

Kestokol WR 6040



- Suitable for e.g. parquet manufacture
- Long pot life
- Well suited for high frequency press

AREA OF APPLICATION

Kestokol WR 6040 + Hardener M is an isocyanate emulsion polymer adhesive that has excellent resistance against climatic stress. Fulfills the requirements of EN 204/D4 water resistance durability class.

Kestokol WR 6040 + Hardener M can be used in applications that are exposed to harsh weather conditions such as garden furniture, boat gluings (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 6040 adhesive and mix properly. If the pot-life 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 one sided evenly. 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. 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.

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 and methods will affect the product performance and result. The result is 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.

DENSITY/SPECIFIC WEIGHT	1.15 kg/dm
pH	6.5 - 8.0
COLORS	Light beige
MIXING RATIO	100 : 15
VISCOSITY	4000 mPas (Brookfield, RVT +20 °C)
MIXTURE VISCOSITY	11000 mPas (Brookfield RVT +20 °C) immediately after addition of hardener.
MIXTURE COLOUR	light beige
POT LIFE	The pot life of the mixture is max. 60 min (+20 °C)
OPEN TIME	11 - 24 min (consumption 150 - 250 g/m ²)
CONSUMPTION	150 - 250 g/m ²
PRESSING TIME	minimum 40 min
MINIMUM FILM FORMING	+5 °C
WOOD MOISTURE CONTENT	6-15 %
TEMPERATURE RESISTANCE	EN 14257 (Watt 91): 13.2 N/mm ²
STORAGE	In unopened containers, above +1 °C, for 6 months. After long storing, stir before use.



ENVIRONMENT AND SAFETY

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