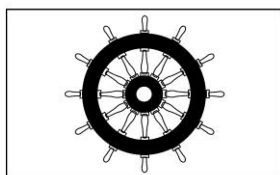


# KLEIBERIT 543.8

## Fields of application

- Bonding of diverse sandwich elements, especially aluminium honeycomb panels
- KLEIBERIT 543.8 corresponds with IMO FTP Code Part 5 & Part 2 / Approval according to test certificate BG Verkehr (Ship Security Service) for the international assignment according to module B)



Approval number:  
118.426

Certified order quantity: 200 g / m<sup>2</sup>

## Advantages

- One sided application
- Tough glue joint
- Relatively long open time
- Short press time through heat activated acceleration

## Properties of the adhesive

Two component system, solvent free

<b>Base:</b>	polyurethane
<b>Component A:</b>	KLEIBERIT 543.8
<b>Component B:</b>	KLEIBERIT 870.0
<b>Mixing ratio:</b>	Comp. A : Comp. B = 100 : 25 ppw
<b>Density:</b>	Comp. A: 1.42 ± 0.03 g/cm <sup>3</sup> Comp. B: 1.23 ± 0.02 g/cm <sup>3</sup> Mixture: approx. 1.38 g/cm <sup>3</sup>
<b>Colour of the mixture:</b>	beige
<b>Viscosity</b>	
<b>Brookfield (20 °C) , Sp. 5/20 rpm:</b>	Comp. A = 6,600 ± 1,000 mPa s Comp. B = 150 ± 50 mPa s
<b>Consistency of the Mixture:</b>	flows well
<b>Pot Life (100 g mixture at 20 °C):</b>	approx. 50 ± 10 minutes (solid)
<b>Press time at 75°C:</b>	
(metal face sheets):	approx. 5 minutes
<b>Hardness (Shore D):</b>	approx. 70, after 4 weeks storage at room temperature

## Identification:

Comp B: identification required according to EU regulations; contains diphenylmethane-4,4'-diisocyanate (see our safety data sheet)

## Application

- Two-part mixing and dosing plant

## Processing

The surfaces to be bonded must be clean, and free of dust, dirt, moisture and grease.

The adhesive can be processed without foaming at a temperature range of 10-35 °C and up to 85% relative humidity. Ideal processing temperature is 20-25 °C. Higher temperatures reduce and lower temperatures prolong the pot life of the adhesive mixture.

Comp. A must be homogenised before and during processing.

We recommend processing with a two component mixing and dosing plant fitted with equipment for bead application.

The metal face sheets of the sandwich elements to be bonded must have a suitable coating on the glue side so that good bonding is achieved.

**Application quantity:** approx. 200 g/m<sup>2</sup> for aluminium sandwich panels

The press time at 75 °C is approx. 5 minutes for elements with metal face sheets. Afterwards they can be stacked.

## Cleaning

The pieces and tools can be cleaned with KLEIBERIT 820.0 or other suitable cleaning agents and must be cleaned before the adhesive is hardened.

## KLEIBERIT 543.8

### Packaging

**KLEIBERIT 543.8, Comp. A:**

container, 1,200 kg net

**KLEIBERIT 870.0, Comp. B:**

container, 1,200 kg net

### Cleaner

**KLEIBERIT 820.0:**

metal canister, 4.5 kg net

metal can, 22.0 kg net

Additional packaging sizes available upon request.

### Storage

KLEIBERIT 543.8, Comp. A, and KLEIBERIT 870.0, Comp. B, can be stored in factory sealed containers at temperatures from 15 to 20 °C for approx. 12 months.

Storage temperatures above +30 °C reduce the shelf life of Comp. B. Storage temperatures above +50 °C must be avoided, as this can damage Comp. B.

The adhesive components are not frost sensitive to a temperature of -20 °C. Bring to room temp. before processing when stored in a cool place.

Protect from humidity!

Before extracting Comp. A from the packaging, homogenise the contents. A fast rotating stirrer with dissolving disk is best suited for this.

Version 27/10/2020 ga; replaces previous versions

#### Disposal of containers and contents

**Waste disposal key 080410 - Comp A**  
**Waste disposal key 080501 - Comp B**

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.