

KIWOBOND® 930

Two-component screen adhesive

KIWOBOND 930 is a two-component screen adhesive for a highly chemically resistant bonding of screen meshes to frames made from aluminium, steel, wood and galvanized iron frames. It can easily be applied by brush. KIWOBOND 930 is fast drying and after curing resistant to almost all screen printing inks and most cleaning agents. Perfect adhesion to metal and wood. 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. New aluminium frames can be roughened chemically with PREGAN PASTE (see separate technical product information). Between the treatment with PREGAN PASTE and the adhesion do not clean again with solvents. It is important to keep the time between roughening or cleaning and the adhesion as short as possible in order to obtain all reliable adhesion.

In some cases the adhesion to metal frames may be difficult if silicone-based separating agents have permeated into the frame surface. In this case singe the frame with a soot-free flame.

Before use, mix KIWOBOND 930 with 20% of a hardener of the KIWODUR 930 series. Stir both components well and apply within approx. 2 - 3 hours. Using pressure, apply the adhesive mixture with a hard brush onto the area of the mesh to be bonded. For very fine meshes (finer than 100 threads/cm) the mixture can be reduced with a little KIWOSOLV L 63 or L 72.

The drying time mainly depends on the mesh to be bonded, the quantity of adhesive to be dried and the room temperature. Make tests to determine the best conditions.

Guide values at 20°C:

Mesh	Time in stretching unit
100 - 40	approx. 15 min.
51 - 70	approx. 20 min.
21-140	approx. 30 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 KIWOBOND 930 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. The one-component lacquer ESTELAN Y 224-03 is especially suitable (see separate technical product information). The protective lacquer can be applied after approx. 2-4 hours depending on the applied adhesive quantity and drying conditions.

POTLIFE	2-3 hours (depending on the room temperature and the mixed adhesive quantity)
REDUCING	KIWOSOLV L 63 or -L 72
CLEANING	Unhardened: KIWOSOLV L 63 or -L 72 Hardened: PREGAN DL

COLOUR Colourless

FLASH POINT Approx. -11°C

**HEALTH HAZARDS/
ENVIRONMENTAL
PROTECTION** When working with KIWOBOND 930 and a hardener of the KIWODUR 930 series 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 2 years (at 20-25°C)

If affected by temperatures below -2°C, consistency of KIWOBOND 930 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.