**PRODUCT DESCRIPTION**

Dorus® DL 215B conforms to Type I, ANSI/HPVA HP-1-1994 and meets Wet Use Classification, ASTM D5572-95. With the exception of creep-resistance requirements, it also conforms to ASTM D 2559, Adhesives For Structural Laminated Wood Products for Use Under Exterior (Wet Use) Exposure Conditions. It also meets the requirements of European Specification EN204 D4 and DIN 68602-B4. It is used successfully as a laminating adhesive for cold press, hot press or radio frequency press in the production of veneered tops and end panels, solid and hollow core doors and face and edge glued lumber. It is also used to bond expanded polystyrene to mineral board in the manufacture of insulated roofing underlayment. It meets Factory Mutual wind uplift test requirements for such constructions.

**TYPICAL PROPERTIES**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
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</thead>
<tbody>
<tr>
<td>Viscosity</td>
<td>Approx. 4,500 cps before adding catalyst</td>
</tr>
<tr>
<td>Weight/Gallon</td>
<td>Approx. 9.2 lbs.</td>
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<tr>
<td>Freeze/Thaw Stability</td>
<td>Fair.</td>
</tr>
<tr>
<td>pH</td>
<td>Approx. 4.6 before catalyzation</td>
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<tr>
<td>Working Life</td>
<td>See Page 2</td>
</tr>
<tr>
<td>Storage</td>
<td>See Page 2</td>
</tr>
</tbody>
</table>

**APPLICATION**

**Application:**
Brush, roller or glue spreader

**Coverage:**
- Smooth surfaces: 30-40 pounds/1000 square feet
- Screenbacks/absorbent materials: 40-65 pounds/1000 square feet

**Temperature:**
Over 40°F (glue line)

**Open Time:**
0 - 1 minute

**Closed Assembly:**
0 - 10 minutes

**Press Cycle:**
This factor will vary with substrates, construction and equipment (hot press, cold press, RF). Press cycles can range from 30 seconds/plus (hot press, RF) 30 minutes/plus (cold press laminating) and 45 minutes to 2 hours (cold press edge and face glue). See Page 2 for application instructions for roofing underlayment. **SEE CAUTIONS REGARDING HANDLING OF CATALYST ON PAGE 2.**

**OTHER PRECAUTIONS**

Keep adhesive covered to prevent drying out and contamination. Do not mix with other adhesives.

**IMPORTANT NOTE**
Minimum operating temperature can vary with changes in moisture content of wood and plant conditions (temperature and relative humidity). Discoloration of wood veneer products occurs occasionally. Such discoloration is very infrequent and ranges in appearance, color and may vary with the species of the veneer. Discoloration may appear during or after the manufacturing process. Among other things, environmental conditions in some processing plants can contribute to discoloration. If veneer discoloration occurs, our technical service representatives are prepared to assist you in attempting to identify the causes of the staining and possible solutions. Because such discoloration is attributable to conditions beyond our control, National Starch and Chemical Company can assume no responsibility or liability for any discoloration that might occur.

**MIXING INSTRUCTIONS**
Dorus® DL 215B must be accurately and thoroughly mixed with Catalyst 2300 prior to use. Normal catalyst concentration is 5% on the Dorus® emulsion by weight. Addition of Catalyst 2300 results in a pastel green color which makes adhesive application visible. When product end-use makes this green color undesirable, 5% by weight of Catalyst 2301 may be substituted. See Volumetric Measuring Table, below, for convenient estimations of Catalyst.

**VOLUMETRIC CATALYST MEASURE**
To one gallon of adhesive, add: 5 fluid ounces of 42-2300...
OR ...5½ fluid ounces of 42-2301 Add slowly while stirring. Mix thoroughly.

**CAUTION!**
Catalysts are acidic in nature. Handle with care! Protect eyes from catalyst. Should skin contact occur, wash the area immediately with water. In case of eye contact, flush with large amounts of water. Call physician immediately.
APPLICATION
ROOFING UNDERLAYMENT. Using a Black Brothers glue spreader or equivalent, apply 6 to 8 wet mils of adhesive to the expanded polystyrene (EPS). Place a section of mineral fiberboard on top and build a stack of insulation panels. Within 25 minutes from the time the first panel is prepared, place the stack in an air-bag press or cold press to apply contact pressure of about 2-5 psi for 15-20 minutes. Remove stack from press and allow to stand at room temperature for 24 hours before trimming or further handling.

WORKING LIFE
16 to 48 hours at 72°F; will decrease at higher temperatures.

STORAGE LIFE
Shelf life of Dorus® DL 215B is approximately 3 months from date of manufacture (70°F). Maximum stability is attained if material is stored between 40°F and 70°F. The viscosity will increase with time in storage. Containers are dated so that storage life can be determined easily.

Note
The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits. The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

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