PVA TYPE 2 WOOD GLUE

AW2539

PRODUCT DESCRIPTION

DURAPRO AW2539 is a pre-catalyzed cross linkable polyvinyl acetate-based adhesive that provides good water-resistance and excellent bond strength. AW2539 is suitable for end products that are intended to be exposed to weather, and for interiors projects where high humidity resistance or water resistance is beneficial. AW2539 meets ASTM D-4317 Type II water-resistance.

PRODUCT FEATURES

- **Water-resistance PVA Type II**
- **One part glue**
- **Easy clean up**
- **Can be cold pressed, hot pressed or radio frequency cured**

PREPARATION

Mix well before using. Adhesive, material and room temperature should be between 15^{0}C and 22°C. All surfaces to be glued must be clean and dry. Best bonds are obtained when moisture content of wood ranges between 6% and 8%.

APPLICATION

Apply directly from the plastic bottle or using a stiff brush or a glue spreader. Apply generously to one surface. Joints must be tight fitting. Join the parts, clamp or press using sufficient pressure. When glue becomes colorless, a full-strength bond has been formed. Allow to dry before sanding.

GUIDELINES (AT 20°C % 50% RH)

Assembly time: 15-20 minutes
Clamp time: 25-60 minutes
Drying time: 6-8 hours
Spread rate: approx. 6 sq.m./L (240 sq.ft./gallon)

ATTENTION

Not for continuous submersion or use below waterline. Must dry 5 hours before exposing to water or humidity. Optimal water resistance is achieved after 7 days.

CLEAN-UP

Clean hands and tools with warm soapy water before the product dries. If glue has hardened, use 50% solution of acetone and water for cleaning. On bonded materials, scrape off and sand dry excess.

PHYSICAL PROPERTIES

Viscosity	4,000 – 5,000 cps (5/20 rpm/25^{0}C)
Solids	48 - 50 %
Specific Gravity	1.11
pH	3
Colour	White
Dry film	Transparent
VOC calculated (SCAQMDR 1168) (Ecologo UL2762)	< 30 g/L less water < 5% per weight

ADDITIONAL INFORMATION

AW2539 meets the following bond specifications :
- CSA 0112.8 M1977 / Type II
- BS EN 2004 : 1991 / Class D3
- DIN #68602 / Class B3
- CSA 0132.2.3 Type 1 Wood flush door adhesive
- NWWDA I.S. 1 Type 1 Wood flush door adhesive

AW2539 is approved for on 20-90 minutes rated wood and mineral core fire doors, with or without plastic laminate faces.

STORAGE

Rotate stock. Store indoor in a cool, dry location between 10^{0}C and 35^{0}C. Keep container closed when not in use. Protect from freezing. Product is freeze-thaw stable if frozen not lower than -10^{0}C in transit.

SHELF LIFE

Stable for 3 months at room temperature in the original unopened container from the date of manufacture at 21^{0}C. The viscosity will increase with time, but as long as the glue can be stirred to a smooth consistency it is satisfactory to use. Maximum stability is obtained when stored indoor in a cool, dry location between 5^{0}C and 15^{0}C.

DISPOSAL

Consult your municipality to dispose container and left-over in accordance with environmental regulations.

ENVIRONMENT

This product contains no added urea-formaldehyde resin. The use of this product may contribute in obtaining LEED credits.

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PACKAGING & ORDERING INFORMATION

Item code	Size	Units per Case	Units per Row	Units per Pallet
AW2539-473	473 ml	8	192	960
AW2539-004	4 L	4	36	108
AW2539-015	15 L	1	16	48

PRECAUTIONS

Keep out of reach of children. May cause slight eye and skin irritations. Avoid contact with eyes and skin. **FIRST AID TREATMENT:** If in eyes or on skin, rinse the affected areas with water. If swallowed, drink water and call a doctor. **For industrial user – Refer to Safety Data Sheet (SDS) for further information.**

Product labeled for sale and use in Canada only.

LOT CODE

Lot code (batch number) is stamped on the lid or on the side panel of the container. Code consists of 6 digits: 2 letters and 4 numbers

1st letter = last number of the year of production corresponding to the sequential alphabetical order (excluding I and J) (starts over at A every decade);

2nd letter = indicates the month of production corresponding to the sequential alphanumeric order (excluding I and J);

4 numbers = sequential batch number starting by 0001 on the 1st day of production in the annual calendar year.

Example: CF1234
1st letter: C = 2023
2nd letter: F = June
4 digits: 0123 = 1234th batch produce since January 1, 2023

WARRANTY

Surface conditions, product application, storage and transport are beyond the manufacturer's control; liability, if any, is limited to the replacement of product ONLY.

DISCLAIMER

Our personal is available to help purchasers obtain best results from our products, and recommendations are based on tests and information believed to be reliable. However, since we have no control over the conditions under which our products are transported to, stored, handled, or used by purchasers, all recommendations and sales are made on conditions that we will not be held liable for any damages resulting from their use. No representative of ours has any authority to waive or change this provision.

TECHNICAL SERVICES

Technical assistance is available by phone at 800-361-2340 or email at durapro@dural.ca

To acquire technical and safety literature, please visit our website at www.duraproadhesives.com .

REVISION DATE

May 2026

MANUFACTURED BY

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Dural DURA PRO®

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ADDITIONAL INFORMATION

ASSEMBLY TIME
- Open time : 5 minutes
- Close time : 20 minutes

PRESS TIME
- Cold press : 30 minutes à 50 – 150 psi à 21^{0}C
  60 minutes à 50 – 150 psi à 15^{0}C
- Hot press : 2 - 3 minutes (100 psi, 120^{0}C)
- High frequency : 1 – 2 minutes

NOTES :

1- The assembly time and the press time vary according to the nature of the material used.

2- It is necessary to use an adequate pressure in order to obtain a good contact between surfaces to be bonded.

3- For lamination, the pressure exerted on the glue line de colle should be 30 – 100 psi. Higher pressure is needed for hardwood (175 – 200 psi), for soft wood (100 – 150 psi), and for the edges.

4- For hot press, the pressing schedule depends on the operating conditions such as: application rate, assembly time, plate temperature.

5- The nature and the thickness of the material also affect the time of the pressing.