KLEIBERIT 605.1.20

1C STP 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 and concrete materials and hard foams

Advantages

- Very low-emission (EC1 plus) according to GEV EMICODE classification (GEV-licencing no.: 17390/31.12.10 dated 12.09.2023)
- Fast and bubble-free curing
- 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

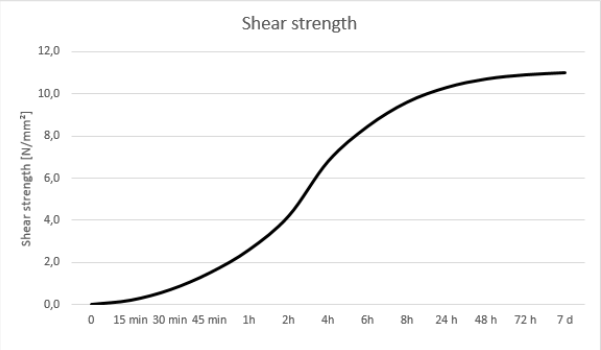
Properties of the bond

- The glue joint is resistant to high temperatures Bond quality D4 according to DIN EN 204 (See (ift-test Certificate No. 21-000886-PR01 from 31/05/2021)
- Tested according to DIN EN 14257 (Watt 91) (See ift Test Certificate No. 21-000886-PR02 from 30.04.2021)

Properties of the adhesive

Base:	STP (silane terminated polymers)
Colour:	beige
Specific gravity:	approx. 1.5 g/cm³
Viscosity at 23°C at 6.8/s - Brookfield RVT:	approx. 10,500 mPa s
Consistency:	thin liquid
Identification:	see our safety data sheet
Note:	Intended for commercial use only.

Strength structure:
Orientation for a 0.1 mm thick adhesive joint between two beech wood test specimens at 23 °C / 50 % rel. humidity



Application techniques

Processing conditions:
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.
At 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 605.1.20 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

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masonry).

Application methods:
The application can be done with brush, roller, spatula or nozzle equipment.

Application:
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. 50 °C relative humidity. This period is reduced by high room temperatures, high humidity or the supply of moisture.

Setting:
The adhesive hardens to a water-resistant, solvent-resistant and semi-rigid adhesive film when exposed to humidity (from the air or materials being bonded).
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).

Pressing the parts:
There is no pressure required for the cross-linking process, the parts to be joined may only have to be fixed. The necessary pressure is dependent on the kind and size of the materials; a good joint fit should be ensured.

Fixing times:
The press times are dependent on temperature and moisture supply.
Guide values:

Temp.	Fixing time
20 °C	from 90 minutes
40 °C	from 60 minutes
60 °C	from 45 minutes
80 °C	from 30 minutes

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

Final setting time:
Subsequent processing of the bonded parts is possible after approx. 1-2 hours, final strength is achieved after approximately 24 hours.

Cleaning
Clean application tools with KLEIBERIT 816.0 **immediately** following use.

Packaging
KLEIBERIT 605.1.20:
carton with 12 plastic bottles á 0,75 kg net
plastic canister, 7.5 kg net
IBC, 1,300 kg net

Cleaner
KLEIBERIT 816.0:
Metal bottle, 0.65 kg net
metal can, 4.5 kg net

Additional packaging available upon request.

Storage
KLEIBERIT 605.1.20 can be stored in closed air-tight containers at 20°C for approx. 12 months. Keep in a cool and dry place and carefully protect from humidity. Opened containers should be used up as soon as possible.
KLEIBERIT 605.1.20 is not frost sensitive at temperatures above -25°C.

Version 15.09.23 lz, replaces previous version

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.

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