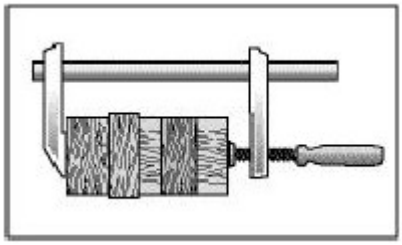
Technical Information
DORUS MD 072



PVAc Dispersion Glue for Assembly
Water resistant as per D3 and D4 / EN 204

Characteristics
- Medium viscosity
- Fast setting
- Long open time
- Gap filling
- Gives transparent, tough-elastic glue joint

- High water resistance one component = Durability class D3 as per EN 204,
  plus DORUS R. 397 hardener (5%) = Durability class D4 as per EN 204
  plus DORUS R. 476 hardener (5%) = Durability class D4 as per EN 204

Fields of application
- Joints were increased water resistance is required
- Gluing solid wood
- Gluing of blockboard cores and composed solid wood panels
- Doors and stairs
- Windows, window scantlings, composite window elements
  (For fleece-backing and veneering we recommend DORUS D3 Express.)

Technical data

Basis:	polyvinylacetate
Colour:	white, transparent after drying
Viscosity (Brookfield, 20 rpm):	approx. 13 000 mPa·s
pH value:	approx. 3,5
Minimum film formation temperature (MFFT):	approx. + 5 °C (+ 41 °F)

Instructions for use

Open time (beech/beech)	
Quantity applied 150 g/m²:	approx. 10 min
Quantity applied 200 g/m²:	approx. 20 min
Pressing time	
- Surface bonding (Chipboard/HPL)	
Quantity applied approx. 100 g/m²:	from 10 min
Quantity applied approx. 200 g/m²:	from 20 min
- Joint bonding (beech/ beech)	
Quantity applied approx. 150 g/m²:	from 25 min
Quantity applied approx. 200 g/m²:	from 35 min

The data shown is based on 8-12 % wood moisture, 20 °C room and material temperature, 65 % relative air humidity and 0.5 N/mm² pressure.
The actual open and setting times will depend heavily on the working conditions such as temperature, humidity and absorption of the wood, surface characteristics, stresses in the material and application thickness of the glue, etc.
The glue is supplied ready for use. If required, it can be thinned with water up to 3 %.

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The working temperature of the workpiece and glue should be at least + 12 °C.
Ensure that the parts to be bonded are close fitting and free from dust and grease.
Fit tolerances increase the setting time and reduce the bonding strength.
Due to the acidic character gluing with D3 and D4 dispersion glue can give discoloration of acid sensitive wood species (e. g. pine).
Metal parts may cause discoloration, due to their reaction with the tannin of the wood (especially with oak).
Usually, application of the glue to one side only is sufficient. Applying glue to both sides, however, is recommended when gluing difficult-to-bond woods and hardwood, in order to improve bonding strength; in this case the open time is increased.

Glue/Hardener Mixture
DORUS MD 072 plus 5 % R. 397 hardener = durability class D4 according to EN 204
Glue and hardener should be mixed well and used within approx. 7 hours (pot life).

Glue/Hardener Mixture
DORUS MD 072 plus 5 % R. 476 hardener = durability class D4 according to EN 204
Glue and hardener should be mixed well and used within approx. 3-4 hours (pot life).

The setting and pressure times of the glue/hardener mixture are – depending on the amount of hardener used – about 2-3 min longer than DORUS MD 072 glue without hardener.

Cleaning

Equipment used to apply the glue may be cleaned easily using cold or luke-warm water before the adhesive has dried hard. Hard dried glue remnants have to be removed mechanically.

Storage

Store in the original tightly closed container in a cool, dry place away from frost. Stir well before use. Storage life up to 12 months.

Labelling

Not required according to GefStoffV and EU Directives.
For hardener DORUS R. 397 see extra datasheet.
For hardener DORUS R. 476 see extra datasheet.

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