

## FOLCO® - LIT 1kD4

### General information

Type of product	<b>FOLCO® - LIT 1kD4</b> is an unfilled PVAc-based adhesive with cross linkable groups.
Field of application	<b>FOLCO® - LIT 1kD4</b> is particularly suitable for applications where an increased water resistance is required:  Fitted parts in the interior area which are very often in contact with draining water or condensation as for example furniture in damp rooms / bathrooms and kitchens/canteens.  For parts which are exposed to the weather, however, with appropriate surface protection.  For the bonding of wood and wooden materials, bonding of joints in boards and block gluing of hard and soft wood, surface bonding of e.g veneers, HPL/CPL, installation of lamination flooring.
Properties	<b>FOLCO® - LIT 1kD4</b> is a highly water resistant wood adhesive which corresponds to the durability class D4 according to DIN EN 204. It is not necessary to add any hardener (no pot life has to be considered!). <b>FOLCO® - LIT 1kD4</b> achieves a high final strength with only short press times. Can be stored for approx. 6 months.

### Characteristics

Viscosity (on the day of manufacture)	approx. 5000 m·Pas	(Brookfield RVT, 20 °C, Sp. 6, 20 Upm.)
pH-value:	approx. 3	

### Further properties

Min. film forming temperature (MFT):	+ 8	°C
Density	1,08	g/cm <sup>3</sup>
Open time at 150 g/m <sup>2</sup>	max. 6 - 10	min.

### Instructions for use

Wood preparation:	Work pieces should be properly planed and free of dust and grease. Tolerances cause prolonged setting times and less mechanical strength.
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#### Use

Among others, the temperature, humidity and absorption of the materials, the coating weight and the tension within the material have different influence on the open time, the setting time and the pressing time. Heat accelerates the setting procedure and shortens the open time.

For good results we recommend the following working conditions:

Room, material and adhesive temperature	18 – 22	°C
Wood moisture (should correlate with the later wood moisture)		
Interior use: approx.	6 – 12	%
Exterior use: approx.	11 - 15	%
Relative air humidity	60 – 70	%
Coating weight: for surface bonding for assembly	80 ... 150 100 ... 180	g/m <sup>2</sup> g/m <sup>2</sup>
Press pressure for tensionless work pieces	0,1 – 1	N/mm <sup>2</sup>
Minimum pressing time: Surface bonding (HPL / chipboards)	ca. 1	min.
with 70°C	30 – 40	min.
with 20°C	5 – 10	sec.
decor –finish film (short cycle presses)	8 – 15	min.
Assembly		

**FOLCO® - LIT 1kD4** is applied with the common application tools on one or both sides. The coating weight depends on the absorption and the surface conditions of the materials to be bonded. Do not apply below +10°C (room and material temperature).

Within the open time the parts are to be joined and pressed.

The compatibility with other adhesives has to be checked before mixing.

The final water resistance is built up after approx. 7 days.

#### Wood discoloration

Usually **FOLCO-LIT 2kD4** does not lead to wood discoloration. Because of the varied nature of wood components unpredictable discoloration may in some cases

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appear. E.g. iron together with the tannin in wood may cause discoloration. We recommend to do your own trials.

#### Cleaning

Fresh and not yet dried adhesive can be removed with water immediately after use.

### Additional advices

#### Safety advice

An EC health and safety data sheet for **FOLCO® - LIT 1kD4** is available and has to be considered before handling, storage or use of the product.

#### Storage

In original containers under suitable conditions **FOLCO® - LIT 1kD4** can be stored for min. 6 months. The material should be stored cool and free from frost. A storage temperature of above 25° C minimizes considerably the storability of the product.

The characteristics which are necessary for the products' allowance are checked by our quality control department during production and before delivery. Dependent on the storage temperature and the time the values can change and fall below or exceed the indicated limits. The viscosity of **FOLCO® - LIT 1kD4** may increase after a longer storage time. In this case we recommend to stir the product before use. However, this does not influence the adhesion properties of the product.

**Last change      03.05.2005**

This data sheet replaces all former technical information.

Instructions on the application methods of our products are based on comprehensive development work and years of experience. They are provided to the best of our knowledge. The most diversified requirements to the object under extremely varying conditions require a suitability test by the processor for the corresponding application. We reserve the right to introduce modifications for the purpose of technical progress or an improvement of our products. The agreed-upon characteristics of the product are finally detailed in this technical data sheet. All additional agreements concerning the characteristics must be made in writing. This applies in particular to products' suitability for any specific application.