



# SCHEDA TECNICA - DATA SHEET

## NUNIVIL 1004

### GENERALITIES

Special PVA glue for wet-resistant gluing in compliance with standards EN204-205 D3 and test WATT91 . Combined with 5% hardener 302 or 303, 7 days after bonding it complies with the standards EN204-205 group D4.

### APPLICATIONS

It is used wherever special water resistance is required, for gluing windows and doors, kitchens and bathroom furniture made of soft and hard woods, for wooden panels covering with plastic laminate, paper and veneer by cold and hot presses.

### CHARACTERISTICS

FORM	white liquid - yellow liquid	
VISCOSITY Brookfield at 23°C s6/20rpm	10000 - 18000	mPa·s
MINIMUM FILM-FORMING TEMPERATURE	+5	°C
pH at 23°C	2,5 - 3,5	
OPEN TIME at 20°C	7 - 9	min

POT LIFE at 20°C WITH HARDENER 302	approx. 6	hours
POT LIFE at 20°C WITH HARDENER 303	approx. 1	hours

### FOR BEST RESULTS

WOOD, ROOM AND GLUE TEMPERATURE	18 - 22	°C
WOOD HUMIDITY CONTENT	9 - 12	%
RELATIVE HUMIDITY	65 - 75	%
COATING	150 - 300	g/m <sup>2</sup>
SETTING TIME at 20°C	20 - 30	min
SETTING TIME at 80°C	60 - 80	s

### GLUE APPLICATION

By means of glue applicator with rollers, spatula, brush, nozzle also with pressure systems.  
Clean glue applicators and equipment with hot water.

### WARNING

In order to comply with the standards EN204-205 D4, the glue must be spread on both jointing surfaces and coating must not be less than 80-100 g/m<sup>2</sup> for each surface.

Do not use the product in case the glue joint is exposed directly to the sun light.

When bonding woods with a high tannin content, the glue joint may become dark.

Do not use iron materials.

### PACKAGING

Jerry-cans of 25 kg; plastic-buckets of 30, 10 and 5 kg; tanks of 1000 kg.

Hardener: cans of 0,5 kg.

### STORAGE

Shelf life: 12 months at 20°C in original closed packages.

To store the product at temperature higher than 30°C may cause an alteration of it.

STORAGE TEMPERATURE NOT BELOW 10°C.

The above data are the results of our experiences and they have to be considered as suggestions, due to the variety of the working conditions.

*Date: june 2018 version n° 07*

- THIS TECHNICAL SHEET HAS NOT TO BE CONSIDERED AS A PRODUCT SPECIFICATION -