

## AQUENCE KL 074

Known as DORUS MD 074

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### PRODUCT DESCRIPTION

AQUENCE KL 074 provides the following product characteristics:

<b>Technology</b>	PVA Dispersion
<b>Product Type</b>	Assembly Glue Water resistant as per D3 / EN 204
<b>Application</b>	Assembly
<b>Appearance</b>	white transparent after drying

### Application Areas

- Joints where increased water resistance is required
- Gluing solid wood
- Gluing of blockboard cores and composed solid wood panels
- Doors and stairs
- Windows, window scantlings, composite window elements

### Product Properties

- Medium viscosity
- Fast setting
- Long open time
- Gap filling
- Gives transparent, tough-elastic glue joint
- High water resistance one component  
= Durability class D3 as per EN 204
- plus cross-linker AQUENCE CATALYST R 397 ( 5% )  
= Durability class D4 as per EN 204

### Technical Data

#### AQUENCE KL 074:

Minimum film formation temperature, °C (MFFT) DIN 53787	~+5
Viscosity, Brookfield - RVT, 6/20/20, mPa.s ISO 2555	12,000 to 18,000
pH value (20 °C) ISO 976	2.5 to 3.5

### DIRECTIONS OF USE

#### Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

#### Instructions for Use

##### Open Time

Open time (beech/beech) :	
Quantity applied 150 g/m <sup>2</sup> , minutes	~10
Quantity applied 200 g/m <sup>2</sup> , minutes	~17

##### Pressing Time

Surface bonding (Chipboard/HPL) :	
Quantity applied 100 g/m <sup>2</sup> , minutes	≥12
Quantity applied 200 g/m <sup>2</sup> , minutes	≥20
Joint bonding (beech/ beech) :	
Quantity applied 150 g/m <sup>2</sup> , minutes	≥30
Quantity applied 200 g/m <sup>2</sup> , minutes	≥35

The data shown is based on 8-12 % wood moisture, 20 °C room and material temperature, 65 % relative air humidity and 0.5 N/mm<sup>2</sup> pressure.

The actual open and setting times will depend heavily on the working conditions such as temperature, humidity and absorption of the wood, surface characteristics, stresses in the material and application thickness of the glue, etc.

The glue is supplied ready for use. If required, it can be thinned with water up to 3 %.

The working temperature of the workpiece and glue should be at least + 10°C.

Ensure that the parts to be bonded are close fitting and free from dust and grease.

Fit tolerances increase the setting time and reduce the bonding strength.

Due to the acidic character gluing with D3 and D4 dispersion glue can give discoloration of acid sensitive wood species (e. g. pine).

All parts which come into contact with the glue must be made either of stainless steel (V2A/V4A) or plastic.

Usually, application of the glue to one side only is sufficient. Applying glue to both sides, however, is recommended when gluing difficult-to-bond woods and hardwood, in order to improve bonding strength; in this case the open time is increased.

**Glue/Cross-linker Mixture**

AQUENCE KL 074 plus 5% cross-linker AQUENCE CATALYST R 397 = durability class D4 according to EN 204

Glue and cross-linker should be mixed well and used within approx. 7 hours (pot life).

Glue and cross-linker should be mixed well and used within approx. 3-4 hours (pot life).

The setting and pressure times of the glue/cross-linker mixture are - depending on the amount of cross-linker used - about 2-3 min longer than AQUENCE KL 074 glue without cross-linker.

**Cleaning**

Equipment used to apply the glue may be cleaned easily using cold or luke-warm water before the adhesive has dried hard. Hard dried glue remnants have to be removed mechanically.

**STORAGE**

Store in the original tightly closed container in a cool, dry place away from frost.

Stir well before use.

Storage life up to 12 months.

**Classification:**

Please refer to the corresponding **safety data sheets** for details on:

**Hazardous Information****Transport Regulations****Safety Regulations****ADDITIONAL INFORMATION****Disclaimer****Note:**

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