

## Liquidweld™ 204 White and 204Yellow 1-Component woodworking adhesive

Liquidweld™ 204 is a woodworking adhesive that is ASTM Type II compliant. The dried adhesive is water resistant, non-toxic, and has excellent sandability. It is suitable for professional and consumer use in wood-to-wood joint assemblies, hot/cold press panel operations, fire door assembly, and in radio frequency curing operations. It is excellent for miters and bonding custom edges. It is also may be suitable for bonding fiberboard, paper, cloth, fabric, and leather to wood, check on a sample piece to determine suitability for your application.

### APPLICATIONS & BENEFITS:

- Excellent adhesive strength
- Tough, water resistant bonds

<u>HANDLING PROPERTIES</u>	<u>VALUE</u>	<u>TEST METHOD</u>
Visual Appearance	Milky white or yellow liquid	
Specific gravity – lbs. /gallon	8.8 – 9.2	ASTM E-201
Viscosity at 25°C	5,500 – 6,500 cps	ASTM D-2393
Percent Solids (non-volatile %)	51% - 55%	
VOC Content	< 20 g/ L	
Coverage	approx., 230 sq. ft/gallon at 7 mils wet	
Drying time:	Clamp items to be bonded together for at least 4-8 hours at room temperature and <50% relative humidity. Functional drying (ex. Bonds strong enough to produce fiber tears in wood) will have developed after 8 hours, but the adhesive bond will improve further with additional time. High humidity levels during drying may extend the dry time.	

<u>PHYSICAL PROPERTIES</u>	<u>VALUE</u>	<u>TEST METHOD</u>
Appearance (when dry)	Cloudy film	Visual
Glass Transition Temp. (Tg)	40°C	
Lap Shear Strength (plywood, 3/4" thick) at 25C	>500 psi	ASTM D906
Flexibility – adhesive film on steel plate bent 180 degrees	show no cracking or delamination	

**NOTE:** Values are based on laboratory or average production results – not for specification purposes.

### SUGGESTED PROCESSING GUIDELINES:

Apply by brush, roller, dipping or spraying. If spraying, the emulsion may be thinned with small amounts of warm, di-ionized water to produce a lower viscosity. However, the addition of water will reduce the solids content and will increase the dry time.

Apply to both surfaces to be bonded and then place the items in firm contact and clamp firmly in place with even pressure over the surface. For cold press applications, 40 – 50 psi of pressure is typically sufficient and the cold-press time will typically be a minimum of 30-60 minutes.

Clean tools, equipment, and surfaces, with hot tap water while glue is wet. Removal of dried adhesive is difficult, but ammonia diluted with warm water may work in some applications. Water used for clean-up is not hazardous under RCRA hazardous waste regulations. Allow to dry out or dispose of waste water in accordance with local and state regulations.

### **STORAGE GUIDELINES:**

Store this material in a clean, cool and dry environment in its tightly closed original container. Do not allow to freeze. If frozen immediately warm to room temperature rather than allowing to remain frozen and stir to re-homogenize. Tightly reseal containers after use to prevent evaporation. If the recommended storage conditions are observed the products will have a minimum shelf-life of 12 months from the date of shipment.

### **HANDLING PRECAUTIONS:**

Mandatory and recommended industrial hygiene procedures should be followed whenever these products are being handled and processed. For additional information please consult the corresponding material safety data sheets.

### **PERSONAL HYGIENE:**

Liquidweld™ 204

**WARNING: AS WITH ALL INDUSTRIAL MATERIAL USE CAUTION WHEN WORKING WITH THIS MATERIAL.** Work in a well ventilated location and avoid breathing vapors. Wash skin and clothing that comes in contact with the adhesive with soap and warm water. Wear eye protection when handling, especially if spraying. Inhalation of vapors may cause irritation of the nasal passages. Wash thoroughly after handling. Do not take internally.

### **FIRST AID**

In case of contact:

**Skin** – Immediately wash skin thoroughly with mild soap and water. Remove contaminated clothing and wash before reuse. Destroy contaminated shoes and other articles made of leather.

**Eyes** – Immediately flush eyes with plenty of water for 15 minutes and get prompt medical attention.

**Inhalation** - Remove person to fresh air. Administer oxygen or artificial respiration if necessary. Call a physician.

**Ingestion** - Do not induce vomiting. Dilute with plenty of water and contact physician immediately. Never give anything by mouth to an unconscious person.

### **DISCLAIMER:**

**IMPORTANT:** The following supersedes Buyer's documents. **SELLER / MANUFACTURER MAKES NO REPRESENTATION OR WARRANTY, EXPRESS OR IMPLIED, INCLUDING OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.** No statements herein are to be construed as inducements to infringe any relevant patent. Under no circumstances shall Seller / Manufacturer be liable for incidental, consequential or indirect damages for alleged negligence, breach of warranty, strict liability, tort or contract arising in connection with the product(s). Buyer's sole remedy and Seller's sole liability for any claims shall be Buyer's purchase price. Data and results presented are based on controlled or laboratory work and must be confirmed by Buyer by testing for its intended conditions of use. The product(s) has not been tested for, and is therefore not recommended for, uses for which prolonged contact with mucous membranes, abraded skin, or blood is intended; or for uses for which implantation within the human body is intended.

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