

KIWOBOND® 1006 HMT

Fast drying, two-component screen adhesive

KIWOBOND 1006 HMT is a fast drying, highly viscous, two-component screen adhesive for a highly chemical resistant bonding of screen meshes to frames made of aluminium, steel, wood and galvanized iron. It is applied by brush. Thick viscosity makes it especially suitable for bondings of coarser screen meshes. After curing it is almost completely solvent resistant. KIWOBOND 1006 HMT is fast drying and therefore allows to release the frame from the stretching unit after a short time. Bondings of screen meshes with high tension values are possible without any loss of tension after having released the frame from the stretching unit. The adhesive film does not embrittle and does not cut the mesh if some adhesive has been brushed into the screen surface.

APPLICATION

Before use, thoroughly remove any old adhesive residue from the frame with e.g. PREGAN DL. This is not necessary if the old adhesive film shows an even surface without break-outs. If sand-blasted aluminium frames are used, ensure that the dust is being removed. The bonding areas have to be free from fats and all other materials operating as separating agents. To achieve best adhesion it is recommended in some cases to apply a hardener of the KIWODUR 1000 HMT series onto the frame.

Before use, mix KIWOBOND 1006 HMT with 20% of a hardener from the KIWODUR 1000 HMT range. Stir both components well and apply within approx. 45 - 70 min. Using pressure, apply the adhesive mixture with a hard brush onto the area of the mesh to be bonded. KIWOBOND 1006 HMT dries especially fast if a relatively thin adhesive film is applied. Depending on the mesh type and ambient conditions the mixture can be reduced with a little KIWOSOLV L 63.

Mesh	KIWOSOLV L 63
under 21 - 140 (T)	undiluted
21 - 140 (T) up to 43 - 80 (T)	15 - 20%
45 - 70 (T) up to 120 - 34 (T)	25 - 30%
over 120 - 34 (T)	35 - 40%

The drying time mainly depends on the mesh to be bonded, the quantity of adhesive to be dried and the room temperature in combination with the respective air circulation.

Guide values at 20°C:

Mesh	Time in stretching unit
120 - 34 (120 T)	approx. 5 min
51 - 70 (51 T)	approx. 10 min.
21 - 140 (21 T)	approx. 15 min

While a relatively good resistance to water and many solvents is already achieved after approx. 1 hour, full resistance will only be reached after a total curing time of approx. 24 hours.

Although KIWO BOND 1006 HMT has a very good solvent resistance, it is advisable to protect the adhesive layer with a protective lacquer especially if automatic screen washing units are to be used. ESTELAN Y 224-03 is especially suitable (see separate technical product information). The protective lacquer can be applied after approx. 2 - 3 hours depending on the applied adhesive quantity and drying conditions.

POTLIFE 45 - 70 min. (depending on the room temperature and mixed adhesive quantity)

REDUCING KIWOSOLV L 63

CLEANING Unhardened: KIWOSOLV L 63
 Hardened: PREGAN DL

COLOUR Colourless

VISCOSITY Approx. 3.600 mPas (Rheomat RM 180, MS = 33, D = 100 s⁻¹, 23°C)

FLASH POINT Approx. -18°C

**HEALTH HAZARDS/
 ENVIRONMENTAL
 PROTECTION** When working with KIWO BOND 1006 HMT and hardeners from the KIWODUR 1000 HMT range ensure sufficient ventilation of the working areas. Avoid contact with eyes and skin. Keep away from sources of ignition. Do not smoke.

Please follow further information given in the material safety data sheets.

STORAGE 15 months (at 20 - 25°C and tightly closed original container)

At temperatures around + 8 °C, consistency of KIWO BOND 1006 HMT can become gel-like. Warm up to room temperature and shake or stir well to achieve normal consistency. Freezing and warming-up do not have any influence on the adhesion strength.