

# WAKOL D 3540 Cork Contact Adhesive

## Technical Information

### Area of application

Dispersion contact adhesive for laying

- Cork flooring with natural cork backing according to ISO 3813 or DIN EN 12104, also veneered, waxed or presealed
- Cork wall coverings
- Textile flooring
- Linoleum
- rubber flooring
- Impact walls (e.g. MAWI TEX)

on properly prepared absorbent and non-absorbent subfloors indoors.

### Special properties



- solvent-free as defined by TRGS 610
- can be walked on immediately

- 1) Based on the criteria of GEV (Association for Emission-controlled Laying Materials), classified as EMICODE EC1 PLUS: very low in emissions  
2) Emissions class according to French law  
3) Solvent-free dispersion laying materials  
4) Emissions-certified construction product i.a.w. DIBt principles: Wakol GmbH, 66954 Pirmasens  
5) Suitable for underfloor heating  
6) Suitable for exposure to castor wheels

### Technical data

Raw material base:	Latex/acrylate dispersion
Airing time:	approx. 30 - 45 minutes on absorbent subfloors approx. 60 - 90 minutes on non-absorbent subfloor and on the rear side of the flooring
Open time:	approx. 2 - 3 hours for precoated corkboards 1 - 1,5 hours

Cleaning agent: Water, before adhesive starts to dry  
 Storage time: 12 months at room temperature  
 Storage temperature: not below +5 °C, sensitive to frost

#### Application and consumption<sup>7)</sup>

WAKOL Primer Roller, 11 mm	at least 250 g/m <sup>2</sup>	Cork flooring Linoleum Rubber flooring Impact walls
Velour roller		
TKB A1 - A3	450-650 g/m <sup>2</sup>	Textile flooring

7) Consumption is dependent on surface structure and absorbability of subfloor.

## Subfloors

The subfloor as well as the room climate conditions must meet the requirements of the applicable standards and data sheets. Subfloors must be permanently dry, solid, level, free from cracks, dirt and adhesion-inhibiting substances. Existing floor coverings must be firmly bonded to the subfloor and have a smooth surface free of wax and other treatment products.

Smooth, level subfloors are required for cork bonding with WAKOL D 3540 Cork Contact Adhesive. Levelling compound should therefore be applied to uneven subfloors as well as to rough screed surfaces using a suitable cement-based Wakol levelling compound, such as WAKOL Z 610 Levelling Compound, dust-reduced, before proceeding. The technical information on the primers and levelling compounds must be heeded. Levelling compound must always be applied to calcium sulphate (anhydrite), magnesite and xylolite screeds and mastic asphalt, with a layer thickness of at least 2 mm. Render that is not sufficiently level must be smoothed using a high-quality fine levelling compound before cork wall coverings can be bonded. Do not install on PVC/CV flooring.

Ground levelling compounds with WAKOL D 3004 Primer Concentrate diluted in a 1:2 ratio with water or WAKOL D 3003 Dispersion Primer prime. Primer must be fully dry before bonding work.

## Usage

Stir adhesive well before using. Using an appropriate applicator, apply generously and uniformly on the subfloor and the back of the flooring, without letting the adhesive pool. Determine the application quantity so as to obtain a closed adhesive film. After the adhesive dries, the adhesive surfaces must present a closed and uniformly glossy film.

Once both adhesive films have dried and become transparent, the flooring is precisely fitted and patted down well with a rubber hammer. The flooring that has been laid can be walked on immediately. In the case of natural cork, the surface can be sealed after 24 hours.

Cork tiles can be pre-coated with WAKOL D 3540 Cork Contact Adhesive before the day they are laid (up to 24 hours in advance) or mechanically pre-coated with WAKOL D 3513 Cork

Pre-Coating (up to 6 months before they are laid). On the day they are laid, the adhesive only needs to be applied to the subfloor and, following a sufficient airing time, the pre-coated cork tiles can be fixed in place using the contact method. In this instance, the open time is 1 - 1.5 hours.

## Important

Processing not below floor temperature of +15 °C and room temperature of +18 °C, as well as room humidity preferably between 40 % and 65 %, maximum 75 %. All information is based on approx. 20 °C and 50 % relative air humidity.

In cold weather, warm up all laying materials in a heated room before use. WAKOL D 3540 Cork Contact Adhesive is not suitable for bonding cork flooring with PVC backing according to DIN EN 655 – please consult our Application Technology department before undertaking laying work.

We guarantee the uniform high quality of our products. All data is based on tests and many years of practical experience and refers to standardised conditions. The variety of materials used and the different construction site conditions, which lie beyond our control, preclude any claims based on this data. We therefore recommend making sufficient trials. Accompanying flooring manufacturer's instructions and the current national standards must be observed. We gladly provide technical advice.

The product data sheets can be found in their latest version at [www.wakol.com](http://www.wakol.com).

This Technical Information of 17.12.2024 supersedes all previous versions.