

AQUENCE FD 151

December 2020

PRODUCT DESCRIPTION

AQUENCE FD 151 provides the following product characteristics:

Technology	PUR
Product Type	Dispersion
Application	3D Application
Appearance	Liquid, transparent after drying

Application Areas

- Thermoforming presses (with and without membrane)
- Furniture fronts for the living area

Product Properties

- Free of solvent
- Heat resistance variably adjustable
- Highest heat and moisture resistance
- Sealable at lowest temperature

Technical Data

AQUENCE FD 151:

pH value, 20°C: ISO 976	6 to 9
Viscosity, Brookfield - RVT, 3/20/20, mPa.s ISO 2555	1,400 to 2,700

DIRECTIONS OF 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.

Instructions for Use

In general, AQUENCE FD 151 is applied together with 5% cross-linker AQUENCE CATALYST R 397, which should be slowly added to the dispersion glue under constant stirring.

The working temperature of the workpiece and glue should be over +18°C to achieve optimal bonding results. Lower working temperature results in higher viscosity of the glue.

The glue mix is sprayed with an appropriate spraying gun (nozzle size: 1,4 to 2 mm). As a rule, it is sufficient to apply one coat to the flat surface. Open pore inner and outer radii, however, need to be coated a second time after a brief drying interval. The pre-glued pieces should be sealed within 24 hours to achieve optimum bond.

Please note

Temperatures above +25°C will shorten the max. storage time of pre-coated fronts significantly.

Drying time, minutes depending on temperature, humidity and quantity applied	≥30
Activation temperature in the glue line, °C at the edges	≥50
Curing time, hours complete curing after 7 days	24

Processing

Processing time, hours with 3-10% cross-linker AQUENCE CATALYST R 397 (Depending on temperature)	4 to 6
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All parts which come into contact with the glue must be made either of stainless steel (V2A/V4A) or plastic.

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

The glue should be transported and stored in the tightly closed original container at temperatures above + 10 °C and below max. + 30 °C.

Cooling below +10 °C can lead to coagulation.

Storage life is up to 9 months.

Classification

- Please refer to the corresponding **safety data sheets** for details on:
Hazardous Information
Transport Regulations
Safety Regulations

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