Wisacoll® HPK 601

Liquid 1-component hybrid assembly adhesive with D4 water resistance, hard and weather-resistant; ideal for wood-based materials, colour: beige

Application areas

Extremely strong, high-quality hybrid polymer adhesive of the latest generation for hard, constructive, long-lasting and waterproof bonding (D4)

- in the entire construction, assembly and industrial sector
- in window and door construction
- for board joint gluing of cassettes in the wood, window and front door sector
- in the floor area (stair treads, skirting boards, laminate installation)
- suitable for repairing wooden surfaces indoors and outdoors
- ideal for carpenters, timber construction, stair construction, window manufacture, garages, handicraft and industry

Product benefits

- no labelling obligation
- extremely high final strength, stronger than wood
- waterproof, achieves stress group D4 for wood / wood bonding in accordance with EN 204
- neither shrinkage nor foaming (no rectification necessary)
- compatible with natural stone
- solvent-free (VOC emission class A+)
- almost odourless
- EU: No training obligation (isocyanate free)
- silicone free
- good processing viscosity (easy to spread)
- sandable when cured
- recoatable, lacquerable
- for indoor and outdoor use
- no risk of corrosion
- good UV, weather and ageing resistance
- above-average hardness for hybrid adhesives
- above-average tensile strength and tensile shear strength
- low consumption (is pressed down to «0»)
- cost-saving, as no minimum layer thickness is required
- good adhesion to the majority of substrates used in the construction industry, even those that are slightly damp like wood-based materials, masonry, metals, aluminium, natural stone, many plastics etc.
- for indoor and outdoor use

Base

Silane-modified polymers (SMP) of the latest generation; cross-linking is chemically neutral with air humidity.

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Restrictions	When bonding different materials (especially outdoors), the thermal linear expansion of the different materials must be taken into account; if necessary, use an elastic assembly adhesive. Not suitable for PE, PP, PTFE, PVC-soft, Teflon®, bitumen and waxy substrates. Not recommended for glass and mirrors.
Cleaning agents	Wisaclean R 216 for cleaning non-absorbent adhesive surfaces and fresh product residues. The cured product can normally only be removed mechanically. To wash your hands, please use water and soap.
Processing	Acclimatise the product before processing. The bonding surfaces must be sound and free of dust and grease. Depending on the surface of the material, it will be necessary to determine whether the adhesion can be improved by sanding or priming the surface. Clean non-absorbent surfaces with Wisaclean R 216 and if necessary sand beforehand. Check treated and non-absorbent surfaces with an adhesion test.
To be considered when bonding	Apply the adhesive. Join parts to be glued together as quickly as possible (Pull out the first wipes from the centre of the can and push them through the opening in the lid.). Press or at least fix parts until sufficient functional strength is achieved. If non-absorbent materials (material moisture <8 %) are bonded together, the adhesive must also be «finely dusted» with water in order to achieve complete curing. If necessary, protect parts that are not to be glued with a PE film.
Remark	Skin formation, dwell time, time to functional strength and curing are largely dependent on temperature, air and material humidity, application thickness and substrate. The processor must add appropriate safety margins to the specified guide values.
Bonding of metals	▪ In most cases, the adhesion will be improved by sanding smooth surfaces with abrasive paper (e.g. P 120).
Bonding of wood	▪ When gluing wood, the wood moisture content must not exceed 15 % or fall below 8 %. If the wood is very dry, it is advisable to wipe the surfaces to be glued with a cloth slightly moistened with water just before applying the adhesive. ▪ In the case of woods rich in substances / oily woods, e.g. teak, wash the bonding surfaces with Wisaclean R 216. ▪ When gluing solid wood, the adhesive should preferably be applied to both glued surfaces. Precise fit is absolutely essential. ▪ The pressing pressure should be >1 N/mm^2. Experience has shown that the final strength increases with the level of pressing pressure. ▪ Provide the exterior wood with a suitable surface protection and protect it structurally.
Density	ca. 1.6 g/ml
Tensile strength	ca. 13.5 N/mm^2 at +20 °C (EN 205)

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Water resistance	D4 (acc. to EN 204)
Volume shrinkage	<3 % by volume
Recoatability	Can be overpainted wet-on-wet with many lacquers immediately after application. Can be painted over after complete cross-linking with most paint systems, except mineral paints. Due to the many colour formulations used in practice, own tests are necessary. The use of alkyd resins and synthetic resin paints may cause a delay in the drying process.
Shore hardness	ca. 80 - 85 (Shore-A) ca. 30 (Shore-D)
Consistency	low viscous-liquid; the viscosity during processing at 15 °C is about twice as high as at +25 °C
Skin formation	ca. **10 - 20 min** under normal conditions (+20 °C, 50 % rel. humidity)
1st functional strength **Final strenght**	from ca. 1 h; wood-wood bonding at +20 °C, 50 % rel. humidity The strength increases slowly over time. Depending on the layer thickness, it may take several days to weeks to reach the final strength.
Applied quantity	ca. 150 g/m^2 depending on the carrier material
Temperature resistance	from -40 °C up to +90 °C (after complete cross-linking) for a short time even at higher temperatures
Processing temperature	from +5 °C up to +40 °C
Frost resistance	up to -30 °C (during transport)
Substrates	Wood, wood-based materials, gypsum fibreboards, skirting boards, window sills, corian, concrete, compact masonry, ceramics, enamel, aluminium, steel, galvanized steel, PVC-hard, polyester, epoxy, glass fibre reinforced plastics, Sagex®, decorative, polyurethane and polystyrene foam panels, many thermoplastics and duroplastic plastics (except PE and PP) and many other materials. In case of other surfaces, own tests are required.
Further information	More information about this product (current technical data sheet, safety data sheet, certificates, product variants, etc.) can be found via the adjacent QR code.
Item no. + Colour	**HPK 601.380 beige** - PE bottle of 380 g
Delivery form **Content quantity**	Packing unit of 12 PE bottles of 380 g

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Shelf life

In closed original packaging, protected from direct sunlight and stored in a dry place between +15 °C and +25 °C, the official shelf life is 18 months from date of production (the printed expiry date is decisive). Over storage time, viscosity increases and reactivity decreases.

Safety and disposal: Familiarise yourself with the valid Safety Data Sheets (SDS) for the products used. All applicable safety regulations and disposal instructions must be observed.