

# KLEIBERIT 651.1.33

## UV-Filler

### Fields of Use

- Photosensitive UV-Filler for the KLEIBERIT HotCoating® technology with very good sandability.

### Characteristics of KLEIBERIT 651.1.33

<b>Base:</b>	UV curing acrylates
<b>Specific weight (at 20°C):</b>	approx. 1,5 g/cm <sup>3</sup>
<b>Solids:</b>	> 99 % (theoretical value)
<b>Colour:</b>	026
<b>Gloss level :</b>	typical for the material, matte, not determined

### Viscosity at delivery (at 20°C)

**8mm DIN cup:** 85 - 120 seconds

**Identification:** Identification is required according to EU regulations (See our safety data sheet)

### Processing

Ambient and substrate processing  
 temperature: 22 - 28°C  
 Application with roller applicator: 10-55g/m<sup>2</sup>  
 Application viscosity: viscosity at delivery

**Stir well with appropriate spatula before use.**  
**All process relevant properties must be checked before processing.**

### Drying / UV-Curing

Gelling: 10 m/min  
 UV-Dosage\*: 100 - 200 mJ/cm<sup>2</sup> (Ga)

Curing: 10 m/min  
 UV-Dosage\*: 250 - 300 mJ/cm<sup>2</sup> (Ga) and  
 300 - 350 mJ/cm<sup>2</sup> (Hg)

\* The stated UV dosages are empirical values based on measurements with „UV-Disc A002400 (Full-UV: 250 – 410 nm)“ by UV-Technique

**It is absolutely necessary to determine the processing conditions for optimal result before starting production.**

These depend on the equipment technology as well as on the substrate to be coated.

The final characteristics like adhesion, scratch resistance and sandability have to be monitored continuously.

### Cleaning

Soiled application tools and machinery parts to be cleaned immediately with cleaner KLEIBERIT 820.0.

### Packaging

#### KLEIBERIT 651.1.33

metal pail, 30 kg net  
 metal can, 25 kg net  
 IBC, 1400 kg net

### Cleaner

#### KLEIBERIT 820.0

metal can, 22 kg net

Additional packaging sizes available upon request.

### Storage

Shelf life in factory sealed containers (at 5 – 25 °C) is at least 9 months.

Storage at high temperatures can shorten the shelf life.

Recommended transport temperature 0 – 35 °C.  
 Protect from light, heat and frost.

Version 05/08/2019 al; replaces previous versions

## KLEIBERIT 651.1.33

**Adhesive and Waste Disposal**

**Waste Code 080111**

Our containers are made of recyclable material. Well drained containers can be recycled.

**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.