



Contact Adhesive 152.0/152.5 toluene-free

Fields of application

Bonding of

- Wood and wood based materials to each other
- Foam materials (except polystyrene foam) to each other or to textile fabric, wood and other solvent resistant materials
- Paper and cardboard materials
- Floor coverings (PVC, linoleum, carpet) for the manufacture of double floorings on substrates made of wood based materials, concrete, gypsum and metal
- Post-forming contact process

Advantages

- Versatile applicable
- High green strength
- Toluene-free

Properties of the bond

Processing ability: immediately after bonding

Final strength: after approx. 8 days,
by addition of hardener
after 3 days

Temperature resistance: approx. -20°C to more than
+80°C, depending on the
materials bonded

Ageing: good ageing resistance, no
embrittlement

Properties of the adhesive

Base: polychloroprene
Solvents: mixture
Specific weight: approx. 0.84 g/cm³

Colour: 152.0 toluene-free: beige
152.5 toluene-free: rot

Viscosity (20 °C)
Brookfield, sp. 2/20 rpm:: 700 ± 100 mPa.s
Consistency: low viscosity

Cleaner + Thinner: KLEIBERIT Cleaner +
Thinner 820.0 toluene-free
Hardener: KLEIBERIT Hardener H
801; 5 % addition

Pot life with hardener: approx. 5 hours
Evaporation time: approx. 5 minutes

Identification: identification required
according to EU
regulations, easily
inflammable, free of aromas
such as toluene
(see our safety data sheet)

Application methods

- With spray gun
- With casting machine

Application techniques

The materials to be bonded must be dry and free from dust, oil and grease. All materials must be acclimatised before processing.

The ideal process temperature is 18-20°C. Do not process below 15°C.

The best moisture content of the wood is at 8-12%.

Before processing stir the adhesive.

For thinning of the adhesive use only KLEIBERIT Cleaner + Thinner 820.0 toluene-free.

By addition of 5 % KLEIBERIT Hardener H 801.1, temperature resistance, adhesion strength to various materials as well as resistance to chemicals and humidity are improved.



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Evenly apply the adhesive to both parts. Let the adhesive evaporate for 3-5 minutes, when hardener is added for 2-4 minutes.

The evaporation time is dependent on the quantity applied, the temperature and the flow of air. When bonding, the adhesive shall no longer be stringy but must still be tacky.

Spray application:

nozzle diameter 1.3 – 1.7 mm
pressure 3-4 bar

Application quantity:

100-150 g/m² for each bond surface

The quantity applied is sufficient when after a short evaporation time a uniform adhesive film is visible.

The parts to be bonded must be precisely put together. Subsequent corrections are not possible. The bonding has to be done under high pressure, at least 0.3 N/mm² for flexible materials and 0.5 N/mm² for rigid materials. A few seconds press time is sufficient.

The higher the pressure, the higher the strength of the bond!

The bonded parts can immediately be further processed.
With addition of hardener the final strength is achieved after approx. 3 days.

Cleaning

Work tools can be cleaned with KLEIBERIT Cleaner 820.0 toluene-free.

Packaging

KLEIBERIT Contact Adhesive 152.0 toluene-free and KLEIBERIT Contact Adhesive 152.5 toluene-free:

metal can, 4.5 kg
metal can, 22 kg net
metal pail, 24.0 kg net
drum, 170 kg net

KLEIBERIT Cleaner 820.0 toluene-free:

canister, 4.5 kg net
metal can, 22.0 kg net

KLEIBERIT Hardener H 801.0:

carton with 12 metal bottles, 0.940 kg net each

Additional sizes available upon request.

Storage

The adhesive should not be stored under -5°C and over +30°C.

If stored below -5°C, the adhesive will thicken. In this case, it must be brought to a processing temperature of +18°C to +20°C per means of indirect heat.

KLEIBERIT Contact Adhesive 152.0 toluene-free and KLEIBERIT Contact Adhesive 152.5 toluene-free can be stored in factory sealed containers at +15°C to +25°C for approx. 12 months.

Stir before use.

EX0311; replaces previous versions

Waste Disposal

Disposal of contents and/or containers should comply with all applicable federal, state and local regulations.
Our containers are made of recyclable material.

Service

Our application department may be consulted at any time without obligation. The statements made herein are based on our experience gained to date. They are to be considered as information without obligation. Please test and establish for yourself the suitability of our products for your particular purposes. No liability exceeding the value of our product can be derived from the foregoing statements. This also applies to the technical consultancy service which is rendered free of charge and without obligation.