

# Kestokol D 400



Kestokol D 400 is a two-component EN 204 D4 classified PVAC-adhesive for face and finger jointing of non-structural window and external door production wood blanks.



- Suitable for exterior use when covered with an adequate surface covering
- 2-component

## AREA OF APPLICATION

Kestokol D 400 + Hardener F is a reactive PVAC-dispersion adhesive, which is an ideal universal adhesive for the woodworking industry. Due to its D4 water resistance durability class, Kestokol D 400 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

Kestokol D 400 and Hardener F should be mixed together properly. Propeller mixer is recommended.

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, 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 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 <sup>2</sup> )	Open time(minutes)
150	7
180	11
220	17
250	19

## 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

pH	2.7
COLORS	White, transparent after drying
MIXING RATIO	100 : 5 (100 weight parts Kestokol D 400 and 5 weight parts Kestokol hardener F)
MIXTURE VISCOSITY	5000 mPas (Brookfield, RVT +20 °C)
MIXTURE COLOUR	White
OPEN TIME	See instructions for use.
CONSUMPTION	150 - 250 g/m <sup>2</sup>
PRESSING TIME	20 min. (Pine, 12 % wood moisture, temperature 20 °C, 50 % RH)
COMPRESSION PRESSURE	0.5 N/mm <sup>2</sup>
MINIMUM FILM FORMING	+6 °C
WOOD MOISTURE CONTENT	6 - 15 %
TEMPERATURE RESISTANCE	EN 14257 (Watt 91): 7.0 N/mm <sup>2</sup>
STORAGE	In unopened containers, above +1 °C, for 12 months. After long storing, stir before use.



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](http://www.kiilto.com).