
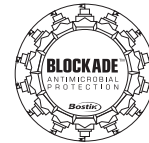


Product Information



DURABOND®

D-321™ Moisture Cure Urethane Wood Flooring Adhesive



Product Description

DURABOND D-321™ Moisture Cure Urethane Wood Flooring Adhesive is a one-part, trowel applied, scientifically formulated adhesive that does NOT contain any water; has zero solvent and zero VOC's as calculated per SCAQMD 1168. Once cured, D-321 is waterproof and is not adversely affected by exposure to moisture, water; its superior properties provide a tough, flexible, tenacious bond to a variety of surfaces. D-321's elastomeric characteristics allow the adhesive to move with the wood as it expands and contracts over the life of the floor. D-321 is easier to spread, holds a better ridge, and cleans up easier than most moisture cure urethane wood flooring adhesives.

D-321 may be used to adhere all engineered, acrylic impregnated, solid plank-flat milled, shorts, bamboo and parquet hardwood flooring designed and recommended in writing by the hardwood flooring manufacturer for glue-down applications. This adhesive can also be used to install plywood as described, as well as, ceramic tile, marble, and stone inlays for light commercial and/or residential applications.

D-321 may be used over all properly prepared substrates common to hardwood flooring installations including: concrete, plywood, particle or chip board (underlayment grade), well bonded vinyl and ceramic tile, cement backer board, gypsum patch/underlayments (dry, above-grade), cement patch/underlayments, radiant-heat flooring, and terrazzo.

This product contains Bostik's BLOCKADE™ antimicrobial protection, which inhibits the growth of bacteria, mold, or mildew on the surface of the dried adhesive; the dried adhesive resists stains caused by mold.

Directions For Use

Read and understand data sheet completely before beginning installation. Follow industry standards and wood flooring manufacturer's recommendations for design, layout and application of wood flooring material.

Surface Preparation

Surfaces must be clean, dry and smooth; free of voids, projections, loose materials, oil, grease, sealers and all other surface contaminants. If there are any moisture related concerns, or if solid wood is being installed, completely remove cutback adhesive residue by sandblasting, shotblasting or scarifying. When sandblasting, shotblasting or scarifying, surface texture must be similar to light broom finished concrete. Maximum acceptable floor variation is 3/16" in 10 feet. Surface areas requiring patching or leveling must be done using a Portland cement based material (i.e. Durabond Webcrete® 95 patch or 83P® self-leveling underlayment).

Installation

The installation begins with a starter row secured to the subfloor; the starter row provides a stationary point to push against so flooring doesn't move during installation. Once the starter row is secured, apply adhesive to substrate with suitable trowel. Flooring may be installed using a "Wet-Lay" method of installation. For "Wet-Lay" installations, spread the adhesive and begin to install the flooring immediately. As you work, immediately clean any adhesive from prefinished flooring with Durabond's Urethane Adhesive Remover™ or mineral spirits. (be careful not to harm finish) and then dry buff with a non-abrasive paper towel. After a few rows have been installed, and as you move across the room, tape the boards together using removable 3M #2080 Blue tape to prevent boards from sliding and to secure close-fitting joints. Rolling is recommended for all installations. Flooring that is not flat should be tacked, weighted, or rolled to ensure proper contact between the flooring and substrate.

Plywood Over Concrete

Score 4' x 4' sheets of 3/4" exterior-grade plywood on the backside every 8" to 10" by using a circular saw and cutting one half the thickness of the plywood; "scoring or kerfing" takes the tension out of the plywood and helps to prevent possible warping or curling. Using a 1/4" x 1/4" x 1/4" square-notch trowel, apply adhesive to substrate and then set the plywood into the wet adhesive. Allow the adhesive to fully cure before nailing strips or using DURABOND D-321 to install flooring.



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• Technical Service 800/523-6530

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Open/Working Time

Refer to “Open/Working Time Chart”.

Cure Time

Humidity affects cure to a greater degree than temperature; the higher the humidity, the faster the cure. Under normal conditions, light foot traffic is acceptable after 8 to 10 hours; normal traffic after 24 hours.

Clean-Up

As you work, immediately clean any adhesive from prefinished flooring with Durabond’s Urethane Adhesive Remover™ or mineral spirits (be careful not to harm finish) and then dry buff with a non-abrasive paper towel. Immediately clean all tools and equipment with Durabond’s Urethane Adhesive Remover™, or mineral spirits before material cures.

Trowel Clean-Up Tip: Before use, cover areas of the trowel that are not used to spread the adhesive with gray duct tape. After use, simply tear off tape before material cures, and clean remainder of trowel with adhesive remover.

Limitations

- Slab temperature should be between 50°F and 100°F during installation.
- Do not use on wet, dusty, contaminated, or friable substrates; do not use over substrates/slabs treated with sealers or curing compounds; do not use in areas subject to hydrostatic head.
- If there are any moisture related concerns, completely remove cutback adhesive residue (and other surface contaminants) by sandblasting, shotblasting, or scarifying.
- Do not use over perimeter bonded flooring material.
- Due to limitations with solid wood flooring (i.e. lack of dimensional stability), “below-grade” installations are limited to engineered hardwood flooring.
- Do not install solid wood flooring over cutback residue or over VCT/vinyl.
- Use over gypsum based patch/underlayment is limited to dry, “above-grade” installations where the gypsum has dried hard (not dusty/powdery), with a minimum compressive strength > 2,000 psi. for engineered hardwood installations, or minimum compressive strength > 2,500 psi for solid hardwood installations.
- Please refer to wood flooring manufacturers recommendation for proper expansion relief around perimeter or throughout installation.

- Do not use with vinyl backed cork flooring.
- Bamboo installations should follow solid hardwood flooring installation recommendations.

Storage/Shelf Life

Store at temperatures between 50°F and 100°F. Shelf life is one year from date of manufacturing in closed, original packaging.

Re-Seal Partially Used Container: With pail upright place a sheet of plastic (e.g. trash bag) over the top of the pail. Secure lid tightly over the plastic on top of pail. Carefully turn pail upside down. Plastic will help prevent the material from bonding the lid closed.

Re-Open Partially Used Container: Carefully turn pail right side up. Remove lid. Carefully cut and discard cured material and plastic from top of pail. Any uncured material may be used.

Coverage

Trowel size is suggested to maximize coverage of adhesive. Periodically check coverage of adhesive during installation; >80% coverage is required for engineered hardwood flooring; >95% coverage is required for solid hardwood flooring. Uneven subflooring may require the use of either a leveling/patching material, or a larger notched trowel for proper coverage of adhesive.

Packaging

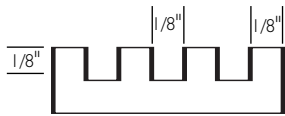
Available in 4 gallon pails.

OPEN/WORKING TIME CHART

| Temp. | Humidity | | | |
|-------|----------|----------------------------|----------------------------|---------------------------|
| | | 40% | 60% | 80% |
| 60°F | Open | ≥ 120 Minutes 3.5 hours | ≥ 100 Minutes 3.5 hours | ≥ 80 Minutes 3 hours |
| 70°F | Open | ≥ 100 Minutes 3 hours | ≥ 80 Minutes 3 hours | ≥ 60 Minutes 2.5 hours |
| 80°F | Open | ≥ 80 Minutes 3 hours | ≥ 60 Minutes 2.5 hours | ≥ 40 Minutes 2 hours |

NOTE: This chart is for reference only. A complete Temperature Humidity Chart is available on data sheet or call Bostik Technical Service at 1-800-523-6530.

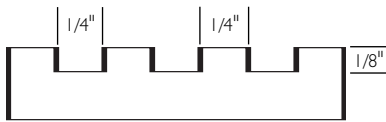
SUGGESTED NOTCHED TROWEL FOR MAXIMUM PERFORMANCE



1/8" x 1/8" x 1/8" Square Notch
Finger Block Parquet
Coverage: 80 ft²/Gallon



3/16" x 5/32" V Notch
3 ply and 5 ply Engineered Plank
Coverage: 50 ft²/Gallon



1/4" x 1/4" x 1/8" Square Notch
> 1/2" Engineered Plank & 3/4" Parquet
Coverage: 40 ft²/Gallon



1/4" x 1/4" x 1/4" Square Notch
Flat Milled Solid & Shorts or Plywood
Coverage: 35 ft²/Gallon

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PLANT LOCATIONS



LIMITED WARRANTY

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August 2008; Supersedes all previously published literature.



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