KLEIBERIT 152.0

Fields of application
Bonding of
- Wood and wood based materials to each other
- Foam materials (except polystyrene foam) to each other or to textile fabric, wood and other solvent resistant materials
- Paper and cardboard materials
- Floor coverings (PVC, linoleum, carpet) for the manufacture of double floorings on substrates made of wood based materials, concrete, gypsum and metal
- Post-forming contact process

Advantages
- Versatile applicable
- High green strength
- low viscosity

Properties of the bond
Processing ability:	immediately after bonding
Final strength:	after approx. 7 days, with addition of hardener, after 3 days
Temperature resistance:	approx. -20 °C to more than +80 °C, without hardener approx. -20 °C up to 140 °C with hardener
Ageing:	good ageing resistance, no embrittlement

Properties of the adhesive
Base:	polychloroprene
Solvents:	mixture
Specific weight:	approx. 0.830 g/cm³
Colour:	152.0 = yellowish – beige 152.5 = red 152.6 = blue
Viscosity (20°C)	
Brookfield, sp. 2/20 rpm::	approx. 550 +/-150 mPa.s
Consistency:	low viscosity
Cleaner + Thinner:	KLEIBERIT 820.0
Hardener:	KLEIBERIT 801.0, 5 % addition
Pot life with hardener:	approx. 4 hours
Open time:	approx.. 5 minutes without hardener approx. 4 minutes with hardener
Identification:	see our safety data sheet

Application methods
- With spray gun
- With casting machine
- Brush

Application techniques
The materials to be bonded must be dry and free from dust, oil and grease. All materials must be acclimatised before processing. The ideal process temperature is 18-20°C. Do not process below 15°C. The best moisture content of the wood is at 8-12 %.

Before processing stir the adhesive.
For thinning of the adhesive use only KLEIBERIT 820.0.

By addition of 5% KLEIBERIT 801.0, temperature resistance, adhesion strength to various materials as well as resistance to chemicals and humidity are improved.

Evenly apply the adhesive to both parts.

Let the adhesive evaporate for 3-5 minutes, when hardener is added for 2-4 minutes.
The evaporation time is dependent on the quantity applied, the temperature and the flow of air. When bonding, the adhesive shall no longer be stringy but must still be tacky.

Spray application:
nozzle diameter 1.3 – 1.7 mm
pressure 3-4 bar

KLEIBERIT SE & Co. KG, Max-Becker-Str. 4, 76356 Weingarten/Germany
Phone: +49 7244 62-0, Fax: +49 7244 700-0
Email: info@kleiberit.com, **www.kleiberit.com**

KLEIBERIT 152.0

Application quantity:
100-150 g/m² for each bond surface

The quantity applied is sufficient when after a short evaporation time a uniform adhesive film is visible.

The parts to be bonded must be precisely put together. Subsequent corrections are not possible. The bonding has to be done under high pressure, at least 0.3 N/mm² for flexible materials and 0.5 N/mm² for rigid materials. A few seconds press time is sufficient.

The higher the pressure, the higher the strength of the bond!

The bonded parts can immediately be further processed.
With addition of hardener the final strength is achieved after approx. 3 days.

Cleaning
Work tools can be cleaned with KLEIBERIT 820.0.

Packaging
KLEIBERIT 152.0:
metal can, 4.5 kg
metal bucket, 24 kg net

KLEIBERIT 820.0:
metal can, 24.0 kg net
KLEIBERIT 801.0:
carton with 12 metal bottles, 0.940 kg net each

Additional packaging sizes available upon request.

Storage
The adhesive should not be stored under -10°C and not over +30°C.

If stored below -10°C, the adhesive will thicken. In this case, it must be brought to a processing temperature of +18°C to +20°C per means of indirect heat.

KLEIBERIT 152.0 can be stored in factory sealed containers at temperatures of 15-25°C for approx. 12 months.

Bring to room temperature and stir before use.

Version 13.12.2022 lz; replaces previous versions

Waste Disposal
Disposal of contents and/or containers should comply with all applicable federal, state and local regulations.
Our containers are made of recyclable material.

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.

KLEIBERIT SE & Co. KG, Max-Becker-Str. 4, 76356 Weingarten/Germany
Phone: +49 7244 62-0, Fax: +49 7244 700-0
Email: info@kleiberit.com, **www.kleiberit.com**