

Kestokol 93 AL



Kestokol 93 AL is a 2-component emulsion polymer isocyanate adhesive for gluing of suitably pre-treated aluminium onto wood based boards for external door production.



AREA OF APPLICATION

Kestokol 93 AL + 93 AL hardener is an emulsion polymer isocyanate adhesive with good water and heat resistance.

Kestokol 93 AL + 93 AL hardener is a 2-component special adhesive for gluing of suitably pre-treated aluminium onto chipboard, plywood or other wood based material.

The adhesive is not suitable for electronically anodised aluminium.

INSTRUCTIONS FOR USE

Add 15 weight parts of Hardener Kestokol 93 AL into 100 weight parts of Kestokol 93 AL adhesive and stir well until the colour is even. 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.

Surfaces to be bonded must be free from dust, grease etc. Check that the joints fit well. Apply the adhesive one-sided in an even layer. Position the pieces together and press. For series production, tests should first be carried out to determine the exact pressing times. The parts should be stored for a while before further machining to reach the necessary bond strength.

The final strength and water resistance of the joint is achieved 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 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.

MIXING RATIO	100 : 15 (100 weight parts Kestokol 93 AL adhesive + 15 weight parts Kestokol 93 AL-hardener)
VISCOSITY	5500 mPas (Brookfield RVT 20 °C)
MIXTURE VISCOSITY	8500 mPas (Brookfield RVT 20 °C)
MIXTURE COLOUR	light beige
POT LIFE	The pot-life of the mixture is at most approx. 60 min (20 °C)
OPEN TIME	4 - 8 min (consumption 130 - 160 g/m ²)
CONSUMPTION	130 - 160 g/m
PRESSING TIME	at least 20 min (20 °C)
MINIMUM FILM FORMING	+ 5 °C
WOOD MOISTURE CONTENT	6 - 15 %
STORAGE	In unopened containers, above +1 °C, for 12 months. After long storing, stir before use.