KLB KÖTZTAL
Lacke + Beschichtungen GmbH

# KLB-BOND
## AC 384 PMMA

Rapid-setting, paste-like 2-component PMMA adhesive for assembly and bonding work. Recommended by BEB for surface and adhesive tensile strength tests with screed, concrete and floor coatings.

### Packaging units

| Article no. | Packaging | Content (kg) | Units/pallet |
|---|---|---|---|
| AK0019-92 | Combo packaging | 1.00 kg | 240 |
| AK0019-94 | | 1.00 Set | 132 |

### Product characteristics

| | |
|---|---|
| Mixing ratio parts by weight | A : B = 1 : 4 |
| Processing time | 5 - 10 minutes at 20 °C / 86 °F |
| Curing time (accessibility) | 25 - 35 minutes at 20 °C / 86 °F |
| Consistency | Structurally viscous paste |
| Colour after drying | Brown-beige |
| Shelf life | 12 months (originally sealed) |

### Product description

**KLB-BOND AC 384 PMMA** is a rapid-setting, paste-like 2-component PMMA adhesive for bonding test stamps within surface and adhesive tensile strength testing on screed, concrete and floor coatings.

**KLB-BOND AC 384 PMMA** is particularly suitable for bonding concrete parts, profiles and other construction elements, where the adhesive has to compensate for inaccurate fitting. In addition, it can be used for small-area repairs. Its reaction times are set to be very fast for quick fixing of the components. A force-fit bond can be achieved after just 15 to 25 minutes.

Surface tensile strengths can therefore be tested within a short time.

The adhesive consists of a liquid resin component A and a reactive powder component B. For consistency control, the dosage of component B can vary within narrow limits (up to about 5-8 %) without loss of quality.

The test kit contains 2 packaging units with 500 g each. For optimal dosing of small quantities, it contains additional equipment (10 pipettes à 10 ml, 2 measuring spoons for approx. 23 g, 10 plastic cups as well as 4 pairs of disposable gloves).

This allows small quantities from approx. 25 g to be mixed efficiently.

### Area of application

Recommended by BEB as testing glue:

- For force-fit assembly and bonding of mineral building components
- For fast-curing small-surface repairs of break-outs or holes prior to the application of reactive resins, etc.
- As suitable adhesive recommended by BEB for testing the "surface and adhesive tensile strength of floors", latest update 2024

## Product features

- very rapid-setting
- low-shrink
- Recommended for surface tensile and adhesive tensile strength tests
- very high adhesion
- short reaction time

## Technical data

| | | | |
|---|---|---|---|
| Solid content | 100 | % | KLB method |
| Density - Component A+B | approx. 1.95 | kg/l | DIN EN ISO 2811-2 (20 °C / 68 °F) |

The values established in tests are average values. Deviations from the product specification may occur.

## Substrate

The surfaces of the elements to be bonded must be dry and free from any kind of dirt. Remove any loose dirt with a broom, vacuum cleaner, or if necessary, with a cleaning machine. Adherent, dry dirt (like slurry, mortar residue, paint or similar) has to be removed mechanically by grinding or shot-blasting. Contamination with liquids (e.g. oil) must be removed with a suitable cleaning agent. In case of unknown or uneven surfaces, a trial bond is recommended.

Test stamps must be grinded to remove any residue from the previous test to allow full-surface adhesion.

In addition, please refer to the information sheet "surface and adhesive tensile strength of floors", from the German Association for Screed and Floor Coverings (Bundesverband Estrich und Belag e.V., "BEB").

## Product components

**KLB-BOND AC 384 PMMA**

**AC 384 PMMA testing kit** contains the following:

- 2 bottles of AC 384, Component A with 0.1 kg
- 2 plastic cans of AC 384, Component B with 0.4 kg
- 10 pipettes 5 ml
- 2 measuring spoons for powder component
- 10 wooden spatulas
- 10 plastic mixing cups
- 4 pairs of disposable gloves

**AC 384 PMMA 1 kg packaging unit**

1 packaging unit AC 384 Component A: 0.2 kg
1 packaging unit AC 384 Component B: 0.8 kg

## Mixing

Components A and B will be supplied in the correctly measured mixing ratio. Due to the high reactivity, only the required quantities should be mixed for the respective bonding works.

For processing, pour the liquid A component into a clean mixing container and add powder component B in the required dosage. With small quantities, mixing can be done by hand; however, ensure sufficient mixing especially in the bottom and wall areas. Apply the adhesive immediately after mixing, as the time window is only a few minutes.

With the testing kit supplied, a certain quantity of liquid can be dispensed with the pipette as required. The pipette in the box can dispense 5 ml of liquid. If 10 ml is required, the pipette is filled twice and poured in a mixing container. The required

powder component B can be dosed with the contained plastic spoon. One smoothly levelled spoon corresponds to approx. 22.5 g of powder. This means that 2 levelled spoons are required for dosing 10 ml of liquid.

For consistency control, the dosage can be adjusted slightly within narrow limits. Adding a little less or a little more will not affect the stability.

**Processing**

**Process immediately after mixing!**

Apply the fresh mixture in portions to the area to be glued, distribute and place evenly. Ensure even and full-surface application, then place the part to be bonded on top and press it on; if necessary fix until sufficient adhesion is achieved.

Adhesive stamps must be coated with a thin layer of the mixed material over their entire surface, placed on the desired area and pressed with a slight circular motion.

**Cleaning**

Fresh soiling should be removed as much as possible still in the gelling phase of the adhesive, by mechanical means. If required, to clean fresh contamination and to clean tools, use **VR 28** or **VR 119** immediately. Hardened material can only be removed mechanically.

**Storage**

Store in a cool and dry place. Protect from direct sunlight! Tightly re-seal opened containers. Bring to a suitable processing temperature before application.

**Special remarks**

The product is regulated by the German Ordinance on Hazardous Substances (GefStoffV), the German Ordinance on Industrial Safety and Health (BetrSichV), and transport regulations for hazardous goods. The necessary information is contained in the DIN Safety Data Sheet. Observe all identification information on the container label!

GISCODE: RMA 20

**Indication of VOC-content:**
(EG-Regulation 2004/42) Maximum Permissible Value 500 g/l (2010,II,j/lb): Ready-for-use product contains < 500 g/l VOC.

Please consider the latest version of this product information on our website.

All stated information is based on our experience and technical preparation. We guarantee the correct and proper quality of our products. We do not assume any responsibility for the work not carried out by us, since we have no influence on the processing or processing conditions. We recommend on-site trials to be conducted in individual cases. With the publication of this new KLB product information, all prior information loses validity. The latest version is available electronically on our website www.klb-koetztal.com. In addition, our "General Terms and Conditions“ apply.

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