

# WOODLOK 3500 Polyurethane Glue

WOODLOK 3500 is a moisture curing polyurethane adhesive formulated for interior and exterior applications.

Used primarily as a wood glue, it can also be used to bond almost any other substrate provided one of them is porous. WOODLOK 3500 is commonly used for timber joinery, windows, doors, furniture and marine applications.

WOODLOK 3500 can also be used for manufacture stainless steel bench tops, sandwich panels, plywood panels etc. A slight foaming occurs whilst curing which drives the adhesive into the fibres of timber or other porous surfaces. The cure film sand wells and accepts stains and lacquers. Interior / Exterior



## PHYSICAL & CHEMICAL PROPERTIES:

Chemical Description :	Polyurethane
Appearance :	Honey
Typical Viscosity:	2,500cps @ 25°C
Solids Content	100% (Solvent Free)
Coverage :	6 - 8m <sup>2</sup> per ltr
Open Time @ 20°C	15 minutes
Cure Time @ 20°C	4 hours
Shelf Life :	12 Months
Sizes:	500ml Pro Bottle 5ltr Jerry Bottle

## APPLICATION RECOMMENDATIONS :

For best results, temperatures should be above 10°C for both the work area and the stock being used.

## MOISTURE CONTENT :

Moisture content of wood may run as high as 20% 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 :

Coverage of 6m<sup>2</sup> per litre when laminating.

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.

Wipe one side with a damp cloth and apply adhesive to the opposite side.

Spread glue evenly onto the surface and assemble within 10-15 minutes and clamp if possible.

Assembly time (from application of glue to application of pressure) should not exceed 15 minutes, and in general, should be as soon as possible after glue application.

Apply sufficient glue to result in a small amount of squeeze out when parts are assembled.

Allow squeeze out to foam and cure as it is easier to remove in this form.

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 120 minutes but for best results clamp for as long as 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 spring clamps, "C" clamps, wood clamps, inflated bags, mechanical or hydraulic presses.

## SETTING TIME :

The pressure period will be 4 hours, depending on the species of wood, thickness of the lay-up, temperature and relative humidity at the time of gluing.

## SPECIAL NOTE :

The suitability of WOODLOK 3500 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.

## CLEAN UP :

Use Acetone for cleaning tools and spills.

Always wear gloves when using this product.

Cured glue can be cut, scraped or sanded away.

INDUSTRIAL GRADE ADHESIVES FOR THE PROFESSIONAL  
**WOODLOK**<sup>TM</sup>

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**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 9 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.

