



# Kiilto R Marine fix and sealant



Kiilto R Marine is a one-component adhesive for metals, glass fiber and different types of plastics in the marine industry.



- Fast-curing
- NSF registered: Can be used in areas where food is handled.
- Good resistance against chemicals
- Good resistance against weather and UV radiation
- Paintable
- Excellent adhesion
- Gluing cleats, hinges, fittings etc. to boat hull

## AREA OF APPLICATION

It is suitable for different types of materials in demanding structural gluing applications. Kiilto R Marine is suitable for use with most metals, polystyrene, polyurethane, glass, glazed surfaces, epoxy and polyester fiber, stone and concrete. Complies with M1 emission classification for building materials. Fast bonding. Excellent adhesion to different materials - no need for priming in most cases. Does not contain isocyanates, PVC, tin catalyst or solvents. Almost odourless. Good resistance against detergent solutions (alkali and acid solutions), temporary resistance against fuels, mineral oils and vegetable oils. Excellent resistance against weathering and UV-radiation. Almost non-shrinking. Paintable with most water-based paints (test before use).

## INSTRUCTIONS FOR USE

Materials being used must be dust-free, dry and free from grease and oil. When gluing large uniform surfaces or surfaces in very dry conditions, we suggest spraying lightly with water (approx. 5–10 g/m<sup>2</sup>). We recommend cleaning the surfaces with Kiilto Cleaner 303 and priming with Kiiltoflex Metalliprimer. Uncured adhesive can be removed with xylene or acetone, cured adhesive only mechanically.

## 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 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. Ensure that the product is suitable for the intended application.

TYPE/BINDER	Silyl modified polymer
DENSITY/SPECIFIC WEIGHT	Approx.1.62 kg/l
LAP SHEAR STRENGTH	3.5 N/mm <sup>2</sup>
TENSILE STRENGTH	2.2 N/mm <sup>2</sup> (DIN 53504)
ELONGATION AT BREAK	200 % (DIN 53504)
HARDNESS	Shore A 60
VISCOSITY	approx. 2.5 million mPas (BrookField H-Path T-F/2.5 +20 °C)
SKIN TIME	approx. 10 min (23 °C, 50 % RH)
CURING THROUGH	3 mm/d, approx. 10 mm/7 d (23 °C/50 % RH)
APPLICATION TEMPERATURE	+1–40°C
TEMPERATURE RESISTANCE	-40–+90°C
STORAGE	Unopened at +10–25 °C for 18 months.



**ENVIRONMENT AND SAFETY**

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