

KLM 476 DK

SOLVENT FREE EPOXY ADHESIVE

DESCRIPTION

KLM 476 DK is a solvent free epoxy based thixotropic adhesive. **KLM 476 DK** is wood / plywood lamination and core material (such as PVC foam) adhesive. It has a high humidity tolerance.

TECHNICAL PROPERTIES

Number of components	2
Mixing Ratio	A/B
By weight	50/50
Mixing Density (g/cm³, 20°C) (TS EN ISO 2811-1)	1,20 - 1,40
Pot-life (min.,23°C, 100 ml) (DIN 16945)	40 - 80
Mixing Viscosity (mPas,at 25°C) (DIN 53229)	Thixotropic
Curing Time (23°C) (TS 4317)	
Surface Dry (min)	80 - 120
Dry to Touch (hours)	5 - 8
Fully Cured (week)	1

ADVANTAGES

- Thixotropic, no sagging on vertical.
- Good adhesion on wood, foam or GRP surfaces.

APPLICATION

WORKING CONDITIONS

The temperature in the operation area should be in the range of 10°C – 30°C.

MIXING

Component A and B are mixed in their own cans with a mixer. Then the component B is poured into the can of component A during stirring, and they are mixed together using a mixer, till a homogenous mixture is obtained. The mixing period shouldn't exceed 2 – 5 minutes. Because mixer could introduce air bubbles into mixture, the rotation of the mixer shouldn't exceed 400-500 rpm.

If product is purchased in big containers (i.e. drums), please use the necessary measurement instruments for correct mixing.

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SURFACE PREPARATION, MIXING AND APPLICATION METHOD

The application surface has to be cleaned and made completely rust, oil, dust and contaminant free. Surface shouldn't be humid.

After appropriate surface preparation and primer application for each kind of substrate, **KLM 476 DK Solvent Free Epoxy Adhesive** is applied onto surface using a trowel, roller or brush. Adhered parts must be kept under pressure for 10 - 12 hours at 25°C.

THINNER

DO NOT ADD ANY THINNER!!!

PACKAGE

A and B components are provided in 2 separate packages.

EQUIPMENT CLEANING

PR 20 is recommended for cleaning the brushes and the other tools. Tools are soaked in **PR 20**, then washed under flowing water.

STORAGE AND SHELF LIFE

KLM 476 DK should be kept in its original, unopened package and in closed and dry places, which are at 15 – 25°C. It must not stay under direct sun light. Under these conditions, the shelf life is 12 months.

SAFETY MEASURES

Product's skin contact must be avoided. In case of contact, skin must be washed with water. Eyes should be flushed with water and medical attention must be sought immediately. Wear suitable protective clothing, gloves and goggles. Keep away from children.

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ATTENTION

- Applied surface temperature must be between 10°C-30°C
- There may be no touching or water contact on the application area till 24 hours after the adhesion.
- Just enough quantities of the product must be mixed for the application. Application mustn't stop till the whole mixture is consumed.
- **KLM 476 DK's** complete curing time at 20-25°C is approximately 7 days.

NOTE: The above specifications are based on laboratory test results. This data sheet is valid until subsequent issue. We reserve the right to change the given data without notice.

**Duratek®**

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