

KLEIBERIT 573.8

Fields of application

For high stress bondings of

- metals, concrete, and many plastics (e. g. laminated boards, rigid PVC) to each other
- wood and laminated boards to each other

For coating of

- metals and heating oil tanks (interior parts) with or without PVC foil

Advantages

- Universally applicable
- Oil resistant
- High resistance to heat and cold
- Protects metals from corrosion

Properties of the bond

Bond strength according to DIN 53 283:

Specimen of 1 mm thickness, 20 mm width, 10 mm overlapped

Material	Test Temperature (° C)	Combined Tension and Shear Resistance (N/mm²)
V2A/V2A*	+20	23
AL/AL*	+20	11
Steel/Steel St 12 03*	-20	24
	0	25
	+20	22
	+60	7
	+100	2

* Test specimen sanded and overlapped

Compression strength according to DIN 53 454:

Material	Test Temperature (° C)	Amount Compressed (mm)	Compression Strength (N/mm²)
PM 573.8 (cube of 10 mm edge length)	+20	1	63
	+20	5	99

Properties of the adhesive

Two-component system, solvent-free

Base: polyurethane

Component A: 573.8

Component B: 870.0

Mixing ratio:

comp. A : comp. B = 3 : 1 parts by weight

comp. A : comp. B = 12 : 5 parts by volume

Specific weight of the mixture:

approx. 1.45 g/cm³

Colour of the mixture:

concrete grey

Viscosity at 20°C

Brookfield, sp. 7/20 rpm:

comp. A 600,000 ± 150,000 mPa s

comp. B 150 ± 50 mPa s

mixture 45,000 ± 10,000 mPa s

Consistency:

thixotropic, can be applied with spatula

Pot life

(mixture of 100 g at 20°C): approx. 45 minutes;
may be extended by cooling the mixing pot

Service time

(mixture of 1 kg at 20°C): approx. 35 minutes

Fixing and setting times (approximate values):

Temperature (° C)	Fixing Time	Setting Time	
		50 %	100 %
100	15 min.	48 min.	75 min.
60	30 min.	90 min	7 hr
20	6 hr	48 hr	7 days

*based on final strength

Identification:

see our safety data sheet

Note:

Intended for commercial use only.

KLEIBERIT 573.8

Application methods

- with spatula
- with mixing and dosing devices

Application techniques

The materials to be bonded must be free from rust, dust, oil and grease. Highest strength can be achieved with pure metallic surfaces. The most favourable processing temperature is at 20°C. **Do not process below 5°C.** Please observe the correct mixing ratio and mix both components thoroughly.

Consumption:

adhesive application 250-300 g/m²,
as coating approx. 1 kg/m², depending on layer thickness

As a rule single-sided application is sufficient. Double-sided application would improve the quality of the bonding of strongly absorbent materials and provides a better wetting of metal surfaces. Set parts together, if needed use light pressure. **It is necessary to ensure that the adhesive is not pressed out of the joint.** For fixing and setting times see "PROPERTIES OF THE ADHESIVE"

Cleaning

It is absolutely necessary to clean the work tools with KLEIBERIT 820.0 prior to curing.

Packaging

KLEIBERIT 573.8 comp. A:

carton containing 10 tins, 0.670 kg each
metal pail, 3.6 kg net

KLEIBERIT 870.0 comp. B:

carton containing 10 tins, 0.230 kg each
carton containing 12 bottles, 1.2 kg net each

KLEIBERIT 820.0:

tin can, 4.5 kg net

Additional packaging available upon request.

Storage

KLEIBERIT 573.8, comp. A, and KLEIBERIT 870.0, comp. B, can be stored for approx. 1 year at 20° C in factory sealed containers.

Store in a cool and dry place.

Component A is not frost sensitive at temperatures above -20°C. Component B should be stored and transported at temperatures above -10°C.

Bring up to room temperature and homogenise prior to processing. .

If the mixture is inhomogeneous (jelly like, sandy, crystallised), it is possible to come back to a homogeneous consistency and initial quality by heating up to 50-60°C. (Please consult safety measures in our safety data sheet)

Version 20/10/2020 ga; replaced 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.