

AQUENCE® SL 077

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Product description

AQUENCE® SL 077 provides the following product characteristics:

Technology	PVA dispersion
Product type	EPI Assembly glue Waterproof with hardener component as per D4 / EN 204 and JAS
Application	Assembly
Appearance	White, transparent after drying

Application areas

- Gluing of hardwoods
- General assembly work
- Gluing solid wood
- Door and window components
- Sauna and similar applications where high water resistance is requested

Product properties

- EPI-system
- Fast setting
- Gives transparent, tough-elastic glue joint
- Non runny, even on vertical surfaces
- Excellent water resistance together with 15% cross-linker AQUENCE® CATALYST R 396 (brown) = Durability class D4 as per EN 204 and JAS
- High heat resistance, tested according to EN 14257 (WATT 91)

Technical data

AQUENCE® SL 077:

Viscosity, Brookfield - RVT, 5/20/20, mPa.s (cP) ISO 2555	10000 - 15000
pH value 20°C ISO 976	6.5 - 7.5

Direction for use

Preliminary statement

Prior to application 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.

Instruction for use

Open time

Open time (beech/beech):

Quantity applied 150 g/m ² , minutes	~ 7
Quantity applied 200 g/m ² , minutes	~ 10

Pressing time

Surface bonding (Chipboard/HPL):

Quantity applied 100 g/m ² , minutes	≥ 15
Quantity applied 200 g/m ² , minutes	≥ 20

Joint bonding (beech/ beech):

Quantity applied 150 g/m ² , minutes	≥ 30
Quantity applied 200 g/m ² , minutes	≥ 35

The data shown is based on 8 - 12% wood moisture, 20°C room and material temperature, 65% relative air humidity and 0.5 N/mm² 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 glue is supplied ready for use. If required, it can be thinned with water up to 3 %.

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

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).



The glue is carefully mixed with AQUENCE® CATALYST R 396 by adding the cross-linker slowly to the glue under constant stirring. Immediately after the addition the mix starts to foam slightly. The foam can be kept down by continuous slow stirring. Although the viscosity does not considerably change over a period of about 8 hours, the processing time should not exceed 30 minutes, thus guaranteeing superior water resistance.

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.

Application

- thinly and evenly by brush, toothed spatula, manual and automated glue spreader

Potlife

Potlife of the mixture: 30 min

Cleaning

Wet glue may be removed from the equipment with water preferably containing a dish washing agent. Dried glue must be removed mechanically or with the help of ethylacetate solvent. If the solvent is used, the application equipment must be resistant to solvents.

Classification

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

- Hazards identification
- Transport information
- Regulatory information

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