

Kestokol WR 125



Kestokol WR 125 is a 2-component emulsion polymer isocyanate adhesive for specific glulam applications.



- Short pressing time
- Long pot-life
- Unprotected outside usage

AREA OF APPLICATION

Kestokol WR 125 + Hardener M is an emulsion polymer isocyanate adhesive that has excellent resistance against climatic stress. Fulfills the requirements of EN 204/D4 water resistance durability class 4:2005 and the EN 302:2 delamination standard.

Kestokol WR 125 + Hardener M can be used in objects strongly exposed to changing weather conditions such as garden furniture, boat gluing's (not for parts below the water level!) and specific glulam applications.

INSTRUCTIONS FOR USE

Add 15 weight parts of Hardener M into 100 weight parts of Kestokol WR 125 adhesive and mix well. If the pot-life of the mixture is exceeded, the mixture starts to foam. New mixture can be added into an older mixture within the pot-life.

Check that the joints fit well. 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, thermo or high frequency press. Hot and high frequency presses shorten the required pressing time. In order to determine the necessary pressing time and ensure the adhesive joint strength, adequate tests are to be carried out before use in full-scale production.

Parts may need to be stored for a while before further machining to reach the necessary bond strength. The final strength and water resistance of the bond is reached within 7 days.

Technical data for general and specific glulam applications:

	General use	Specific glulam applications
Consumption	140 - 160 g/m ²	200 - 240 g/m ²
Open time	10 - 15 min	15 - 20 min
Pot life	50 min	35 min
Pressing time (minimum)	20 min	30 min

DENSITY/SPECIFIC WEIGHT	1.11 kg/dm
pH	6.5 - 8.0
MIXING RATIO	100 : 15
VISCOSITY	5000 mPas (Brookfield, RVT +20 °C)
MIXTURE VISCOSITY	8000 mPas (Brookfield RVT +20 °C) immediately after addition of hardener
MIXTURE COLOUR	Light beige
POT LIFE	The pot life of the mixture is at most 50 min (+20 °C), (In specific glulam applications 35 min)
OPEN TIME	10 - 20 min (consumption 150 - 220 g/m ²) See instruction for use.
CONSUMPTION	140 - 240 g/m ²
PRESSING TIME	minimum 20 min
MINIMUM FILM FORMING	+5 °C
WOOD MOISTURE CONTENT	6 - 15 %
TEMPERATURE RESISTANCE	EN 14257 (Watt 91); 10,3 N/mm
STORAGE	In unopened containers, above +1 °C, for 6 months. After long storing, stir before use.

**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.

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.