



TECHNICAL DATA SHEET

2400 Boston Street | Suite 200 | Baltimore, MD | 21224

DAP® WELDWOOD® Plastic Resin Glue

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.



PACKAGING	COLOR	UPC
1lb	Amber	7079800203
4.5lb	Amber	7079800204
300lb	Amber	7079800208

KEY FEATURES & BENEFITS

- **Excellent for Craftsman and Artisans**
- **Forms a Bond Stronger Than the Wood Itself**
- **Ideal for Interior Wood Applications**
- **Water Resistant**
- **Low Odor**
- **Long Working Time**
- **Water-Activated**

SUGGESTED USES

Ideal for Interior use on:

- Veneering
- Edge Gluing
- Laminating
- General Woodworking
- Cabinet Work

Applications:

- Bonds laminates too:
 - Wood
 - Plywood



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- Particle Board

Excellent for:

- Cutting Boards
- Interior Doors & Trim
- Countertops
- Cabinetry
- Furniture
- Hobby & Craft

APPLICATION

MIXING DIRECTIONS

<u>Mixing Ratios</u>	<u>By Weight*</u>	<u>By Volume</u>
Powder	5 Parts	5 Parts
Water	3 Parts	2 Parts

* Mixing by weight is recommended.

PREPARATION

1. Surfaces should be clean, dry, smooth, and free from all foreign material.
2. Water temperature must be between 68°F (20°C) and 100°F (38°C). Higher water temperature will result in shorter working time.
3. Measure powder and water into separate containers.
4. Add powder slowly to the water while mixing continuously until uniform mix is achieved. Final consistency should be a smooth, creamy paste.
5. If mixture does not combine to smooth consistency, or mixture results in a gritty or lumpy texture, product may no longer be suitable for use.

APPLICATION:

1. Apply a thin coat of glue mixture. Application of glue on only one of the bonding surfaces is generally sufficient. Use a paint brush, paint roller, 1/32" notched trowel, spray gun or conventional glue spreader.
2. Clamp or screw bonded materials together with sufficient pressure forcing excess glue from joints to release trapped air bubbles and ensure maximum adhesive coverage between surfaces. Refer to table below for recommended clamp times.
3. Clamping Pressure Required: 50 PSI for softwood or well machined hardwood; 175 PSI for rough cut softwood materials; 300 PSI for rough cut hardwoods. Finished glue line thickness should be from 0.003 + 0.006 inch for best results.

WORKING TIMETABLE

	<u>70°F</u>	<u>80°F</u>	<u>90°F</u>
<u>Temperature</u>	<u>(21°C)</u>	<u>(27°C)</u>	<u>(32°C)</u>



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Mixture Pot Life (hours)	4 - 5	2.5 - 3.5	1 - 2
Maximum Assembly Time			
OPEN (glue set time before bonding) (min)	15	10	5
CLOSED (after bonding, before clamping) (min)	25	15	8
Minimum Clamping Pressure Period (hours)	14	8	5

*Note that if the full 15 mins. Is used for OPEN time, CLOSED time may not be used.

- Temperature of the surfaces to be bonded, working area, and adhesive must be maintained at 70°F (21°C) or above while working and during setting period.
- Assembly can be lightly machined upon release from pressure. Full bond strength and moisture-resistance develops after curing at room temperature for 7 days.

COVERAGE: One pound of Plastic Resin Glue powder combined with 9.5 fl. Oz. of water will yield approximately 2.5 pints of glue mixture. This volume should be sufficient to cover approximately 40 square feet with a thin coat of adhesive.

TYPICAL PHYSICAL & CHEMICAL PROPERTIES

Base:	Urea- Formaldehyde Resin
Volatile:	Water
Flash Point:	>200°F
Solids:	60.6% by Weight
Weight/Gallon:	5 lbs./gal powder
Viscosity:	1200-3,000 CPS (When mixed)
Color:	Amber
Consistency:	Thick liquid (when mixed)
Useful Temperature Range:	70°F minimum
Pot Life	2-4 hours
Bond Strength:	Bond shear, 2800 PSI minimum ASTM D 905
Freeze/Thaw Stability:	Stable
Coverage:	1 lb. powder plus 9.5 fl oz water yields approx. 2.5 pints adhesive for about 40 sq. ft. coverage with .0006 inch glue line.
Shelf Life:	12 months – properly stored dry powder



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CLEAN UP & STORAGE

Clean up tools and surfaces with water before mixture hardens. Once cured, Plastic Resin Glue cannot be fully removed from most surfaces successfully; sanding, scraping, grinding, chiseling, or other similar mechanical removal methods will be required. Test an inconspicuous area before proceeding. Store in cool dry place with lid tightly sealed. Avoid humid storage conditions and moisture exposure.

SAFETY

See product label and Safety Data Sheet (SDS) for health and safety information. You can request an SDS by visiting our website at dap.com or by calling **1-888-DAP-TIPS**.

WARRANTY

If product fails when use as directed within one year of purchase, DAP will provide replacement product or refund sales price: call 1 (888) DAP TIPS, with your sales receipt and product container available, to arrange for warranty fulfillment. DAP is not liable for incidental or consequential damages.

COMPANY IDENTIFICATION

Manufacturer: DAP Products Inc., 2400 Boston Street, Baltimore, Maryland 21224

Usage Information: Call **1-888-DAP-TIPS** or visit dap.com & click on "Ask the Expert"

Order Information: 800-327-3339 or orders@dap.com

Fax Number: 410-558-1068

Also, visit the DAP website at dap.com