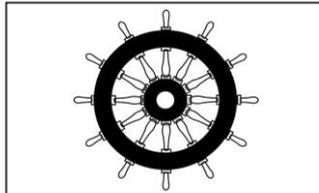


KLEIBERIT 503.9

1C-PUR Adhesive

Field of application

- Manufacture of sandwich elements, e.g. EPS/polystyrene, PUR foam or mineral wool as core material and synthetic panels, coated sheet metal, gypsum fibre boards etc. as cover.
- Bonding in shipbuilding
KLEIBERIT 503.9 complies with INO FTP-Code Part 5 & Part 2.
Approval according to test certificate BG Verkehr (department maritime safety) for international Use according to Module B)



Approval number: 118.276-04
 Certified application quantity: 150 g/m²

Advantages

- Single-component adhesive - no pot life problems
- Very light-coloured joint

Properties of the bond

- Soft elastic bond
- Good resistance to humidity and the influence of temperature
- Transparent or white shade following hardening

Properties of the adhesive

Base: isocyanate
Colour: amber
Density: 1.10 ± 0.02 g/cm³
Viscosity at 20° C
Brookfield RVT Sp.5/20 rpm: 6,000 ± 2.500 mPa·s
Consistency: medium viscosity
Open time: 13 - 17 min (20° / 50%)
Identification: see our safety data sheet

Application methods

- Roller application

Processing

The parts to be bonded must be free of dust, grease, oil and any separation agent. Single-sided application to the part with the less porous surface is sufficient. Dependant upon the type of surface of the materials to be bonded, the amount of adhesive required is between 100 and 400 g/m².

For bonding in shipbuilding, please observe that the certified application quantity of 150 g/m² is complied with.

Curing

Exposure to the influence of moisture (air-humidity, material) will cause the adhesive to cure to a very light white soft-elastic adhesive film. If too little moisture is available from the surrounding air and from the material being bonded, it is recommended that additional moisture be provided, e.g. with a fine mist of water.

Pressing, etc., fixing the parts

Heavy elements can usually just be stapled. Light or keyed boards must be pressed. If bonded parts are not pressed and if the adhesive layer is thick, the adhesive will tend to foam.

Press or fixing times

These times are dependant upon temperature and moisture supply.
 Guide values are:

Temp.	Press time (moistened joint)
20°C	approx. 30 minutes

Exact values must be established for each particular application, according to the conditions in question.

KLEIBERIT 503.9

Final bonding time

The above mentioned press times are minimum values, the final strength is achieved after a few days.

Cleaning

Clean application tools with KLEIBERIT 820.0 or acetone immediately after use.

Packaging

KLEIBERIT 503.9:

Metal canister	5 kg net
Metal can	30 kg net
Plastic container	1,000 kg net

Cleaner

KLEIBERIT 820.0

Metal can	4.5 kg net
Metal can	22 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 503.9 can be stored in air-tight containers at 20° C for approx. 9 months.

Keep in a cool and dry place.

Protect carefully from humidity.

The contents of opened containers should be used as soon as possible.

Version 24.08.2023 lz; 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.