

AQUENCE KL 074Known as DORUS MD 074
June 2018**PRODUCT DESCRIPTION**

AQUENCE KL 074 provides the following product characteristics:

Technology	PVA Dispersion
Product Type	Assembly Glue Water resistant as per D3 / EN 204
Application	Assembly
Appearance	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
- 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
- High heat resistance, tested according to EN 14257
(WATT 91)

Technical Data

AQUENCE KL 074:

Minimum film formation temperature, °C ~+5
(MFPT)
DIN 53787Viscosity, Brookfield - RVT, 6/20/20, mPa.s 12,000 to
ISO 2555 18,000pH value
(20 °C) 2.5 to 3.5
ISO 976**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/m², minutes ~10
Quantity applied 200 g/m², minutes ~17

Pressing Time

Surface bonding (Chipboard/HPL) :
Quantity applied 100 g/m², minutes ≥12
Quantity applied 200 g/m², minutes ≥20
Joint bonding (beech/ beech) :
Quantity applied 150 g/m², minutes ≥30
Quantity applied 200 g/m², 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/mm² 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 nature of a D3 and D4 dispersion adhesive, some discoloration can occur as some wood types are sensitive to acid (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).

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:**

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.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:

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. 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.

In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:

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.

Trademark usage: [Except as otherwise noted] All trademarks in this document are trademarks and/or registered trademarks of Henkel and its affiliates in the U.S. and elsewhere.

Reference 0.2