

ALPHABOND 142

WATER-RESISTANT WOODWORKING ADHESIVE (D3)



PRODUCT INFORMATION

Alphabond 142 Water Resistant Woodworking Adhesive is a white, free-flowing creamy liquid which cross-links on drying to give a translucent heat and water resistant film. It is a one part cross-linking system with excellent water and heat resistance. It exhibits fast bond strength development to give very high final bond strength.

The high performance of this adhesive makes it ideally suited for interior and exterior applications. Alphabond 142 Water Resistant Woodworking Adhesive is extensively used in the Furniture and Joinery industries and conforms to BS EN 204 D3 specifications. NOT RECOMMENDED FOR CONTINUOUS IMMERSION IN WATER.

KEY INFORMATION

- Conforms to BS EN 204 D3 specifications
- An extremely versatile woodworking adhesive
- Excellent water and heat resistance
- Easy to use
- Fast bond strength development
- Very high final bond strength

TYPICAL APPLICATIONS

Alphabond 142 Water Resistant Woodworking Adhesive is suitable for the following applications:

- Bonding various types of wood
- Fabrication
- Lamination

PRODUCT CHARACTERISTICS

The following technical information and data should be considered representative or typical only, therefore the information should not be used for specification purpose.

Property	Data
Colour	White (liquid) / Clear (dried)
Base	PVAc
Consistency	Viscous liquid
Total Solids	49 ± 1%
Viscosity (20°C)	10,000 – 15,000 cP
Specific Gravity (20°C)	1.04
Open Joint Time	Instant to 10 minutes*
Temperature Resistance	Up to 100°C
Application Temperature	+15°C to +35°C
Coverage	6-10 square metres / litre*

* dependent on materials used, temperature & relative humidity

PRODUCT PERFORMANCE

Test	Substrates	Results/Observations
Shear Strength	Wood	> 1000 N

HANDLING & APPLICATIONS

The general application information presented here is based upon typical conditions determined by Alpha Adhesives & Sealants Limited testing. Our recommendations on the use of this product are based on methods believed to be reliable. It is advised that users conduct their own tests to determine the suitability of the product for their specific application.

Process Step	Guidelines
Surface Preparation	The surfaces to be bonded should be dry, clean and free from dust, loose chippings, oil or grease. When used on oily timbers e.g. teak, the surfaces should be wiped with a solvent before bonding.
Adhesive Application	<p>FABRICATION</p> <ol style="list-style-type: none">1. Apply the adhesive using brush, roller, extruded roller coating machines etc, to one surface. In the case of mortice, tenon and dowel joints, it is advisable to apply the adhesive into the hole, in order that the adhesive is carried into the joint during assembly. Gap clearances in the joint should be minimal to achieve the best results.2. Bond the material whilst the adhesive is still wet and surplus material can be cleaned with a wet cloth.3. Apply light pressure on the bond line by conventional means, such as presses, clamps, jigs, etc.4. Before staining assemblies, sand down areas adjoining the adhesive lines to remove adhesive. This ensures uniform staining of the wood. The setting time is generally governed by ambient conditions of temperature and humidity as well as the wood substrates used (see Curing section below). <p>LAMINATION</p> <ol style="list-style-type: none">1. Apply a uniform coat of Water Resistant Woodworking Adhesive to one surface by roller coater. Brush application is also suitable where small areas are to be bonded. The typical application coat weight required is 50-100g/m².2. After lamination the assembly can be cured and bonded by pressing (see Curing section below).
Curing	<p>Fabrication</p> <p>At low temperatures or in moist conditions, setting will be between 12-24 hours. Warmer conditions with dry timber will shorten this time considerably. Optimum bond strength and water resistance will develop in 7-10 days.</p> <p>Lamination Pressing</p> <ul style="list-style-type: none">• Hot Press – 80 psi for 15-30 seconds at a temperature of 100-110°C.• Cold Press – 20-40 psi for 30-60 minutes at room temperature. The maximum adhesive bond strength and optimum water resistance will develop after 7-10 days.
Cleaning	For wet adhesive: water should be used. For dried adhesive: remove adhesive using an abrasive pad.

HEALTH & SAFETY INFORMATION

Alphabond 142 is classified as non-hazardous according to Directive EC 1272/2008. Please refer to the Alphabond 142 Safety Data Sheet for further health & safety information.

STORAGE

Alphabond 142 should be stored in its original container, with the lid tightly secured, in dry conditions and at temperatures between 5°C and 25°C. Alphabond 142 will keep satisfactorily for up to 18 months from date of manufacture if stored according to the recommended conditions.

PRODUCT AVAILABILITY

Product Reference	Pack Size	Container	Box Quantity
Alphabond 142	1L	Plastic Bottle	12
Alphabond 142	5L	Plastic Jerrycan	N/A

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