

KLEIBERIT 541.6

2C PUR Adhesive

Fields of application

- For strong adhesion of polystyrene foam and PUR foam and other insulation materials with sheet metal, fiber glass reinforced polyester and other laminate sheets.
- For building insulation materials - heat range up to approx. +90°C
- Manufacture of filters with self-supporting end caps made from **compact** and **hard** curing PUR
- Bonding filter end caps for oil-, Diesel- and kerosene filters

Advantages

- Single sided application
- Economical application with roll applicator, two-component mixing and dosing units and felt rollers
- Due to the usage time, also possible for manual processing
- Good bond strength

Properties of the adhesive

Two-component system

Base: Polyurethane
Component A: KLEIBERIT 541.6
Component B: KLEIBERIT 870.0
Mixing ratio:
 Comp. A :Comp. B 4 : 1 by weight

Specific weight (20°C):

Comp. A approx. 1.59 g/ cm³
 Comp. B approx. 1.23 g/ cm³
 Mixture approx. 1.52 g/ cm³

Color of the mixture: beige

Viscosity at 20°C (Brookfield 20 rpm):

Comp. A 30,000 ± 5000 mPa·s
 Comp. B 120 ± 50 mPa·s
 Mixture 3,000 ± 500 mPa·s

Consistency: flows easily

**Pot life of
100 g mixture at 20° C:** approx. 45 minutes

Optimal usage time: approx. 30 minutes

**Hardening and
press time (20°C):** minimum 4 hours at 0.5 bar
pressure or stacking

**Subsequent processing
of the bonded elements:** after 4-6 hours

Final bond strength: 5-7 days at 20°C

Hardness (shore D): approx. 80

**Reaction of the adhesive during flame treatment
with a burner (DIN 53438 Part 3):**

- **Surface flaming:** F 1 / 4 mm

Identification: see our safety data sheet

Properties of the bond

Tensile shear strength in N/mm² at different
temperatures

Bonding of steel plate (ST 1203):

Temperature ° C	-20	0	20	40	60	80	100
Setting, 7 days at 20° C	19.6	18	17	14.5	10	4.3	2.3
Setting, 7 days at 20° C, conditioning 1 hour at 100° C	-	-	-	19.9	-	-	-

Application techniques

The surfaces to be glued must be free from dust, dirt and grease. Perfect working temperature 20°C; do not process below +5° C. Mix the adhesive carefully with the mixing ratio 4:1. A uniform beige color without streaks indicates a thorough mixture. Please mind the pot life.

Consumption: 200-250 g/m² depending on surface quality.

Single sided application is sufficient. Please note the service time. Subsequent processing of the bonded parts can be made after storing for 4-6 hours.

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Cleaning

It is required to clean the working tools with cleaner KLEIBERIT 820.0 prior to curing.

Packaging

KLEIBERIT 541.6, comp. A:

metal drum, 10 kg net
metal drum, 40 kg net
metal drum, 250 kg net

KLEIBERIT 870.0, comp B:

plastic can, 5 kg net
metal can, 35 kg net

Cleaner

KLEIBERIT 820.0:

metal can, 24 kg net

Additional packaging sizes available upon request.

Storage

Both components can be stored in factory sealed containers at room temperature for approx. 12 months. Ideal storage temperature is 15-25°C. Protect from humidity!

Components A and B are frost resistant down to -20°C.

Slowly bring to room temperature before processing.

Component A is hygroscopic. If exposed to moisture the quality of the mixture can be affected (bubbles or foam will appear).

Component B will form a skin if exposed to moisture.

The contents of open containers should be used as quickly as possible

Version 01/02/2021 al; replaces previous versions

Adhesive and Waste Disposal

Waste Code 080410 Component A
Waste Code 080501 Component B

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.