

# Kestopur PL 240



Kestopur PL 240 is a two-component polyurethane adhesive for the gluing of metal, wood and insulation materials as well as fibre composite in sandwich panel constructions for the marine industry.



- Solvent-free
- Excellent adhesion to various materials
- Paste consistency
- Good ridge forming and stays well on vertical surfaces

## AREA OF APPLICATION

Kestopur PL 240 gives an extremely strong bond. Ideal for trowel application. Used in conjunction with Kestopur 200/S hardener. Kestopur PL adhesives are fire classified according to IMO FTPC, Part 5 and have an MED certificate (Wheel-mark). Kestopur PL 240 is used for the gluing of metal, glass fibre laminate, insulation wools and foams, ceramic tiles and sandwich panels. When gluing plastic e.g. PES, PC, PVC, ABS and PA, always test adhesion beforehand.

## 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. When applying Kestopur PL 240 on concrete, relative humidity of the surface can be max. 90%. First stir Kestopur PL 240 resin and then add the hardener and stir until the mixture is even-coloured. Apply the adhesive on one or both sides of the materials to be bonded with suitable equipment. Remove fresh adhesive stains with a dry cloth and clean the surfaces with Kiilto Cleaner 302, acetone or xylene. Hardened adhesive can only be removed by mechanical means. We recommend gluing at room temperature. Gluing can be carried out at below room temperature (+5–10 °C), but the hardening process will be slower and application may be affected.

## 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.

TYPE/BINDER	Polyurethane
DENSITY/SPECIFIC WEIGHT	Resin: approx. 1.60 kg/dm <sup>3</sup> , Hardener: Approx. 1.20 kg/dm <sup>3</sup>
LAP SHEAR STRENGTH	Al/Al +20 °C; 7 N/mm <sup>2</sup> Al/Al -20 °C 12 N/mm <sup>2</sup> Al/Al -190 °C 13 N/mm <sup>2</sup> (28 d 23 °C, 50 % RH)
TENSILE STRENGTH	8 N/mm <sup>2</sup> (DIN 53504)
ELONGATION AT BREAK	10 % (DIN 53504)
HARDNESS	Shore D 65
MIXING RATIO	5 weight parts Kestopur PL 240 resin + 1 weight part Kestopur 200/S hardener
VISCOSITY	Resin: approx. 2.5 million mPas Hardener: approx. 200 mPas
MIXTURE VISCOSITY	approx. 1.5 million mPas (BrookField T-F 20° C)
MIXTURE COLOUR	beige
POT LIFE	approx. 60 min (120g, 20 °C, 50 % RH)
OPEN TIME	max. 1½ h / 20 °C
CONSUMPTION	300–800 g/m <sup>2</sup> depending on materials
PRESSING TIME	min. 6–7 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.