KLEIBERIT 546.8

2C-PUR-Adhesive

Fields of application

- For strong adhesion of polystyrene foam and PUR foam and other insulation materials with sheet metal, fibre glass reinforced polyester, laminate sheets, modelling plastics, etc.
- For building insulation materials - heat range up to approx. +80°C

Advantages

- Single sided application
- Economical application with roll applicator, two-component mixing and dosing units
- 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 546.8
Component B:	KLEIBERIT 578.0
Mixing ratio:	
Comp. A :Comp. B	5 : 1 by weight

Specific weight (20° C):	
Comp. A	1.60 ± 0.02 g/ cm³
Comp. B	1.24 ± 0.02 g/ cm³
Mixture	approx. 1.54 g/ cm³

Colour:	Comp. A:	light beige
	Comp. B:	brown
	Mixture:	beige

Viscosity at 20° C (Brookfield 20 rpm):	
Comp. A	14,000 ± 2,000 mPa·s
Comp. B	300 ± 100 mPa·s
Mixture	4,000 ± 1,500 mPa·s
Consistency:	flows easily

Pot life of (100 g mixture at 20°C):
approx. 2 hour (solid)

Open time (20°): 120-150 minutes
(adhesive layer on substrate)

Hardening and press time (20°C):
10-12 hours at 0.5 bar pressure or stacking

Subsequent processing of the bonded elements: after 12-16 hours
Final bond strength: >14 days at 20°C

Hardness (shore D): approx. 70

Tensile shear strength according to DIN EN ISO 527-1-2-3
After curing:> 12 MPa

Tensile shear strength according to DIN EN 1465 when bonding aluminum / aluminum (sanded and degreased):> 12Mpa

Identification:
Component B: see our safety data sheet

Processing

The surfaces to be glued must be free from dust, dirt and grease.
Ideal working temperature 20°C; do not process below +5°C.
Mix the adhesive carefully with the mixing ratio 5:1. A uniform beige colour without streaks indicates a thorough mixture. Observe period of use.

Consumption: 150-250 g/m² depending on surface quality.

Single sided application is sufficient.
Subsequent processing of the bonded parts can be made after 12-16 hours press or stacking pressure (at room temp. 20-25°C.)

Cleaning

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

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Packaging

KLEIBERIT 546.8, Comp. A:
metal pail, 30 kg net
IBC, 1,400 kg net

KLEIBERIT 578.0, Comp B:
metal can, 35 kg net
metal drum, 250 kg net

Cleaner
KLEIBERIT 820.0:
metal can, 22 kg net

Additional packaging sizes available upon request.

Storage

The optimal storage temperature is 15-25°C.
Protect both components from moisture and store is well sealed containers.
Comp. A and Comp. B are frost resistant to -10°C. Slowly bring to room temperature before processing.

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

Comp. B will form a skin if exposed to moisture.

Both components can be stored for at least 9 months at room temperature in well sealed factory containers.
The contents of open containers should be used as quickly as possible.

Version 27.05.2024 al; 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.

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