

Kestopur 305/15



Kestopur 305/15 is a two-component polyurethane adhesive for sandwich panel constructions in the exterior door manufacture.



- Ideal for automatic ribbon spreading

AREA OF APPLICATION

Kestopur 305/15 is a two-component, solvent-free polyurethane adhesive which gives a strong, yet elastic bond. Designed for automatic application. Used in conjunction with Kestopur 200/S hardener. Suitable for gluing of e.g. wood, insulation materials, epoxy primed aluminium and fiber composite.

INSTRUCTIONS FOR USE

The surfaces to be bonded must be clean and dry. Remove oxides by sanding, and grease etc. dirt with Kiilto Cleaner 303. The properly cleaned surface can be sanded and then primed to improve adhesion. Remove the sanding dust carefully prior to adhesive application. Stir Kestopur 305/15 -resin before use. Add Kestopur 200/S hardener to resin and mix until a uniform colour is achieved. Apply the adhesive on one or both sides of the materials to be bonded.

Fresh adhesive stains are removed with a dry cloth and then surfaces are cleaned with Kiilto Cleaner 303 or Kiilto Cleaner 300. Hardened adhesive can only be removed by mechanical means.

We recommend gluing at room temperature. The open time of the adhesive depends on temperature and air humidity. However, the gluing can be carried out at lower temperatures (even at +10 °C), but then the pressing time will be significantly longer and spreading properties will suffer. Higher pressing temperature will shorten the pressing time. Take into account adhesive's short pot life. During breaks, the adhesive must be run or wash started approx. 30 sec after the flow has stopped.

ADDITIONAL INFORMATION

The information given in this product data sheet is based on our tests and our practical knowledge. The technical data is defined in standard conditions. Variations in local working conditions and methods will affect the product performance and result. The result is strongly affected by working methods. We guarantee the high quality of our products according to our Quality Management System. No liability can be accepted from incorrect use of the product or prevailing conditions, over which we have no control. Thus, we cannot be held responsible for the final result. The user of the product must test the product's suitability for the intended application.

ENVIRONMENT AND SAFETY

Avoid unnecessary skin contact with and exposure to the uncured adhesive: use safety gloves. Refer to material safety data sheet. For information on product and package disposal, visit www.kiilto.com.

TYPE/BINDER	Polyurethane
DENSITY/SPECIFIC WEIGHT	Resin: 1.5 g/cm ³ , Hardener: 1.2 g/cm ³
MIXING RATIO	5 weight part Kestopur 305/15 -resin + 1 weight part Kestopur 200/S -hardener
VISCOSITY	Resin: approx. 8000 mPas, Hardener: approx. 200 mPas (Brookfield, RVT 20 °C)
POT LIFE	approx. 15 min (120 g, 20 °C, 50 % RH)
OPEN TIME	30 min (23 °C, RH 50 %)
CONSUMPTION	160–300 g/m ² depending on materials
PRESSING TIME	Min. 20 minutes / 55 °C
STORAGE	Unopened at +10–25 °C in a container (1000 l) for 3 months. After long storing, stir before use.