

## AQUENCE KL 071/2

January 2021

### PRODUCT DESCRIPTION

AQUENCE KL 071/2 provides the following product characteristics:

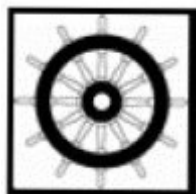
<b>Technology</b>	PVA Dispersion
<b>Product Type</b>	Water resistant as per D3 / EN 204
<b>Application</b>	Assembly
<b>Appearance</b>	white transparent after drying

### Application Areas

- Joints where increased water resistance is required
- Gluing solid wood
- Gluing of blockboard cores and composed solid wood panels
- Doors and stairs
- Veneer gluing

### Certificates and Approvals

Test certificate of Danish Institute of Fire and Security Technology, DK-2650, for low flammability in ship building according to IMO Resolution FTPC part 5, based on an applied quantity of 200 g/m<sup>2</sup>.



Notified Body  
0098 / 2021

### Product Properties

- Medium viscosity
- Fast setting
- Long open time
- Free from discolouration
- 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
- Formaldehyde content <10 mg/kg

### Technical Data

#### AQUENCE KL 071/2:

Minimum film formation temperature (MFFT), °C:  
DIN 53787 ~+5

Viscosity, Brookfield - RVT, 5/20/23, mPa.s :  
ISO 2555 9,000 to 15,000

pH value, 20°C:  
ISO 976 4 to 5

### DIRECTIONS OF USE

#### Preliminary Statement

Prior to application it is necessary to read the **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 ~7  
Quantity applied 200 g/m<sup>2</sup> , minutes ~15

##### Pressing Time

Surface bonding (Chipboard/HPL) :  
Quantity applied 100 g/m<sup>2</sup> , minutes ≥8  
Quantity applied 200 g/m<sup>2</sup> , minutes ≥16  
Joint bonding (beech/ beech) :  
Quantity applied 150 g/m<sup>2</sup> , minutes ≥20  
Quantity applied 200 g/m<sup>2</sup> , minutes ≥30

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 working temperature of the workpiece and glue should be at least + 12°C.

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

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.

#### Glue/Cross-linker Mixture

AQUENCE KL 071/2 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).

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 071/2 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

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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