



Technical Bulletin

2400 Boston Street, Suite 200, Baltimore, Maryland 21224
Phone: 410-675-2100 or 800-543-3840

Revised: 9/20/01

DAP® WELDWOOD® Plastic Resin Glue

- Excellent for craftsman and artisans
- Forms a bond stronger than the wood itself
- Water activated

Packaging: 1 lb, 4.5lb
Color: Tan
UPC Number: 00203,00204

Company Identification:

Manufacturer: DAP Inc., 2400 Boston St., Baltimore, Maryland 21224
Usage Information: DAP HELPLINE: 888-DAP-TIPS, 9:00 am to 7:00 pm EST.
Order Information: 800-327-3339
Fax Number: 410-534-2650

Also, visit the DAP website at www.dap.com.

Product Description:

DAP® WELDWOOD® Plastic Resin Glue is a powdered, pre-catalyzed water-activated glue designed to provide strong, durable bonds for wood and wood products. Plastic Resin Glue is an excellent glue for the craftsman, artisan or hobbyist.

Suggested Uses:

Ideal for:

* Veneering	* Laminating
* Cabinet Work	* Edge Gluing
* General Woodworking Applications	

Bonds laminates to:

* Wood	* Plywood
* Particleboard	

Excellent for:

* Chopping Blocks	* Cutting Boards
* Counter Tops	* Plates
* Furniture	

Performance Characteristics:

- Forms a high strength, water-resistant bond.
- Resistant to fungi, bacteria, oil, gasoline, or solvents.

Surface Preparation & Application:

Temperature of the surface and working area, as well as the adhesive, must be above 70°F. Preferred moisture content of wood is 6% to 10%. Make sure the surfaces to be bonded are clean, dry and free of oil, wax and foreign materials. Do not use containers or tools of copper or copper bearing alloys to mix adhesive.

Mix by weight or by volume in these ratios:

	<u>WEIGHT</u>	<u>VOLUME</u>
Powder	10 parts	10 parts
Water	6 parts	4 parts

Mix by adding powder to approximately 2/3 of the total water, then add the remaining water. Once mixed, the mixture begins curing immediately, although a “pot life” of up to 4 hours exists. Pot life will be affected by temperature as such:

	<u>TEMPERATURE</u>			
	<u>70°F</u>	<u>80°F</u>	<u>90°F</u>	<u>100°F</u>
Pot Life (hours)	4	2.5	1	.5

Once the glue is applied, pressure should be applied. Soft wood and machined hard woods can be glued at low pressures (50 PSI). Rough cut parts require more pressure (175 to 300 PSI) for softwood and hardwood respectively. Sufficient adhesive should be applied so that some squeeze out of excess adhesive is visible at edges. Glue line thickness should be from 0.003 + 0.006 inch for best results.

Pressure should be continued for these lengths of time:

	<u>TEMPERATURE</u>					
	<u>70°F</u>	<u>80°F</u>	<u>90°F</u>	<u>100°F</u>	<u>120°F</u>	<u>140°F</u>
Pressure Period (hours)	13	8	5	3-1/4	1	1/2

FOR BEST RESULTS

Physical & Chemical Characteristics:

Base:	Urea - Formaldehyde Resin
Volatile:	Water
Flash Point:	>200°F
Solids:	60.6% (When mixed)
Bulk Density:	5 lbs. per gallon Powder
Odor:	Slight formaldehyde odor
Color:	Amber
Consistency:	Thick liquid (When mixed)
Useful Temperature Range:	70°F Minimum
Bond Strength:	Block shear, 2,800PSI minimum, ASTM D 905
Pot Life:	2-4 hours
Freeze/Thaw Stability:	Stable
Shelf Life:	One year minimum - dry powder
Viscosity:	1200 - 3,000 CPS (When mixed)
Storage:	Store in cool dry place
Coverage:	One pound adhesive powder plus water at .0006 inch glue line covers about 40 square feet

MSDS No. 30201

Clean Up:

Clean up with water before mixture hardens. Once cured, Plastic Resin Glue cannot be removed from most surfaces successfully; sanding scraping or chiseling may be successful. Test an inconspicuous area before proceeding. Rinse all equipment with clean water after use.

Safety:

See product label or Material Safety Data Sheet for safety information. You can request an MSDS sheet by calling 888-DAP-TIPS or by visiting our website at www.dap.com.

Warranty Information:

If not satisfied with product performance when used as directed, return used container and sales receipt to DAP Inc., Technical Customer Service, 2400 Boston St., Baltimore, MD, 21224, for product replacement or sales price refund. DAP will not be liable for incidental or consequential damage.