

# Kestopur 206/70



Kestopur 206/70 is a two-component polyurethane adhesive for the gluing of metal, wood and insulation materials, as well as fibre composites in sandwich panel constructions for the transportation industry.

- Mixing ratio 6:1
- Strong, durable
- Suitable for automatic application

## AREA OF APPLICATION

Kestopur 206/70 is a two-component, solvent-free, polyurethane adhesive which gives a strong, yet elastic bond. Suitable for automatic application. Suitable for the gluing of e.g. metals, wood, insulation materials, high-pressure laminate, fibre composite and plastics such as PVC, PS or ABS and glass. A preliminary test should be carried out for different materials to ensure adhesion (especially plastics), strength and pressing time. Possible to use with smaller amount of hardener. Used in conjunction with Kestopur 200/S hardener. Adhesive is compliant with M1 Emission Classification of Building Materials.

## INSTRUCTIONS FOR USE

The surfaces to be bonded must be clean and dry. Remove oxides by sanding, and grease and other 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 206/70 resin before use. Add Kestopur 200/S hardener to the 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 surfaces are wiped with Kiilto Cleaner 303 or 2K Cleaner. 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. A higher pressing temperature will shorten the pressing time.

## 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 will affect the product performance and result. The result is also 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.

DENSITY/SPECIFIC WEIGHT	Resin: 1.6 g/cm <sup>3</sup> , hardener: 1.2 g/cm <sup>3</sup>
LAP SHEAR STRENGTH	SS 9 N/mm <sup>2</sup> (28 d 23°C, 50 % RH)
TENSILE STRENGTH	6 N/mm <sup>2</sup> (DIN 53504)
ELONGATION AT BREAK	25 % (DIN 53504)
HARDNESS	Shore D 50
MIXING RATIO	6 weight part Kestopur 206/70 resin + 1 weight part Kestopur 200/S hardener.
VISCOSITY	Resin: approx. 20,000 mPas, Hardener: approx. 200 mPas (Brookfield RVT 20 °C)
MIXTURE VISCOSITY	approx. 6500 mPas
MIXTURE COLOUR	Beige
POT LIFE	approx. 70 min (120 g, 20 °C, 50 % RH)
OPEN TIME	max. 2 h after mixing (23 °C, RH 50 %)
CONSUMPTION	150-500 g/m <sup>2</sup> depending on materials
PRESSING TIME	min. 8 h / 20 °C
STORAGE	Unopened at +10–25 °C in a container (1000 l) for 6 months, in smaller containers 12 months. After long storing, stir before use.