



PUR-Adhesive 501.6

Humidity curing single-component reaction adhesive based on polyurethane, highly resistant to water and temperature. Waterproof according to DIN/EN 204, D4.

Fields of application

- Bonding windows and doors
- Laminate bonding of wood and wood materials
- Joint bonding for outdoor use
- Bonding of mineral building boards, ceramic and concrete materials and hard foams

Advantages

- Single-component adhesive, no pot life problems
- Easy application
- Long open time

Properties of the bond

- The thermosetting glue joint is resistant to high temperatures and achieves highest bonding strength
- Quality of the bond: D 4 as per DIN/EN 204 (Certificate from the German IFT, Institute for Window Technology – certificate number 505 15002/1 dated 04.05.1994))

Properties of the adhesive

| | |
|--|---|
| Base: | isocyanate |
| Colour: | brown |
| Specific gravity: | approximately 1.13 g/cm ³ |
| Viscosity at 20°C - Brookfield RVT: | 7.000 ± 1.500 mPa s |
| Consistency: | thin liquid |
| Identification: | identification required according to EU regulations, contains 4.4 diphenyl methane diisocyanate (see our safety data sheet) |

Note: Intended for commercial use only.

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:

With spatula or hand roller from plastic squeeze bottle

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. 70 minutes at approx. 20°C. 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 (water spray, approx. 20 g/m²) or by higher temperatures (50°C up to max. 70°C).

Pressing the parts:

The cross-linking process takes place when sufficient pressure is applied to ensure contact with the surfaces to be bonded. The necessary pressure is dependent on the kind and size of the materials; a good joint fit should be ensured. Minimum pressure for the bonding of laminated wood: 0.6 N/mm². The more intensive the cross-linking of the adhesive under pressure, the higher the subsequent loading ability.



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Press times:

The press times are dependent on temperature and moisture supply.

Guide values:

| Temp. | Press time |
|-------|---------------------|
| 20°C | approx. 6 - 7 hours |
| 40°C | approx. 2 - 3 hours |
| 60°C | approx. 1 - 2 hours |

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 1 day, final strength is achieved after approximately 7 days.

Cleaning

Clean application tools with KLEIBERIT Cleaner 820.0 **immediately** following use.

Packaging

KLEIBERIT PUR-Adhesive 501.6:

Metal canister, 5 kg net

Metal pail, 30 kg net

Carton with 12 bottles at 0.5 kg net each

KLEIBERIT Cleaner 820.0 Toluene-free:

Metal can, 22 kg net

Additional sizes available upon request.

Storage

KLEIBERIT PUR-Adhesive 501.6 can be stored in closed air-tight containers at 20°C for approx. 1 year.

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

KLEIBERIT PUR Adhesive 501.6 is not frost sensitive at temperatures above -20°C.

EX0311; 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.