

# KLEIBERIT 605.0

## 1C STP Adhesive

### Fields of application

- Bench glue for bonding beech, oak and spruce wood elements for use in dry interior rooms with a room climate of 20°C and 50-65% relative humidity.
- Surface bonding of polyester GRP, epoxy GRP, hot-dip galvanised steel, electrolytically galvanised steel, stainless steel, aluminium, glass and concrete to wood-based materials such as blockboard, chipboard and MDF for use in dry indoor areas with a room climate of 20°C and 50-65% relative humidity.

### Advantages

- Anhydrous
- water-free can be painted over after complete curing (due to the variety of paints and coating systems available on the market, preliminary tests are necessary)
- Processing from +5 °C to +30 °C

### Properties of KLEIBERIT 605.0

<b>Base:</b>	STP
<b>Cross-linking system:</b>	cure under influence of humidity (air, substrate)
<b>Specific gravity:</b>	approx. 1.55 g/cm <sup>3</sup>
<b>Viscosity, 23 °C at 6,8/s:</b>	approx. 15 Pa·s
<b>Skinning time 23°C/50%RH):</b>	approx. 8 minutes
<b>Setting speed (23°C/50%RH):</b>	approx. 2-3 mm/day
<b>Application:</b>	flat application
<b>Color numbers:</b>	605.0.20 (beige) 605.0.90 (grey)
<b>Identification:</b>	see our safety data sheet

### Application techniques

The bonding surfaces must be stable, free of grease and dust and dry. If necessary, sand substrates such as metals for better adhesion.

In the case of large-area bonding, at least one substrate must have moisture-permeable properties (e.g. wood, wood-based materials, concrete).

The adhesion and compatibility of KLEIBERIT 605.0 must be checked by the user by carrying out preliminary tests with his own substrates under the individual conditions.

The substrates must be bonded together within the specified skin formation time.

Do not paint over the material until it has fully cured.

The following information is based on experience and is to be understood as an indication. Due to the large number of different materials and process-related influencing factors at the respective user, the stated values may vary to a certain extent. If necessary, they must be adjusted accordingly by the user and checked for suitability on their own responsibility.

### Application method

The adhesive can be applied to the substrates using a brush, roller, notched trowel or nozzle system.

### Adhesive application

It is sufficient to apply adhesive to one side of the less porous part to be joined.

### Application quantity

100 - 150 g/m<sup>2</sup> depending on the material properties.

### Open time/Skin formation time

Approx. 8 minutes at approx. 20 °C and 50 % relative humidity. This time is shortened by high room temperature, high humidity or addition of moisture.

### ProcessingPressing the parts

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Protect the pressing surfaces from leaking adhesive by applying silicone paper.

**Pressing pressure**  
0.5 N/mm<sup>2</sup>

### Pressing time

The times are highly dependent on the temperature and humidity.  
As a guideline: from 60 minutes at 20 °C / 50 % relative humidity

Exact times must be determined for the respective application according to the prevailing conditions.

### Curing

The adhesive cures to a semi-hard adhesive film due to the influence of moisture (from ambient air, material).

### Post-bonding time

The suitability for further processing of the glued parts must also be checked by the user based on the prevailing conditions.

### Cleaning

Clean working tools immediately after use.  
Cured adhesive can only be removed mechanically.

### KLEIBERIT 605.0

Plastic canister, 7,5 kg net  
Plastic bottle, 0,75 kg net  
IBC, 1300 kg net  
Additional packaging sizes available upon request.

### Transport

KLEIBERIT 605.0 is insensitive to cold down to a temperature of -10 °C during transport in the original sealed container.

### Storage

KLEIBERIT 605.0 can be stored for up to 9 months in its original sealed container in a dry place at a temperature between 10 °C and 20 °C.

### Note:

Opened containers should be used as soon as possible, as skin formation can occur due to the effects of moisture.

Version 27.05.25 lz, replaces previous version

## Packaging

### Adhesive and Waste Disposal

#### Waste Code 080409

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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