

KLEIBERIT 607.0

1C STP Adhesive

Fields of application

- Manufacture of wall elements and other non-load-bearing structures made of wood and wooden materials
- Bonding of different materials such as: mineral building boards, ceramic materials, concrete materials, hard foams, wood, glass, metals and plastics in interior areas.

Advantages

- Fast and bubble-free curing
- No foaming of the glue line
- No swelling or shrinking of wooden parts
- UV and weather resistant
- Paintable (due to the variety of paints and coating systems available on the market, preliminary tests are necessary)
- Processable from 5 - 30°C
- For flat surfaces, stationary press or pressure is not required after joining. Stack pressure is sufficient in many cases. This must be tested in preliminary trials.

Properties of the adhesive

Base:	STP (silane terminated polymers)
Colour:	607.0.90 grey 607.0.20 beige
Specific gravity:	approx. 1.2 g/cm ³
Consistency:	thin liquid
Identification:	see our safety data sheet
Note:	Intended for commercial use only.

Application techniques

The adhesive is processed by means of high pressure equipment as a spray application. We will be pleased to provide you with information on manufacturers of such equipment. The substrates to be bonded have to be tempered to at least 18 °C room temperature. The substrates must be clean, dry and free from grease. For wood-based materials the material moisture shouldn't be below 5 %. Remove release agent from the substrates to be bonded if present.

Do not process KLEIBERIT 607.0 below +5°C.

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 for the respective user, the values mentioned can vary within a certain range. If necessary, they are to be adapted accordingly by the user and checked independently with regard to suitability.

For large-area bonding, at least one substrate must have sufficiently permeable properties (e.g. solid wood, wood-based material, EPS, concrete or masonry). For impermeable substrates, moisture can alternatively be supplied by means of a fine water spray onto the adhesive surface. Since the moisture requirement depends on the respective adhesive application quantity, preliminary tests must be carried out accordingly.

Application:

The adhesive is applied by spraying using suitable high-pressure equipment. Single-sided application suffices on less porous surfaces

Application quantity:

100-200 g/m² according to the condition of the material

Open time:

Approx. 8 minutes at approx. 20 °C and 50% relative humidity. This period is reduced by high room temperatures, high humidity or the supply of moisture.

Setting:

The adhesive hardens to a semi-rigid adhesive film when exposed to humidity (from the air or materials).

The cross-linking process can be accelerated by means of targeted moisture supply (in the form of a fogging system) or by higher temperatures (40°C up to max. 80°C).

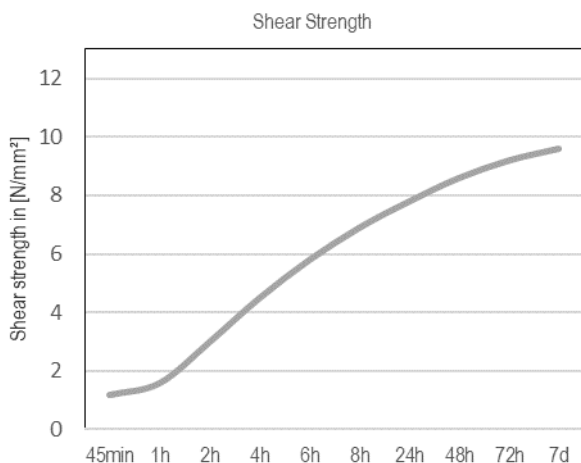
KLEIBERIT 607.0

Pressing the parts:

No additional pressure is required for the cross-linking process. However, if flat components or molded parts are to be bonded, the form must be fixed (e.g. to prevent slipping) during curing. As with all bonding, care must be taken to ensure a good joint fit. Protect pressing surfaces from adhesive leakage by placing silicone paper on them.

Strength structure:

Orientation for a 0.1 mm thick adhesive joint between two beech wood test specimens at 20 °C / 50 % rel. humidity



Fixing times:

These times depend on the temperature, the moisture content, the material composition and the dimensions and are to be determined in own tests. For solid wood bonding of e.g. beech with beech and a wood moisture content of 9%, the following times are suggested:

Temp.	Fixing time
20 °C	from 180 minutes
40 °C	from 90 minutes
60 °C	from 60 minutes
80 °C	from 45 minutes

Final setting time:

Subsequent processing of the bonded parts is possible after approx. 2 hours at 20 °C, final strength is achieved after approximately 7 days.

Cleaning

Clean application tools with KLEIBERIT 816.0 immediately following use.

Packaging

KLEIBERIT 607.0:

IBC, 1,300 kg net
Metal barrel, 230 kg net
export can, 30 kg net

Cleaner

KLEIBERIT 816.0:

metal bottle, 0.65 kg net
metal can, 4.5 kg net
export can, 30 kg net

Additional packaging available upon request.

Storage

KLEIBERIT 607.0 can be stored in closed air-tight containers at 20°C for approx. 6 months. Keep in a cool and dry place and carefully protect from humidity.

Opened containers should be used up as soon as possible.

KLEIBERIT 607.0 is not frost sensitive at temperatures above -25°C.

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Disposal of containers and contents

Waste disposal key 080501

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.