

# KLEIBERIT 625.0

## Aqueous Adhesive for lacquered surfaces

KLEIBERIT 625.0 is an artificial resin glue with a medium setting time and very good surface-dissolving properties. Due to its medium viscosity and long open time the glue can be processed easily and is versatile in use.

### Fields of application

- Bonding to nitro-lacquer surfaces - without sanding
- Bonding to acid-curing lacquers, DD-lacquers, polyester lacquers - slightly sand lacquered surfaces

### Advantages

- Good surface-dissolving and adhesion properties to nitro-lacquer.
- Especially suited for bonding of structural components
- Short press times

### Properties of the bond

- High joint strength
- Transparent glue line
- Tough-elastic glue line

### Properties of the glue

<b>Base:</b>	PVAC-dispersion
<b>Specific gravity:</b>	approx. 1.08 g/cm <sup>3</sup>
<b>pH:</b>	approx. 4
<b>Colour:</b>	white
<b>Viscosity:</b>	
<b>Brookfield RVT, sp. 6, 20 rpm:</b>	13,000 ± 2,000 mPa·s
<b>Consistency:</b>	medium viscosity
<b>Open time:</b>	5-8 minutes
<b>Chalk point:</b>	+7°C
<b>Identification:</b>	see our safety data sheet

### Application methods

- With paint brush or spatula
- With filament pistol
- With glue spreaders only under certain conditions because of evaporation of the solvent

### Application techniques

The materials to be bonded must be free from dust, oil and grease and acclimatized. The most favourable working temperature is at 18-20°C, the ideal moisture content of the wood is 8-12%, at maximum 15%. Do not process below +10°C.

KLEIBERIT 625.0 is ready to use. The addition of thinners and fillers alter the glue.

Best adhesion is achieved to nitro-lacquer. When bonding DD-lacquer, acid-curing lacquer and polyester lacquer slightly sand the surface in order to improve the adhesion. In case of nitro-cellulose lacquered surfaces bonding of lacquered surfaces to each other is possible to a limited extent. However the setting process is significantly delayed. The glue is applied to one side.

**Application quantity:** 130-200 g/m<sup>2</sup>

**Open Time:** up to 8 minutes

The open time is influenced by the quantity applied, the absorption capacity of the material, the moisture content of the wood and the humidity of the air as well as the temperature.

**Press Time:** 8-12 minutes at 20° C

The setting process can be accelerated by means of heat supply.

### Cleaning

Application tools and containers can be cleaned with water before the glue has set.

## KLEIBERIT 625.0

### Packaging

#### KLEIBERIT 625.0:

plastic can, 28 kg net

Additional packaging sizes available upon request.

### Storage

KLEIBERIT 625.0 can be stored for approx. 6 months in factory sealed containers at 20°C.

The glue is frost resistant to approx. -10°C, but it is recommended to store at room temperature!

Version 10/02/2021 ga; replaces previous versions

#### 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.