

AQUENCE LD 082

Known as DORUS LD 082

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PRODUCT DESCRIPTION

AQUENCE LD 082 provides the following product characteristics:

Technology	PVA Dispersion
Product Type	Foil Lamination Glue
Application	Assembly
Appearance	transparent after drying

Application Areas

- Lamination of resinated decorative paper or PVC foils to particle board
- Bonding of porous wooden parts to NC lacquered surfaces without previous sanding

Product Properties

- Medium viscosity
- High green tack
- Very short setting time
- Good spreading properties in lamination machines
- Gives smooth glue coat and excellent overall wetting of the foil
- High solid content
- High adhesion to PVC foils
- Dissolving NC lacquer
- Excellent adhesion to NC lacquered surfaces

Technical Data

AQUENCE LD 082:

Minimum film formation temperature, °C (MFFT) DIN 53787	~+3
Viscosity, Brookfield - RVT, 6/20/20, mPa.s ISO 2555	11,000 to 16,000
pH value (20 °C) ISO 976	4.5 to 5.5

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material 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

Open Time

Open time (raw /lacquered beech), min:	~10
Open time (PVC on particleboard) : Quantity applied 100 g/m ² , minutes	~4

Pressing Time

Pressing time (raw/lacquered beech)	≥8
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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 and a glue application weight of 100 g/m² .

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

The glue is supplied ready for use. If required, it can be thinned with water up to 3 %.

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.

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.

The parts are to be joined within the open time and kept under pressure till the initial adhesion is strong enough for further processing.

For gluing to lacquered surfaces pre-tests are recommended in principal. Surfaces have to be free of dust and grease. Since the make and quality of laquers differ considerably, check the suitability of the lacquer glue. The laquer type and age of the laquering can influence open and pressing time. Completely cured lacquered surfaces are difficult to bond. Glue squeezed out of the joint can cull the lacquered surface and should therefore be removed immediately.

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.

Application

Thinly and evenly by brush, toothed spatula, manual and automated glue spreader

STORAGE

Reference 0.0

Store in the original tightly closed container in a cool, dry place away from frost.
Stir well before use.
Storage life up to 12 months.

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information

Transport Regulations

Safety Regulations