

Kestokol D4

Kestokol D4 is EN 204 D4 classified PVAC-adhesive for face- and finger jointing of non-structural window and external door production wood blanks.



- Used in conjunction with Hardener S.

AREA OF APPLICATION

Kestokol D4 + Hardener S is a reactive PVAc-dispersion adhesive for window and door manufacture and face and finger jointing. Due to D4 water resistance durability class, Kestokol D4 + Hardener S can be used for exterior applications exposed to weather when covered with an adequate surface covering, or indoors for applications with frequent long-term exposure to running or condensation water.

INSTRUCTIONS FOR USE

Add 5 weight parts of Hardener S to 100 weight parts of Kestokol D4 and mix well. Check that the joints fit properly. Apply adhesive evenly on one side. Assemble and press the parts together aiming at an even squeeze out for the whole length of the joint. Joints can be pressed in a cold, hot or high frequency press. The final strength and water resistance of the bond is reached within 7 days.

With some wood types the adhesive's acidity may cause discolouration in the adhesive bond. If in contact with iron, some discolouration in the blue-grey adhesive bond may also occur.

The consumption affects the open time of the adhesive as follows (pine 12 % wood moisture, 20 °C, 50 % RH):

Consumption (g/m ²)	Open time(minutes)
150	7
180	11
220	13
250	16

ADDITIONAL INFORMATION

The information given in this product data sheet is based on our tests and our practical knowledge. The technical data is defined in standard conditions. Variations in local working conditions will affect the product performance and result. The result is also strongly affected by working methods. We guarantee the high quality of our products according to our Quality Management System. No liability can be accepted from incorrect use of the product or prevailing conditions, over which we have no control. Thus, we cannot be held responsible for the final result. The user of the product must test the product's suitability for the intended application.

pH	2.5
MIXING RATIO	100 : 5
VISCOSITY	11,000 mPas (Brookfield RVT 20 °C)
MIXTURE VISCOSITY	6000 mPas (Brookfield, RVT 20 °C)
MIXTURE COLOUR	Bluish-grey, transparent when dry
POT LIFE	3 - 4 weeks (30 °C) 8 weeks (20 °C)
OPEN TIME	7 - 16 min (consumption 150 - 250 g/m ²)
CONSUMPTION	150 - 250 g/m ²
PRESSING TIME	20 min (Pine, wood moisture 12 %, temperature 20 °C, 50 % RH)
COMPRESSION PRESSURE	0.5 N/mm
MINIMUM FILM FORMING	9 °C
WOOD MOISTURE CONTENT	6 - 15 %
TEMPERATURE RESISTANCE	EN 14257 (Watt 91): 8,4 N/mm ²
STORAGE	In unopened containers, above +1 °C, for 12 months. After long storing, stir before use.



ENVIRONMENT AND SAFETY

Avoid unnecessary skin contact and exposure with the fresh product, use safety gloves. Refer to material safety data sheet. For information on product and package disposal, visit www.kiilto.com.