

## AQUENCE® KL 132

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### Product description

AQUENCE® KL 132 provides the following product characteristics:

<b>Technology</b>	PVA dispersion
<b>Product type</b>	Water resistant as per D3 / EN 204 Assembly glue
<b>Application</b>	Assembly
<b>Appearance</b>	White transparent after drying

### Application areas

- Joints where increased water and heat resistance is required
- Gluing solid wood
- Gluing of blockboard cores and composed solid wood panels
- Doors and stairs
- Windows, window scantlings, composite window elements

### Product properties

- Medium viscosity
- Fast setting, suitable for high frequency
- Longer open time compared to standard D3
- Gives transparent, tough-elastic glue joint
- High water resistance one component = Durability class D3 as per EN 204
- plus cross-linker AQUENCE® CATALYST R 397 or CATALYST R 398 ( 5% ) =Durability class D4 as per EN 204
- High heat resistance, tested according to EN 14257 (WATT 91)

### Technical data

#### AQUENCE® KL 132:

Minimum film formation temperature, °C	~+5
DIN 53787	
Viscosity, - Brookfield RVT, mPa.s	12000 - 18000
Spindle 5/ 20 RPM/ 23°C; ISO 2555	
pH value, 20 °C	2.5 - 3.5
ISO 976	

### Typical properties

#### Open time

Open time, minutes	~8
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#### Pressing time

Surface bonding (Chipboard/HPL):

Quantity applied 100 g/m <sup>2</sup> , minutes	≥ 10
Quantity applied 200 g/m <sup>2</sup> , minutes	≥ 20

### Direction for use

#### Preliminary statement

Prior to use it is necessary to read the **Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

#### Instructions for use

The data shown is based on 8 - 12 % wood moisture, 20 °C room and material temperature, 65% relative air humidity and 0.5 N/mm<sup>2</sup> pressure.

The actual open and setting times will depend heavily on the working conditions such as temperature, humidity and absorption of the wood, surface characteristics, stresses in the material and application thickness of the glue, etc.

The working temperature of the workpiece and glue should be at least +10°C.

When using cross-linker AQUENCE® CATALYST R 397 or CATALYST R 398, the glue can still be used after exceeding of pot life, but loses D4 respectively JAS qualification and goes down to D3.

Final bonding strength and water resistance of D3 or D4 is achieved after 7 days of bonding.

Ensure that the parts to be bonded are close fitting and free from dust and grease.

Fit tolerances increase the setting time and reduce the bonding strength.

Due to the acidic nature of a D3 and D4 dispersion adhesive, some discoloration can occur as some wood types are sensitive to acid (e. g. pine).

Metal parts may cause discoloration, due to their reaction with the tannin of the wood (especially with oak).

Usually, application of the glue to one side only is sufficient. Applying glue to both sides, however, is recommended when gluing difficult-to-bond woods and hardwood, in order to improve bonding strength; in this case the open time is increased.

**Glue/Cross-linker Mixture**

AQUENCE® KL 132 plus 5% cross-linker AQUENCE CATALYST R 397 or CATALYST R 398 = durability class D4 according to EN204.

Glue and cross-linker should be mixed well and used within approx. 7 hours (pot life).

**Cleaning**

Equipment used to apply the glue may be cleaned easily using cold or luke-warm water before the adhesive has dried hard. Hard dried glue remnants have to be removed mechanically.

**Storage**

Store in the original tightly closed container in a cool, dry place away from frost.

Stir well before use.

**Shelf life**

Shelf-life (in unopened original packaging), months 12

**Classification**

Please refer to the corresponding **Safety Data Sheet** for details on:

**Hazards identification**

**Transport information**

**Regulatory information**

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