

KLEIBERIT 517.0

2C Adhesive

Fields of application

Bonding of automotive headlights

Advantages

- Fast curing
- Permanently elastic
- Solvent-free
- favorable fogging values

Properties

Two-component system

Base: polyurethane
Component A: KLEIBERIT 517.0
Component B: KLEIBERIT 517.1
Mixing ratio: Cp. A : Cp. B = 100:20 by weight
 (approx. 100 : 24 by volume)

Density at 23°C:
 Comp. A: approx. 1, 61 ± 0,03 g/cm³
 Comp. B: approx. 1, 35 ± 0,02 g/cm³

Color:
 Comp.A: black
 Comp.B: beige
 Mixture: black

Viscosity at 23°C (Brookfield RVT)

-Sp. No. 7, 20rpm:
 Comp. A approx.. 130,000 ± 10.000 mPa·s
- Sp. No. 6, 20rpm:
 Comp. B approx. 27,000 ± 7.000 mPa·s

Consistency:
 Comp.A: pasty
 Comp.B: flowing

Assembling time (applied as bead):
25 - 45 seconds

Pot life, 23 °C (100g hand mixture)
2-4 minutes

Hardness: approx. 75 Shore A

Tensile shear strength (23 ° C, PC with PP plasma-treated): > 2 MPa

Identification:

Comp. A: no identification required according to EU regulations

Comp. B: identification required according to EU regulations, contains diphenyl methane -4.4'-diisocyanate (see our safety data sheet)

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Application techniques

- with 2 C mixing and dosing unit

Processing

The surfaces of the materials to be bonded must be free of dust, grease and oil. Homogenize Component B before use if required.

The material to be bonded shall be optionally pretreated by plasma or flame. Adhesion tests prior to application are recommended.

Before application, the components should be in the correct mixing ratio, homogeneously mixed and processed within the pot life.

The processing temperature should not be below +15°C.

The ideal application temperature is at 20 - 25 ° C. Higher temperatures accelerate, lower temperatures slow down the curing process.

Cleaning

For cleaning the applications it is suitable to use the KLEIBERIT 820.0 or other solvents. Cured adhesive can only be removed mechanically!

To clean the mixing and dosing unit, please observe the instructions from the manufacturer.

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.

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Packaging

KLEIBERIT 517.0 Comp. A:

Metal pail, (Ø 285 mm cylindrical) 30 kg net
Metal pail, (Ø 305 mm conical) 40 kg net
Metal drum, 250 kg net

KLEIBERIT 517.1 Comp. B:

Metal pail, (Ø 280 mm cylindrical) 32 kg net
Metal pail, (Ø 305 mm conical) 32 kg net
Metal drum, 250 kg net

KLEIBERIT 820.0:

Metal can, 22.0 kg net

Additional packaging sizes available upon request.

Storage

Both components can be stored in factory sealed containers at room temperature for at least 6 months.

Both Components are not frost sensitive over -20°C.

Optimum storage temperature: 15°C - 25°C

It is recommended that open containers are flushed with nitrogen (protective gas).

Component B may react with moisture and will form a crust if exposed to ambient air. Therefore all containers should be tightly closed.

Version 19/10/2020 ga; replaces previous versions

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