



Since 1990

DECCOBOND 381

GLUEDOWN

Wood Flooring Adhesive

DESCRIPTION:

DECCOBOND 381 GLUEDOWN Wood Flooring Adhesive is a premium grade, high performance hydrophobic hybrid polymer, wood flooring adhesive. It is environmentally friendly, solvent & odor free, non-flammable, LEED® compliant, VOC & isocyanates free. Cured films are alkali resistance and waterproof, which makes it suitable for commercial-grade installations. It has flexible open working time, superior bond strength, flexible & resilient setting properties which make the cured films stable and form an anti-fracture membrane that can bridge cracks up to 1/8". This revolutionary formulation with high solids is ideal for wood flooring glue-down installation over various subfloor systems including in-floor hot water radiant heated subfloor. **DECCOBOND 381** contains anti-microbial protection which inhibits molds in damp environment.

APPLICATION:

DECCOBOND 381 GLUEDOWN Engineered Wood Flooring Adhesive can be used to adhere all engineered hardwood, acrylic impregnated laminates, plywood, bamboo, cork, parquet wood flooring, vinyl backing wood flooring, and flat milled solid hardwood plank*. It is ready to use and no mixing required.

Surface Preparation:

All subfloors must be structurally sound, stable, level, and flat. Surfaces must be clean, dry and smooth, free of voids, loose materials, projections, oil, old adhesive, wax, sealers or other contaminants that may compromise the adhesion of the installation of the floor. The maximum acceptable floor variation is 1/8 inches per 10 feet. If surface leveling is required, it must be done with Portland cement based with high compressive strength.



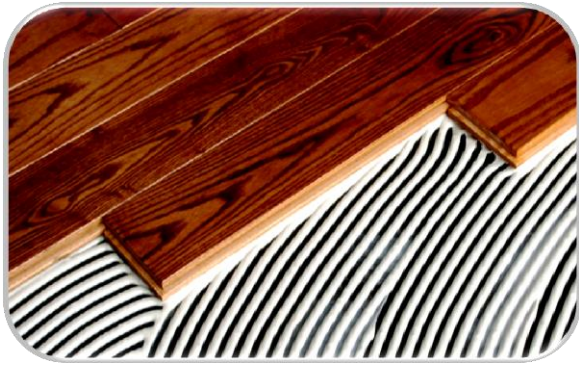
Superior Quality. Revolutionary.

- **Strong & Resilient**
- **Ultimate Bond Strength**
- **Moisture Barrier & Waterproof**
- **Easy Spread & Trowel**
- **Commercial-Grade**
- **Odor, VOC & Isocyanates Free**
- **High Solids**
- **Anti-microbial & Anti-fracture Membrane**
- **Ideal for Installation over Radiant Heated Subfloor**

Applications

- **Engineered Hardwood**
- **Bamboo**
- **Cork**
- **Parquet**

* Trademark of Tenco Westech Polymers Inc.



Acceptable subfloors:

Plywood, underlayment grade OSB boards, in-floor hot water radiant heated concrete slabs, and fully cured cement-based concrete, leveling, and patching compounds. Adhesive can be used to install plywood on ceramic tile, marble, and stone inlays for commercial or residential application. Other approved subfloors per flooring manufacturer.

Below Grade Installation:

For subfloor with high hydrostatic water pressure, **DECCOSEAL 506 Waterproofing Barrier Coat** is recommended for sealing the subfloor prior to installing the wood flooring.

Installation:

Begin the installation with an “Anchor” or starter row properly secured to the subfloor. The Anchor row must be able to withstand any movement when the subsequent planks are pushed during installation. Then adhesive is applied to the substrate with the suitable trowel as recommended (see **Trowel Recommendation**). For open time and working time (see **Open/Working Time**). Begin laying the wood flooring from the “Anchor” or starter row, working into the field. Work on a small section at a time to ensure proper adhesive transfer, the wood floor is well seated into the adhesive. It is not advisable to walk on top of the floor that is just laid. Rolling is recommended where necessary. Install flooring per the flooring manufacturer’s recommendations.

Clean Up:

Clean off any adhesive smudges or residues on the wood floor before curing begins with water. Use caution and avoid pouring mineral spirit

directly onto the wood floor when cleaning off dried adhesive. For best result, **DECCO® GLUE REMOVER** is recommended for cleaning off any dried adhesive.

Trowel & Tools Clean Up:

Clean tool with warm water while the adhesive is fresh/wet. Use **DECCO® GLUE REMOVER** for dried adhesive.



VOC Compliant:

Zero grams/liter SCAQMD Rule #1168 (South Coast Air Quality Management District)

LEED Credit:

DECCOBOND 381 GLUEDOWN Wood Flooring Adhesive may contribute to LEED certification projects based on the following categories.

LEED CREDIT	
LEED (Version 3.0)	LEED Point
Regional Materials (MR Credit 5.0)	2
Low-Emitting Materials (IEQ Credit 4.1)	1

Cure Time:

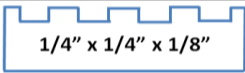
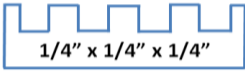
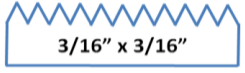
Light foot traffic in about 24 hours, normal traffic after 48 hours.

*Limitation:

DECCOBOND 381 is not recommended for solid hardwood plank with any dimensions exceeding 3½” width, ¾” thick, and 5’ length. For solid hardwood plank installation, allow longer open time to flash off excess adhesive moisture.

Trowel Recommendation:

Trowel size is recommended to get the maximum coverage of glue over the floor. It is important to note that, the actual coverage of glue may vary based on subfloor surface conditions, and the flooring manufacturer's product backing texture and characteristic. For full transfer of adhesive from the flooring backing to subfloor, sufficient ridge heights are needed.

Flooring Type	Trowel Size	Coverage (ft ² /Gallon)
>1/2" Engineered ≤1/2" Solid Hardwood	 1/4" x 1/4" x 1/8"	40 - 50
Flat Milled Solid & Shorts	 1/4" x 1/4" x 1/4"	35 - 45
≤1/2" Engineered Hardwood	 3/16" x 3/16"	50 - 60

Open/Working Time Chart:

Actual open/working times may vary based on temperature, humidity, subfloors, trowel size, and jobsite conditions, and flooring manufacturer's product backing texture and characteristic.

Products	Open (minute)	Working Time (hour)
>1/2" Engineered ≤1/2" Solid Hardwood	15 – 25	2
Flat Milled Solid & Shorts or Plywood	60 – 120	2
≤1/2" Engineered Hardwood	15 – 25	2

STORAGE:

DECCOBOND 381 GLUEDOWN Wood Flooring Adhesive is stable. Stores well at 20° C room temperature for at least 12 months from date of manufacture in closed, original packaging. Do not store next to heaters or very high temperatures of 70° C or more. **KEEP FROM FREEZING.**

PHYSICAL PROPERTIES			
Type	Hybrid Polymer	Viscosity	100,000 cps
Appearance	Off-white Paste	Odor	Mild to None
Solids	60 - 65%	Flammability	Non-flammable
Weight/gallon	4.0 kg	VOC	0 g/L

PACKING INFORMATION		
Size	Kg/Unit	Units/Pallet
3.5 Gal. Pail	15.0	48
5.0 Gal. Pail	21.4	36

