



# TECHNICAL DATA SHEET

## Gorilla Glue

**Product description:** Gorilla Glue is a one-component moisture hardening polyurethane adhesive for weather- and boil-resistant bonds in accordance with the classification requirements in EN 204/205-D4.

Gorilla Glue is generally intended for bonding wood plus wood-based products, but can also be used to bond metal and plastic. The adhesive is formulated to produce tight-glued joints, for which reason its gap-filling properties are limited.

**Application:** Lamination plus assembly bonding of, for example, windows, doors, building components, furniture components and other products where high bonding strength and bond stability are required.

Gorilla Glue hardens by using moisture in the work pieces and by absorbing moisture from the atmosphere.

Note: To achieve a good bonding result, it is important to keep the specified moisture limits.

As oak may contain a great deal of tannic acid, it is recommended to make a glue test before applying, when the gluing job is oak tree against oak tree.

Exposed glue line must be protected against UV-light (direct sunlight).

The adhesive does not contain solvents.

### Technical data

**Form:** Liquid

**Color:** Dark brown



**Viscosity (Brookfield):** 4,000-7,000 mPas (RVT sp6 / 20 rpm at 25°C)

**Specific gravity:** Approx. 1.14 g/cm<sup>3</sup> at 20°C

### **Working conditions (general)**

**Working temp. Wood:** 10-30°C

**Working temp. Adhesive:** 10°C to max. 60°C, normally 10-25°C for cold clamping.

**Moisture in wood:** Min. 12 % to max. 20 % humidity (for highly porous wood types the moisture limit can be raised to max. 25 %. It is recommended to make a glue test before start of production).

Note: If the wood contains less than 12% moisture, it must be moistened before bonding takes place. Moistening should be done at least one hour before bonding so that the added moisture can spread through the structure of the wood.

**Glue consumption:** 100-250 g/m<sup>2</sup> depending on wood type.

**Pressing time at 20°C:** 1-4 hours depending on wood type.

The pressing time is increased at low material moisture / low temperature, and reduced at higher material moisture / higher temperature.

**Pressing force:** 3-12 kg/cm<sup>2</sup>.

**Working life/open time:** As the adhesive reacts to both the moisture content in the work pieces and the humidity of the atmosphere, is it only possible to give rough guidelines.

At 20°C, 50% relative humidity:  
Approx. 5-10 min. (Open assembly time)  
Approx. 10-15 min (Closed assembly time)



At higher temperatures and higher total humidity, the working life and open time will be reduced.

**Curing time:** Gorilla Glue achieves full bonding strength after 24 hours at 20°C, after which further processing and possible impregnation can take place.

Note: If wood bonded with Gorilla Glue is to be pressure-impregnated, it should be ensured that the wood has been processed correctly, and, depending on the purpose, test bonding is recommended.

**Cleaning:** Liquid adhesive: cellulose thinner, xylene.  
Cured adhesive can only be removed mechanically.

**Storage:** Gorilla Glue must be stored in tightly sealed packaging with no risk of moisture reaching the adhesive.  
If the adhesive is stored in large packs, moisture-absorbent pressure compensation must be fitted.  
Storage: avoid direct sunlight, temperature 10°C to max. 25°C

**Shelf life:** The adhesive has a minimum shelf life on 1 year from the production date.

**Safety precautions:** Gorilla Glue contains 4,4'-diphenylmethan-diisocyanat.  
The product is harmful by inhalation. Irritating to eyes, respiratory system and skin. May cause sensitization by inhalation and skin contact. The Safety Data Sheet for Gorilla Glue should be observed thoroughly before start of using the adhesive.

*Our technical staffs are always happy to provide advice and guidance regarding use of our adhesive products. The above data is only advisory, as actual use of the products is outside our control.*

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