



Technical Bulletin

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DAP® WELDWOOD® Carpenter's Wood Glue

- Professional quality
- Heat, water and solvent resistant
- Sets fast and sands easily once dry

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 Carpenter's Wood Glue is a professional grade aliphatic resin premium glue that provides fast, strong bonds for most porous and semi-porous materials.

Suggested Uses:

Ideal For

- Woodcraft
- Cabinet Making
- Hobby & Craft Activities
- Furniture Manufacturing
- Edge-Bonding and many other uses where a high strength, long lasting bond is required

Bonds:

- Plastic Laminates to Wood, Plywood and Hardboard
- Porous and Semi-Porous
- Leather and similar materials to themselves or wood, hardwood, cloth or cardboard bases

Performance Characteristics:

- Resistant to oil, grease, and paint solvents.
- Does not dull cutting tools.
- Especially resistant to shock and sharp impact when thoroughly set.
- Sands well.
- Immersion in water for short periods will have a softening effect on the bond. When allowed to dry, all the original strength is recovered.

Surface Preparation & Application:

- All surfaces to be glued must be clean and dry. Remove all oil, grease, wax, old glue, finish or other foreign material before gluing.

- Temperature should be 55°F or above. Optimum temperature range is 70°F to 80°F.
- Wood requires no special preliminary treatment; however, the most efficient bonds develop when the wood has been resurfaced just prior to applying glue.
- Moisture content of wood may run as high as 15% but best bonds are obtained when moisture content ranges between 8% and 12%.
- **FURNITURE JOINT GLUING:** Wood surfaces should be smooth and snug fitting. Avoid excessive sanding or handling of joint surfaces. Spread glue evenly onto surfaces, assemble within 5 to 7 minutes and clamp if possible. Clamp or weight for a minimum of 30 minutes. Allow to dry overnight before sanding and handling.
- **WOOD AND COMPOSITION BOARD:** Soft wallboard, Celotex, etc., should be presized with diluted glue before gluing (equal parts of water and glue). Allow haze to disappear and then apply full strength to board surface. Press together. Allow to remain undisturbed at least one hour.
- **HARDBOARD LAMINATION:** Apply glue to one surface. Use sufficient pressure to assure contact of all gluing surfaces. When glue becomes colorless, a full strength bond has been formed. Tempered hardboard produces the best results when scuff-sanded before applying glue.
- **NOVOPLY:** Use a thin uniform coat of glue on one surface. Bonding time same as wood to wood.
- **REPAIR GLUING:** Remove all old adhesive or finish. Coat all surfaces with glue, assemble parts and clamp. Allow to dry overnight. Excess glue should be removed immediately with a damp cloth prior to drying.
- **ASSEMBLY:** Assembly time (from application of glue to application of pressure) should not exceed 10 minutes, and in general, should be as soon as possible after glue application. Length of time glue may be exposed to the air is determined by the absorbtivity of the substrates, moisture content and relative humidity of the air.
- **PRESSURE:** May range from 25 to 100 lbs. per square inch, depending upon the fit of the joint. Soft wood and carefully cut hard woods can be glued at relatively low pressure. A carefully machined, close fitting joint requires much less pressure than a rough fitting one. Pressure of 25 to 50 lbs. per square inch is usually sufficient on well fitted parts. Higher pressures are necessary for rough cut joints. However, high bonding pressure does not compensate for poor fitting joints. Pressure may be applied by spring clamps, “C” clamps, wood clamps, inflated bags, mechanical or hydraulic presses. Excellent for glue-nail constructions.
- **SETTING TIME:** Almost immediately for fabrics and paper. On flat laminations and tight fitting joints, pressure may be released before glue has completely set if rough handling is avoided. The pressure period will vary from 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. Pressure periods for spruce, mahogany, poplar, maple and birch are approximately the same. Under normal conditions, joint reaches maximum strength in 72 hours.
- Heat may be used to accelerate the drying period if desired. Drying chambers, heat lamps, hot press platens, heat rooms, or any suitable method for imparting heat to the assembly is acceptable. If heat is used, the assembly must be held under pressure until sufficiently cooled to maintain bond.

FOR BEST RESULTS

- **Work** glue into the pores of both wood surfaces. Apply sufficient glue to result in squeeze out when parts are assembled.
- On rough or uneven cuts, a double application may be necessary.
- Spread thinly for fabrics, canvas, paper, etc. Use heavier spread for wood joints.
- Use a stiff bristle brush, mechanical glue spreader or spray. Dampen brush bristles with glue just prior to spreading for uniform brush coating.
- Large surfaces can be sprayed. The consistency of glue can be adjusted for spraying by thinning with clear water not to exceed 15% (100 parts glue to 15 parts water).
- Do not expose to lacquer thinner

Physical & Chemical Characteristics:

Appearance: Light Yellow (Dries Clear)
Base: Aliphatic Resin
Weight/Gallon: 8.8 lbs./gal.
Solids: 44%
Coverage: Approximately 225 sq. ft./gallon
(25-30 sq. ft./lb. of glue, or 35-40
lbs./1000 sq. ft. of glue line)
Consistency: Medium Cream
Carrier: Water
Flash Point: T.C.C. - None
Freeze/Thaw: 5 cycles 0°F
Shelf Life: 12 months
Average Shear Values: 2800 psi (ASTM D-905 Blockshears)
Packaging:

<i>UPC</i>	<i>Size</i>
00489	4oz
00490	8 oz
00491	Pint
00492	Quart
00493	Gallon
00494	5 Gallon

MSDS No. 30207

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 or scraped away.

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.