

KLEIBERIT 507.0

1-C-PUR-Adhesive

Fields of application

- Manufacture of wall elements and other non-load-bearing structures made of wood and wooden materials
- Manufacture of wood products that are exposed to the weather, such as windows, doors, fence elements and terrace components, each with a suitable surface protection
- Adhesion of wooden products and elements that are subject to high loads or are temporarily exposed to increased moisture, such as Parquet flooring, sauna and bathroom furniture
- Bonding of mineral building boards, ceramic materials, concrete materials and hard foams

Advantages

- Single-component – no pot life problems
- Easy application

Properties of the bond

- The duromere glue joint is extremely resistant to high temperatures and achieves highest bonding strength
- Bond quality D4 according to DIN EN 204 (See AIDIMME Test Certificate No. 221.I.1907.576.EN.01 dated 26.06.2019)
- Tested according to DIN EN 14257 (Watt 91) (See AIDIMME Test Certificate No. 221.I.1907.576.EN.01 dated 26.06.2019)

Properties of the adhesive

Base:	isocyanate
Color:	brown
Specific gravity, 20°C:	1.12 ± 0.02 g/cm ³
Viscosity 20°C	
-Brookfield RVT:	7,000 ± 1,500 mPas
Consistency:	medium viscosity
Identification:	see our safety data sheet

Application techniques

Processing conditions:

The ideal working temperature is +20°C, the ideal moisture content of the wood 8-12 %.

Do not process below +5°C.

The adherents must be clean, dry and free from grease. Remove release agent from plastic surfaces.

Application methods:

Spatula, hand roller

Application:

Single-sided application to the surface which is least porous

Application quantity: 100-200 g/m²
(depending on material)

Open time:

Approx. 25 minutes at approximately 20°C. High temperatures, high humidity or moisture supply reduce this period.

Curing:

The product cures to a water-resistant, solvent-resistant and semi-rigid adhesive film when subjected to the influence of humidity (air, material).

The cross-linking process can be accelerated by means of a targeted moisture supply, (fine water spray, approximately 20 g/m²), or by higher temperatures (50°C up to max. 70°C).

Pressing the parts:

The cross-linking process should take place with a pressure that guarantees sufficient contact with the adherent. In order to protect exposed surfaces from being contaminated by glue, apply a silicone paper.

The necessary pressure is dependent upon the type and size of materials. A good fit should be achieved. Minimum pressure for the bonding laminated wood: **0,6 N/mm²**. The more intensive the wetting of the adhesive under pressure, the higher the subsequent load.

Press times:

The pressing times are dependent upon temperature and moisture supply.

In the following we give some guide values:

Temperature	Press Time
20°C	approx. 60 minutes
40°C	approx. 30 minutes
60°C	approx. 10 minutes

Exact times must be established for the particular application according to the prevailing conditions.

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Final setting time:

Subsequent processing of the bonded parts is possible after 2-3 hours, final strength is achieved after approximately 24 hours.

Safety measures:

Harmful when inhaled. Irritating to eyes, respiratory system and skin. May cause sensitisation following inhalation and skin contact. In case of contact with eyes, rinse with plenty of water immediately and seek medical advice. After contact with skin, wash immediately with plenty of water and soap.

If you feel unwell, seek medical advice. Heating up to more than 40°C causes harmful vapours, therefore ensure effective ventilation, or wear respiratory equipment in rooms which are not sufficiently ventilated. The adhesive reacts chemically with water, therefore contact with eyes, mouth or mucous membranes should be avoided at all means.

Cleaning

Clean application tools with KLEIBERIT Cleaner 820 immediately after use.

Packaging

KLEIBERIT 507.0:

Metal canister, 6 kg

Metal can, 32 kg

KLEIBERIT Cleaner 820.0:

metal can, 22 kg net

Storage

KLEIBERIT 507.0 can be stored for approx. 9 months at 20°C in airtight plastic bottles without an aluminium bag. In all other airtight sealed containers KLEIBERIT 507.0 can be stored at 20 °C for 12 months.

Keep in cool and dry place and protect from humidity. Opened containers should be used as soon as possible.

Version 27.03.25 Iz; replaces previous version

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.