

KIWOBOND® 933 RAPID

Fast drying, two-component screen adhesive

KIWOBOND 933 RAPID is a fast drying, two-component screen adhesive for a highly chemically resistant bonding of screen meshes to frames made of aluminium, steel, wood and galvanized iron. KIWOBOND 933 RAPID is applied by brush and bondings are resistant to almost all screen printing inks and most cleaning agents. It is fast drying and therefore allows to release the frame from the stretching unit after a very short time. 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 933 RAPID with 20% of KIWODUR 933 RAPID. Stir both components well and apply within approx. 1,5 - 2,5 hours. Using pressure, apply the adhesive mixture onto the area of the mesh to be bonded with a hard brush. KIWOBOND 933 RAPID dries especially fast if a relatively thin adhesive film is applied. For very fine meshes (finer than 100 threads/cm) the mixture can be reduced with a little KIWOSOLV L 63.

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

Guide values at 20°C:

Mesh	Time in stretching unit
100 - 40	approx. 10 min.
51 - 70	approx. 15 min.
21 - 140	approx. 20 min.

While a relatively good resistance to water and many solvents is already achieved after approx. 1 - 2 hours, full resistance will only be reached after a total curing time of approx. 24 hours.

Although KIWOBOND 933 RAPID has a very good solvent resistance, it is advisable to protect the adhesion 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 1,5 - 2,5 hours (depending on the room temperature and the mixed adhesive quantity)

REDUCING KIWOSOLV L 63

CLEANING Unhardened: KIWOSOLV L 63
Hardened: PREGAN DL

COLOUR KIWOBOND 933 RAPID: yellowish-orange
KIWODUR 933 RAPID: dark red

KIWOBOND 933 RAPID + 20% of KIWODUR 933 RAPID: reddish-orange

FLASH POINT KIWOBOND 933 RAPID: approx. -14°C
KIWODUR 933 RAPID: approx. - 4°C

**HEALTH HAZARDS/
ENVIRONMENTAL
PROTECTION** When working with KIWOBOND 933 RAPID and KIWODUR 933 RAPID 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 around +6°C, consistency of KIWOBOND 933 RAPID 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.