

# KLEIBERIT 605.1.20

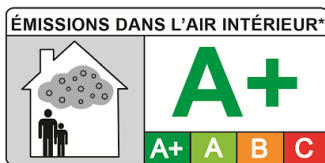
## 1C STP Adhesive

### Fields of application

- Manufacture of non-load-bearing structures made of wood and wood based materials for interior and exterior use with suitable surface protection
- Bonding of polyester fiberglass-reinforced plastic (FRP), epoxy FRP, hot-dip galvanized steel, electrolytically galvanized steel, stainless steel, aluminum, brass, copper, glass, and concrete to wood-based materials such as blockboard, particleboard, and MDF. If other materials are to be bonded, or if pretreatment is generally required, this must be verified by the user.

### Advantages

- Very low-emission (EMICODE® EC 1<sup>PLUS</sup>) according to GEV EMICODE classification (GEV-licencing no.: 17390/01.01.11 dated 11.02.2026)
- Emission class A+ according to French VOC regulations



- Bubble-free curing
- No swelling, no shrinking
- Paintable (Due to the variety of paints and coating systems available on the market, preliminary tests are necessary)
- Processable from 10 °C – 30 °C

### Properties of the bond

- The glue joint is highly resistant to heat and cold
- Adhesive bonding quality D4 according to DIN EN 204 (ift test report no. 25-004035-PR01 dated December 2, 2025)
- Tested according to DIN EN 14257 (Watt 91) (See ift Test Certificate No. 25-004035-PR02 from 02.12.2025)

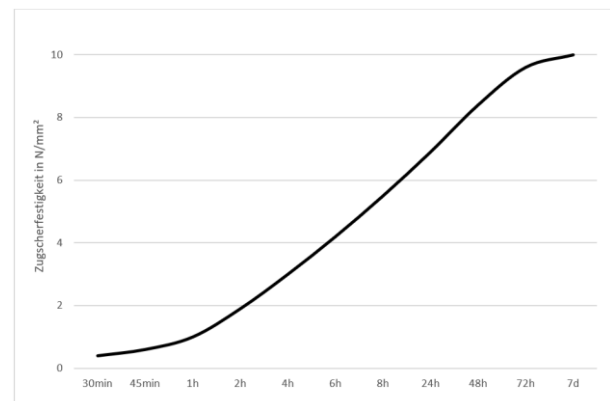
### Properties of the adhesive

<b>Base:</b>	STP (silane terminated polymers)
<b>Colour:</b>	beige
<b>Specific gravity:</b>	approx. 1.5 g/cm <sup>3</sup>
<b>Viscosity at 23°C at 6.8/s - Brookfield RVT:</b>	approx. 10,000 mPa s
<b>Consistency:</b>	thin liquid

**Identification:** see our safety data sheet

### Strength structure:

Orientation for a 0.1 mm thick adhesive joint between two beech wood test specimens at 20 °C / 50 % rel. humidity



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### Application techniques

The bonding surfaces must be sound, dry, and free of dust and grease.

For wood-based materials, the moisture content must not fall below 5%.

Substrates such as metals should be sanded for better adhesion. If release agents or similar substances are present on the surface to be bonded, they must be removed before bonding.

The user must verify adhesion and compatibility by conducting preliminary tests with their own substrates under individual conditions.

Do not process KLEIBERIT 605.1.20 below +10 °C.

The following information is based on experience and should be considered as an indication. Due to the wide variety of materials and process-related factors at each user's site, the stated values may vary. The user must adjust them accordingly as needed and independently verify their suitability.

For bonding large areas, at least one substrate must have sufficiently permeable properties unless additional moistening is performed before pressing.

### Application methods:

The coating can be applied to the substrates using a brush, roller, notched trowel or caterpillar application system.

### Adhesive 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

### Open time:

Approximately 15 minutes at approximately 20°C and 50% relative humidity. High room temperature, high humidity, or the addition of moisture will shorten this time.

The substrates must be combined within the specified open time.

### Pressing the parts:

Protect the pressing surfaces from leaking adhesive by applying silicone paper.

### Pressing pressure:

0.3 - 0.5 N/mm<sup>2</sup> depending on the material properties.

### Press times:

The times depend on the temperature and humidity. Exact times must be determined for each application based on the specific conditions.

The following are guidelines for the pressing temperature:

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

### Final setting time:

The suitability of the glued parts for further processing must be checked by the user based on the prevailing conditions. As a guideline, 90 minutes is recommended at 20 °C and 50% relative humidity. Complete curing is achieved after 7–10 days.

#### Disposal of containers and contents

#### Waste disposal key 080501

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 605.1.20

### Cleaning

Clean application equipment immediately after use with KLEIBERIT 816.0.

### Packaging

#### KLEIBERIT 605.1.20:

carton with 12 plastic bottles á 0,75 kg net  
plastic canister, 7.5 kg net  
IBC, 1,300 kg net

### Cleaner

#### KLEIBERIT 816.0:

Metal bottle, 0.65 kg net  
metal can, 4.5 kg net

Additional packaging available upon request.

### Storage

KLEIBERIT 605.1.20 can be stored for approximately 12 months in an airtight container at 20°C.

Store the container in a cool, dry place.

Protect the adhesive carefully from moisture.  
Use opened containers promptly.  
KLEIBERIT 605.1.20 is not sensitive to frost at temperatures above -25°C.

Version 12.03.2026 al; replaces previous version

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