clamp if possible. Assembly time (from application of glue to application of pressure) should not exceed 7 minutes, and in general, should be as soon as possible after glue application.

## PRESS SCHEDULES :

The following settings have been found to be generally suitable for laminating HPL to MDF in press equipment :

**Cold Press :** 30 minutes @ 23°C  
60 minutes @ 15°C

## Hot Press :

Adhesive Coat Weight : 70 - 80gm<sup>2</sup>  
Press Temperature : 80°C  
Press Time : 2 minutes  
Pressure : 100 - 150 psi

## RF Cure :

A LOW power setting is preferred to produce workable amperage without arcing. A minimal change after the initial amperage drop-off will indicate adhesive is sufficiently set.

## BEST RESULTS :

Work glue into the pores of both wood surfaces especially when working with end grain. Apply sufficient glue to result in squeeze out when parts are assembled.

## CLEAN UP :

If brushes and applicators are kept wet with glue until ready for cleaning they can be easily cleaned with water. Squeeze out excess glue while still fluid and remove with a clean cloth dampened with water. Cured glue must be cut, scraped or sanded away.

## HANDLING & STORAGE :

Keep lids on the containers when not in use to avoid glue contamination. Product should be stored between 5°C and 25°C on a wooden pallet and kept from freezing. Keep out of direct sunlight and away from sources of heat. If the product has been left for prolonged periods between uses, stirring the product is recommended.

## DISPOSAL :

When the container is empty, remove the lid and allow any adhesive residue to dry. Dried residue and container can be disposed of in normal rubbish.

INDUSTRIAL GRADE ADHESIVES FOR THE PROFESSIONAL

# WOODLOK™

# WOODLOK 2500 Premium D3 Crosslinking Cont.

The suitability of **WOODLOK 2500** for some Exotic timbers, (e.g.: Teak, Rubber wood) and local timber species such as Totara or Matai should be fully tested by the user.

**HANDLING & STORAGE :**

Keep lids on the containers when not in use to avoid glue contamination.  
 Product should be stored between 5°C and 25°C on a wooden pallet and kept from freezing.  
 Keep out of direct sunlight and away from sources of heat.  
 If the product has been left for prolonged periods between uses, stirring the product is recommended.

**DISPOSAL :**

When the container is empty, remove the lid and allow any adhesive residue to dry.  
 Dried residue and container can be disposed of in normal rubbish.

**SHELF LIFE:**

Best used within 12 months from date of manufacture when stored under the above conditions in the original unopened containers.

**WOODLOK PRODUCT RANGE**

There are other adhesives within the WOODLOK range. These all have different attributes and need to be selected according to your requirements.

**WOODLOK 2200 Aliphatic Resin**

Cost effective Aliphatic with long open time of up to 15 minutes. Excellent for laminating full sheets of MDF and Particleboard. General purpose

**WOODLOK 2300 Premium Aliphatic Resin**

High strength, fast setting Aliphatic for general use. Excellent all-rounder and our most popular WOODLOK aliphatic resin.

**WOODLOK 2400 Hardline Aliphatic Resin**

High strength, fast setting Aliphatic which dries to a hard glue line. Best sandability.

**WOODLOK 2500 D3 Crosslinking Adhesive**

Water resistant (D3) crosslinking adhesive cures to form a tough, heat resistant (100°C) bond. Excellent all-round to interior and exterior use. Used for bonding HPL laminate to MDF or particleboard.

**WOODLOK 2550 D3 Crosslinking High Viscosity**

Higher viscosity (thicker) version of the WOODLOK 2500 Crosslink. Longer open time.

**WOODLOK 3150 Melamine Adhesive (NEW)**

Ready to use, single pack adhesive formulated for bonding synthetic laminated panels (Melamine) to MDF, particleboard and other porous substrates. Easy to apply and dries clear.

**WOODLOK 3010 - 10min / 3030 - 30min / 3090 - 90min**

Next generation thixotropic gel polyurethane construction adhesive. Waterproof. Ready to use, single part adhesive uses the latest technology to deliver extreme bond strength and hard glue lines. Easy to dispense 300ml standard cartridges in three cure speeds.

**WOODLOK 3500 - 4hour / 3600 - 30min**

Moisture cure interior / exterior liquid polyurethane adhesive. Waterproof and resistant to heat and chemicals. Bonds virtually any surface like metals, stainless steel, wood, stone, glass, most plastics and other difficult surfaces.

**WOODLOK 8000 Marine Grade Structural Epoxy**

Easy mix 1:1 thixotropic epoxy for bonding wood, concrete, fibreglass, stone and marble, metals and some plastics

**WOODLOK GLAZEAWAY Solvent Cleaner**

Solvent for final cleaning PVC edges and counter tops.

**WOODLOK DSOLVAWAY Citrus Cleaner**

Citrus cleaner for final cleaning PVC and ABS Edges and tops. Low odour, high performance surface cleaner.

