

KLEIBERIT 501.8

1C PUR Adhesive

Fields of application

- Bonding windows and doors
- Laminate bonding of wood and wood materials
- Joint bonding for outdoor use
- Bonding of mineral building boards, ceramic and concrete materials and hard foams

Advantages

- Single-component adhesive, no pot life problems
- Easy application

Properties of the bond

- The glue joint is resistant to high temperatures and achieves highest bonding strength
- Bond quality D4 according to DIN EN 204 (See ift Test Certificate No. 505 36161/1 dated July 7, 2008)
- Tested according to DIN EN 14257 (Watt 91) (See ift Test Certificate No. 505 36161/2 dated July 7, 2008)
- Classification of thermosetting adhesives for non-structural applications according to EN 12765 stress group C4 (See ift Test Certificate 18-000219-PR05 dated March 3, 2018)

Properties of the adhesive

Base:	Polyurethane
Colour:	brown
Specific gravity:	approximately 1.13 g/cm ³
Viscosity at 20°C	
- Brookfield RVT:	7,000 \pm 2,000 mPa s
Consistency:	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 501.8 below +5°C.
The following information is based on experience and is to be understood as an indication. Due to the large number of different materials and technical process parameters of the respective user, the values mentioned may vary within a certain range. If necessary, they must be adjusted accordingly by the user and checked for suitability on his own responsibility.

Application methods:

The application can be done with spatula, roller or nozzle equipment.

Application:

Single-sided application suffices on less porous surfaces

Application quantity:

100-200 g/m² according to the condition of the material

Open time:

Approx. 8 minutes at approx. 20°C. 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 (water spray, approx. 20 g/m²) or by higher temperatures (40°C up to max. 80°C).

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Pressing the parts:

The cross-linking process takes place when sufficient pressure is applied to ensure contact with the surfaces to be bonded. The necessary pressure is dependent on the kind and size of the materials; a good joint fit should be ensured. Minimum pressure for the bonding of laminated wood: **0.6 N/mm²**. The more intensive the cross-linking of the adhesive under pressure, the higher the subsequent loading ability.

Press times:

The press times are dependent on temperature and moisture supply.

Guide values:

Temp.	Press time
20 °C	from 30 minutes
40 °C	from 15 minutes
60 °C	from 7 minutes
80 °C	from 4 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 hour, final strength is achieved after approximately 24 hours.

Cleaning

Clean application tools with KLEIBERIT 820.0 **immediately** following use.

Packaging

KLEIBERIT 501.8:

metal can, 6 kg net

metal can, 30 kg net

carton with 12 plastic bottles, 0.5 kg net

Cleaner

KLEIBERIT 820.0:

metal can, 4.5 kg net

Additional packaging available upon request.

Storage

KLEIBERIT 501.8 can be stored for approx. 6 months at 20°C in airtight plastic bottles without an aluminium bag. In all other airtight sealed containers KLEIBERIT 501.8 can be stored at 20 °C for 12 months.

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

KLEIBERIT 501.8 is not frost sensitive at temperatures above -25°C.

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