

# KLEIBERIT 114.5

## Solvent Adhesive

### Fields of application

Bonding the following materials together, and to wood, metal and mineral materials

- **Plastics:**  
Particularly suitable for PMMA, PA PC, ABS, NBR, PS, ceramics, GFK epoxy resin, GFK polyester, HPL laminate, CPL laminate, etc.  
**Not suitable for polystyrene foam.**
- **Metals:**  
Electrolytic galvanised steel, aluminium, copper, brass, lead foil, etc.
- **Mineral materials:**  
Glass and ceramics, etc.
- Veneer, leather, synthetic leather and leather pressed moulding

### Properties of the bond

**Further processing:** Immediately after bonding (due to high green tack)

**Final strength:** Is achieved after 3 days

**Ageing:** No tendency to embrittlement

**Heat resistance:** approx. 80°C without hardener  
up to 100°C with hardener

**Good resistance of the adhesive film to:** Aliphatic hydrocarbons, alcohol, water, diluted alkaline and non-oxidizing acids

### Properties of the adhesive

**Base:** Polychloroprene (PCP)  
**Solvents:** Mixture  
**Specific weight:** Approx. 0.87 g/cm<sup>3</sup>  
**Viscosity Brookfield sp. 3/20 rpm:** 2,800 ± 300 mPa·s  
**Colour:** Beige  
**Consistency:** Brush application possible  
**Thinners:** **KLEIBERIT 820.0**

**Hardener:** For bonding metal:  
**KLEIBERIT 801.0**

For PVC, veneer:  
**KLEIBERIT 802.0**

**Pot life with hardener:** 4-6 hours

**Evaporation time:** without hardener: 10-15 minutes

**Identification:** Is required according to EU regulations  
(See our safety data sheet)

### Application methods

- With paint brush, toothed spatula or knife coater
- With special roller application machines

### Application techniques

The materials to be bonded must be dry, and free from dust, oil and grease. De-grease metal surfaces thoroughly and clean with Emery cloth if necessary. All materials must be acclimatised before processing. Ideal working temperature 18- is 20°C. Do not process below 15°C. Ideal moisture content of the wood is 8-12%.

## KLEIBERIT 114.5

Stir well before use until the adhesive is homogenous. Thin the adhesive using KLEIBERIT 820.0 only. Temperature resistance, adhesion to metals, resistance to chemicals and humidity will be improved by adding 3 % Hardener KLEIBERIT 802.0 or KLEIBERIT 801.0. Apply a uniform coat of adhesive to the parts to be bonded. Allow the solvents to evaporate for 10-15 minutes. Evaporation time is dependent on the quantity applied, temperature and air circulation. The adhesive film must not string at the time of bonding, but must remain tacky (finger test).

**Application quantity:** 125-150 g/m<sup>2</sup> for each surface to be bonded.

The quantity applied is sufficient when a uniform adhesive film is visible after the evaporation time. Position the parts to be bonded together exactly. Subsequent corrections are not possible.

During bonding, the contact pressure must be as high as possible; for flexible materials minimum 0.30 N/mm<sup>2</sup>, and for rigid materials minimum 0.50 N/mm<sup>2</sup>. A press time of a few seconds is sufficient.

Immediate further processing of the bonded parts is possible.

When hardener is added, final bond strength will be reached after approx. 3 days.

### Cleaning

Tools can be cleaned with KLEIBERIT 820.0.

### Packaging

#### KLEIBERIT 114.5:

Carton with 10 cans at 0.70 kg net each

Metal canister, 4.5 kg net

Metal pail, 25 kg net

#### Cleaner

#### KLEIBERIT 820.0:

Carton with 12 bottles at 0.8 kg net each

Metal canister, 4.5 kg net

#### Hardener

#### KLEIBERIT 801.0:

Bottle, 0.25 kg net

Bottle, 0.94 kg net

#### KLEIBERIT 802.0:

Bottle, 0.25 kg net

Bottle, 1 kg net

Additional packaging sizes available upon request.

### Storage

**The adhesive should not be stored below -5°C and over +30°C.**

Storing below -5°C causes thickening of the adhesive. It must be brought to a processing temperature of +18°C - +20°C with indirect heat.

KLEIBERIT 114.5 can be stored at temperatures of +15 to +25°C for approx. 12 months in tightly sealed containers.

Stir before use.

Version 13.08.2020 xv; replaces 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.