

# KLEIBERIT 605.1

## 1C STP Adhesive

### Fields of application

- Manufacture of wall elements and other non-load-bearing structures made of wood and wooden materials
- Manufacture of wood products that are exposed to the weather, such as windows, doors, fence elements and terrace components, each with a suitable surface protection
- Adhesion of wooden products and elements that are subject to high loads or are temporarily exposed to increased moisture, such as Parquet flooring, sauna and bathroom furniture
- Bonding of different materials such as: mineral building boards, ceramic materials, concrete materials, rigid foams, wood, glass, metals and many plastics
- Carcase and frame gluing

### Advantages

- Fast and bubble-free curing
- UV and weather resistant
- Adhesion to painted surfaces, many plastics and metals
- paintable (due to the variety of lacquers and paint systems available on the market, preliminary tests are necessary).
- workable from 5+ -30°C
- No pressing pressure is required for straight joining surfaces. Stacking pressure is sufficient

### Properties of the bond

- The glue joint is resistant to high temperatures
- Bond quality D4 according to DIN EN 204 (See ift Test Certificate No. 21-000886-PR01 dated 31/05/2021)
- Tested according to DIN EN 14257 (Watt 91) (See ift Test Certificate No. 21-000886-PR02 dated 30/04/2021)

### Properties of the adhesive

<b>Base:</b>	STP (silan terminated polymers)
<b>Colour:</b>	beige
<b>Specific gravity:</b>	approximately 1.15 g/cm <sup>3</sup>
<b>Viscosity at 20°C</b>	
<b>- Brookfield RVT:</b>	ca. 10,000 mPa s
<b>Consistency:</b>	thin liquid

**Identification:** see our safety data sheet

**Note:** Intended for commercial use only.

### Application techniques

#### Processing conditions:

The substrates to be bonded have to be tempered to at least 18 °C room temperature.

The substrates must be clean, dry and free from grease.

At wood-based materials the material moisture shouldn't be below 5 %.

Remove release agent from the substrates to be bonded if present.

Do not process KLEIBERIT 605.1 below +5°C.

The following data is based on experience and is to be understood as an indication. Due to the large number of different materials and process-related influencing variables at the respective user, the values stated may vary to a certain extent. If necessary, they must be adjusted accordingly by the user and checked for suitability on his own responsibility.

#### Application methods:

The application to the substrates can be done by brush, roller, notched trowel or nozzle systems.

#### Application:

Single-sided application suffices on less porous surfaces

#### Application quantity:

100-200 g/m<sup>2</sup> according to the condition of the material

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### Open time:

Approx. 8 minutes at approx. 50 °C relative humidity. This period is reduced by high room temperatures, high humidity or the supply of moisture.

### Setting:

The adhesive hardens to a water-resistant, solvent-resistant and semi-rigid adhesive film when exposed to humidity (from the air or materials being bonded).

The cross-linking process can be accelerated by means of targeted moisture supply in the form of a fogging system or by higher temperatures (40°C up to max. 80°C).

### Fixing the parts:

No pressing pressure is required for the cross-linking process. The parts to be joined may only need to be fixed in place. Protect pressing surfaces from leaking adhesive by placing silicone paper on them.

The required pressure depends on the type and size of the workpieces; a good joint fit should be achieved.

### Press times:

The press times are dependent on temperature and moisture supply.

Guide values:

Temp.	Press time
20 °C	from 90 minutes
40 °C	from 60 minutes
60 °C	from 45 minutes
80 °C	from 30 minutes

Exact times must be established for the particular application according to the conditions in question.

### Final setting time:

Subsequent processing of the bonded parts is possible after approx. 1 -2 hours, *final strength is achieved after approximately 24 hours.*

### Cleaning

Clean application tools with KLEIBERIT 823.3 **immediately** following use.

### Packaging

#### KLEIBERIT 605.1:

Plastic bottle, 0.75 kg net

Plastic canister, 7.5 kg net

IBC, 1,300 kg net

### Cleaner

#### KLEIBERIT 823.3:

metal can, 4.5 kg net

Additional packaging available upon request.

### Storage

KLEIBERIT 605.1 can be stored in closed air-tight containers at 20°C for approx. 9 months.

Keep in a cool and dry place and carefully protect from humidity. Opened containers should be used up as soon as possible.

KLEIBERIT PUR Adhesive 605.1 is not frost sensitive at temperatures above -25°C.

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#### Adhesive and Waste Disposal

##### Waste Code 080501

Our containers are made of recyclable material. Well drained containers can be recycled.

#### Service

Our application department may be consulted at any time without obligation. The statements made herein are based on our experience gained to date. They are to be considered as information without obligation. Please test and establish for yourself the suitability of our products for your particular purposes. No liability exceeding the value of our product can be derived from the foregoing statements. This also applies to the technical consultancy service which is rendered free of charge and without obligation.