

WOODLOK 2400 Hardline Aliphatic Resin

WOODLOK 2400 is a premium, fast setting Aliphatic Resin that can be used in temperatures down to 5°C.

The bonds formed are heat and moisture resistant.

WOODLOK 2400 is formulated to provide high strength bonds with minimal creep on softwoods and hardwoods and is suitable for edge and face gluing, laminating and general assembly work.

WOODLOK 2400 has excellent machining and sanding properties due to its high heat resistance and hard glue line when fully cured.

Water clean-up. For interior use.



PHYSICAL & CHEMICAL PROPERTIES:

Chemical Description :	Aliphatic Resin Emulsion
Appearance :	Light Tan
Typical Viscosity:	8,000cps @ 25°C
pH :	4
Solids Content	48%
Coverage :	120gm m ² = 8.3m ² 240gm m ² = 4.16m ²
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 m² of glue line is recommended depending on the porosity of the 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.
Length of time glue may be exposed to air is determined by the

absorptivity of the substrates, moisture content and relative humidity of the air.

Clamp or weight for a minimum of 30 minutes but for best results clamp for as long as possible.

Excess glue should be removed with a damp cloth. Allow to dry overnight before sanding if possible.

PRESSURE :

May range from 25 to 100 lbs. per square inch. Soft wood and carefully cut hard woods can be glued at relatively low pressure e.g. 25—50lbs. A carefully machined, close fitting joint requires much less pressure than a rough fitting one. Pressure may be applied by using spring clamps, “C” clamps, wood clamps, inflated bags, mechanical or hydraulic presses.

SETTING TIME :

The pressure period will vary between 30 minutes to 2 hours, depending on the species of wood, thickness of the lay-up, temperature and relative humidity at the time of gluing. Generally, the higher the pressure the lower the clamp time and vice versa.

Heat may be used to accelerate the drying period if desired. Drying chambers, heat lamps, hot presses or other suitable methods for heating are acceptable.

If heat is used, the assembly must be held under pressure until sufficiently cooled to maintain bond.

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.
On rough or uneven cuts, double the coat weight.
Brush glue into end grains with a stiff brush.

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.

INDUSTRIAL GRADE ADHESIVES FOR THE PROFESSIONAL
WOODLOKTM

WOODLOK 2400 Hardline Aliphatic Resin Cont.

SPECIAL NOTE :

The suitability of **WOODLOK 2400** 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.

