Technical Information

Frimpeks

AQUAPEKS WA 8400

Product Information:

AQUAPEKS WA 8400 is a PVA dispersion for wood assembly adhesive. Water resistant as per D4 / EN 204

Product Properties

- Medium viscosity
- Fast setting
- Gap filling
- Gives transparent, tough-elastic glue joint
- One-component D4 glue
- High heat resistance, tested according to EN 14257

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

Technical Data

Minimum film formation temperature DIN 53787	~+5°C MFFT
Viscosity Brookfield 22°C ISO 2555	4.000 - 10.000 mPa.s
pH value (20 °C) ISO 976	2.5 to 3.5

Storage

When properly stored in a cool, dry location, with the container tightly closed when not in use, this product will have a shelf life of at least 9 months. Recommended Storage: 15°C to 25°C. Storage below 10°C or greater than 50°C can adversely affect product properties. The product is frost-sensitive.

Cleaning

Fresh, uncured material (cleaning application equipment, substrate contamination etc.) can be removed with the PUR-CLEANER; cured adhesive can only be removed mechanically.

Packaging

30 kg PE drums
1000 kg in IBC.

Instructions for Use

Open Time

Open time (beech/beech)	
Quantity applied 150 g/m^2	~7 minutes
Quantity applied 200 g/m^2	~11 minutes

Pressing Time

Surface bonding (Chipboard/HPL)	
Quantity applied 100 g/m^2	≥15 minutes
Quantity applied 200 g/m^2	≥25 minutes
Joint bonding (beech/ beech)	
Quantity applied 150 g/m^2	≥30 minutes
Quantity applied 200 g/m^2	≥40 minutes

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^2 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.

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.

All parts which come into contact with the glue must be made either of stainless steel (V2A/V4A) or plastic.

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.

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