

# Kestopur A2S 125



Kestopur A2S 125 is a two-component, foaming, solvent-free polyurethane adhesive for sandwich panel manufacture.



- Low thermal value
- Ideal for automatic ribbon spreading

## AREA OF APPLICATION

This foaming adhesive is purpose-designed for the gluing of rock and glass wool. Suitable materials are e.g. metals, insulation materials and fibre composite. Kestopur A2S 125 is used in conjunction with Kestopur 200/S hardener. Suitable for manufacturing EN 13501 A2-classified sandwich elements on continuous press lines equipped with automatic applicator for two-component adhesives.

## INSTRUCTIONS FOR USE

The surfaces to be bonded must be clean and dry. Remove dust, dirt, oxides, grease, etc. using Kiilto Cleaner 303. The properly cleaned surface can be sanded and primed to improve adhesion. Remove the sanding dust carefully prior to adhesive application. Kestopur A2S 125 resin must be stirred before use. Add Kestopur 200/S hardener to the resin, and mix until a uniform colour is achieved. Apply adhesive one- or two-sided with application equipment. 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 carrying out the gluing at room temperature. However, the gluing can be carried out at lower temperatures (even at +10 °C), but then the hardening process will be significantly slower and spreading properties will suffer.

## 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 product's suitability to the intended application.

## ENVIRONMENT AND SAFETY

Avoid unnecessary skin contact with and exposure to the fresh product: use safety gloves. Refer to material safety data sheet. For information on product and package disposal, visit [www.kiilto.com](http://www.kiilto.com).

TYPE/BINDER	Polyurethane
DENSITY/SPECIFIC WEIGHT	Resin: 1.6 g/cm <sup>3</sup> , hardener: 1.2 g/cm <sup>3</sup>
LAP SHEAR STRENGTH	> 7 N/mm <sup>2</sup> (epoxy coated steel, 28 d 23°C, 50 % RH)
MIXING RATIO	5 weight part Kestopur A2S 125 resin + 1 weight part Kestopur 200/S hardener
VISCOSITY	Resin 22 500 ± 7 500 mPas, hardener 210 ± 30 mPas (Brookfield RVT 20 °C)
POT LIFE	2 min 5 sec ± 15 sec (42 g, 20 °C, 50 % RH)
OPEN TIME	max. 3 min after mixing / 20 °C
CONSUMPTION	200-250 g/m <sup>2</sup> depending on materials
PRESSING TIME	Approx. 5 min / 40 °C
CALORIFIC VALUE	13.7 MJ/kg (EN ISO 1716)
FIRE CLASS	A2
STORAGE	Kestopur A2S 125 is stored in a tightly closed original containers at +10–25° C for 6 months (1000 l container), and 12 months in smaller packages. After prolonged storage, stir before use. Protect from freezing.