

KLEIBERIT 502.8

1C PUR Adhesive

Fields of application

- Bonding of wood and wood based materials
- Bonding of compounds with core materials: hard foams based on polystyrene, polyurethane, phenol resin and PVC, boards made from mineral and glass fibres as well as honey comb cores, with cover materials: laminate boards, pretreated sheet aluminium (for example yellow chromatised), plaster cardboard and plaster fibre boards, fibre boards and cement-bonded chipboards.

When bonding metals or plastics, the bonding properties must be tested beforehand, due to the great variations in the materials which are available.

Note: For bonding in shipbuilding (meets the requirements of IMO FTPC part 5 & part2) we recommend KLEIBERIT 502.3

Advantages

- Single-component adhesive, no pot life problems
- Short curing times

Properties of the bond

- High bond strength
- Good resistance to humidity and temperature

Properties of the adhesive

Base:	isocyanate
Colour:	amber
Specific gravity:	approx. $1.12 \pm 0.02 \text{ g/cm}^3$
Viscosity at 20°C	
Brookfield RVT sp. 4/20 upm:	$6,000 \pm 1,200 \text{ mPa s}$
Consistency:	low viscosity
Identification:	identification required according to EU regulations (see our Safety Data Sheet)
Note:	Intended for commercial use only.

Application methods

- Closed nozzle application
- Swirl-spray

Application techniques

The adherent must be clean, free from grease and air-dry. Remove release agent from plastic surfaces. Roughen and remove dust from sheet metals and hard plastics. Pre-treat aluminium foils and prime metals, if necessary.

Adhesive application

Single-sided application to the part with the less porous surface is sufficient. Processing time or open time is about 6-8 minutes at 20 °C and 50 % relative humidity of air. High room temperature, high humidity of the air or moisture supply (atomising of water) reduces the open time down to approx. 3 minutes.

Application quantity: 100-200 g/m²

Curing:

Under the influence of humidity (air, material, atomising of water), the adhesive cures to a water resistant, solvent resistant, semi-rigid adhesive film. By means of deliberate moisture supply (atomising of water, approx. 20 g/m²) or by higher temperatures (50°C up to max. 70°C) the cross linking process can be accelerated.

Pressing of the parts:

The cross linking process takes place when sufficient pressure is applied guaranteeing contact with the adherent. The required pressure depends on the type and size of the materials; a tight fit should be achieved.

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Press times:

The press times depend on temperature and moisture supply.

In the following table are some guiding values for the bonding of wood based materials:

Temperature	humidified	not humidified
20 °C	10 minutes	17 minutes
30 °C	6 minutes	11 minutes
40 °C	3 minutes	6 minutes

Exact times must be established for each application according to the conditions in question.

Final setting time:

The before mentioned press times are minimum values, the final strength is achieved after some days.

Cleaning

Clean application tools with KLEIBERIT 820.0 immediately after use.

Packaging

KLEIBERIT 502.8:

metal pail, 8 kg net
metal pail, 30 kg net
metal drum, 220 kg

Cleaner

KLEIBERIT 820.0:

metal canister, 4.5 kg
metal can, 22 kg net

Additional packaging sizes available upon request.*

Storage

KLEIBERIT 502.8 can be stored in air-sealed containers at 20 °C for approx. 6 months.

Keep in a cool and dry place and protect carefully from humidity.

Opened containers should be used up within a short period of time.

KLEIBERIT 502.8 is not frost sensitive at temperatures above -20°C.

*For delivery of 502.8 in 500 ml plastic bottles in tropical regions with high humidity, the bottles are first packed in outer packaging made from aluminium foil and then in cartons.

This ensures good protection from humidity as well as good storage stability – also at temperatures to 30 °C.

Version 22/12/2017; replaces previous versions

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.