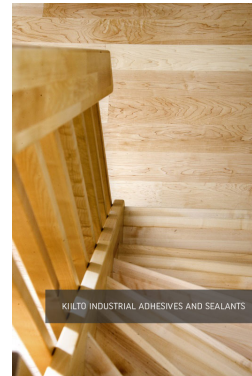


Kestokol D 325 HF



KILTO INDUSTRIAL ADHESIVES AND SEALANTS

Kestokol D 325 HF is an EN 204 D3 classified PVAC- adhesive for wood.

EN 204 D3

WATT 91



- Very fast on high frequency presses
- Long open time
- 1-component

AREA OF APPLICATION

Kestokol D 325 HF is a D3 level performance specially designed PVAc dispersion adhesive with a high film forming temperature for glued boards, form pressing and veneering. The adhesive is especially designed and can only be used in hot and HF presses. The adhesive can be applied in the gluing of E1-classified structures.

INSTRUCTIONS FOR USE

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. The joints can be pressed in a 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.

NOTE! Kestokol D 325 HF is not suitable for cold pressing. Kestokol D 325 HF adhesive reacts even with a small amount of urea formaldehyde adhesive (1 %) forming a thick sponge. For this reason the application equipment (pump, hoses, roller) need to be washed very carefully prior to using Kestokol D 325 HF adhesive.

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.

TYPE/BINDER	PVAc
DENSITY/SPECIFIC WEIGHT	1,07 kg/l
pH	3,1
LAP SHEAR STRENGTH	24 hours + 45 °C / 90 % RH tensile strength is > 8 N/mm ² . Watt 91 tensile strength is > 7,5 N/mm ² .
VISCOSITY	5000 mPas
OPEN TIME	8 minutes closed open time (Pine, 20 °C, 65 % RH, 150 g/m ²) 10 minutes open time (Pine, 20 °C, 65 % RH, 150 g/m ²)
CONSUMPTION	70 - 140 g/m ² .
PRESSING TIME	Pressing time is related to temperatures and power used with heated and HF press.
COMPRESSION PRESSURE	Min. 0.5 N/mm ² recommended.
MINIMUM FILM FORMING	+ 25 °C
APPLICATION TEMPERATURE	15 - 30 °C.
WOOD MOISTURE CONTENT	6 - 15 %
STORAGE	In unopened containers, above +1 °C, for 12 months. After long storing, stir before use.