

KIWOBOND 1000HMT

1. DESCRIPTION

KIWOBOND 1000 HMT is a fast drying, two component frame adhesive for high tensioned mesh. It has excellent chemical resistance and adhesion to all commonly used screen frames.

2. APPLICATION

2.1. Frame preparation

Before adhering the mesh with KIWOBOND 1000 HMT, remove excessive adhesive residue from the frame with PREGAN DL, grinding or sandblasting. Be careful not to roughen the frame surface too much, as this could impair the adhesion of the adhesive. Frames should be free from oil, grease, dirt, water and solvents before applying the adhesive. Slight residues of KIWOBOND 1000 HMT, however, do not need to be removed. The surface should be even. If the frame surface is slightly uneven or has deeper grooves from sandblasting or grinding a precoat of KIWOBOND 1000 HMT with hardener can be used to even the surface.

2.2. Mixing the adhesive.

Before use, mix 100 weight parts of KIWOBOND 1000 HMT with 20 weight parts of KIWODUR 1000 HMT. If no scale is at hand, mix 100 volume parts KIWOBOND 1000 HMT with 10 volume parts KIWODUR 1000 HMT. For higher solvent resistance and for precoating of the frame, the ratio of hardener can be increased. However, when increasing the amount of hardener the adhesive becomes more brittle.

2.3. Applying the adhesive

Using pressure apply the adhesive with a short bristle brush or scraper-type applicator onto the bonding area of the mesh. Make sure that a sufficient amount of adhesive is worked through the mesh and obtains contact with the frame. Bubbles showing through the mesh indicate poor contact between mesh and frame.

2.4. Curing / Drying time

The adhesive dries in about 3-7 minutes depending on application thickness and room temperature. After approximately 3-7 minutes the frame can be cut away from the stretching unit. After 3-4 hours the adhesive is relatively resistant to solvents and water and over-lacquering or degreasing is possible. The complete chemical resistance is achieved after 24 hours.

2.5. Protective lacquers

If the frames are used in automatic screen washing units or if the adhesive has prolonged contact with solvents, over lacquering with Estelan AR is recommended.

3. PHYSICAL PROPERTIES

Cleaning:	Uncured: Acetone Cured: PREGAN DL/2
Color:	Kiwobond 1000 HMT: red Kiwodur 1000 HMT: dark-red
Potlife:	40 - 90 minutes in open containers, or depending on the size of the opening; several hours in closed containers or squeeze bottles.
Shelf life:	24 Months at 68°F, 20°C
Flash point:	Kiwobond 1000 HMT: -18°C, 0°F Kiwodur 1000 HMT: -4°C, 25°F
TLV:	750 ppm Acetone 400 ppm Ethyl Acetate Kiwodur 1000 HMT contains traces of MDI which has a ceiling limit of 0.2 ppm
VOC:	701 grams/liter, 5.84 lbs/gal
HMIS rating:	Health - 2 Flammability - 4 Reactivity - 1

4. PERSONAL PROTECTION / SAFETY

KIWOBOND 1000 HMT and Kiwodur 1000 HMT are highly flammable. Keep away from sources of ignition. DO NOT SMOKE. Do not breathe fumes. Working areas must be well ventilated. Wear chemical-splash eye goggles and protective gloves. Use respiratory protection if exposure limits are exceeded. See Material Safety Data sheet for additional information.

5. ENVIRONMENTAL PROTECTION

Do not empty into drains. Completely hardened and dried adhesive can be eliminated as non-hazardous solid waste. Consult your local authorities for local regulations.

6. PACKAGING

700 gr. Set pack

4.25 kg Kiwobond 1000 HMT (adhesive), 1 kg Kiwodur 1000 HMT (hardener) each sold separately

7. ADDITIONAL INFORMATION

For additional product information, please visit our web site at www.kiwo.com. For further information contact your KIWO distributor or KIWO direct.

Thank you for choosing **KIWO**.