KIWOBOND® 2000 COLOR

Adhesive component for the KIWOBOND 2000 COLOR system

KIWOBOND 2000 COLOR is a fast drying, two-component screen adhesive that can be used for identifying the mesh as well as forming a highly chemical resistant bond between screen meshes and frames made of aluminium, steel, wood and galvanized iron. It is applied by plastic scraper or by brush. The KIWOCOLOR coloring pastes can be added to the adhesive / hardener to identify the mesh. After curing, the adhesive is almost completely solvent resistant. KIWOBOND 2000 COLOR is fast drying and therefore allows removal of the frame from the stretching unit after a very short time. The bonding of screen meshes with high tension values, like high modulus and steel mesh, is possible without any loss of tension after having released the frame from the stretching unit. The adhesive film is not brittle and does not cut the mesh if some adhesive has been scraped / 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 sandblasted aluminium frames are used, ensure that the dust has been removed. The bonding areas have to be free from grease and all other materials operating as separating agents. In some cases, to achieve the best adhesion, it is recommended to apply the hardener KIWODUR 2000 COLOR to the frame first.

Before use, mix KIWOBOND 2000 COLOR with 20% of KIWODUR 2000 COLOR by weight. If required, add 5 - 10% of the relevant coloring paste (-Y-03, -R-04, -B-05, -G-13). When using dark frames we recommend adding 10% to guarantee good opacity. The adhesive / hardener mixture can also be used as a colorless frame adhesive without addition of the coloring paste. Using pressure, apply the adhesive mixture with a plastic scraper or hard brush onto the area of the mesh to be bonded. KIWOBOND 2000 COLOR dries especially fast if a relatively thin adhesive film is applied. For very fine meshes (finer than 260 threads/inch, 100 threads/cm) the mixture can be reduced / thinned with 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 in combination with the respective air circulation.

Guide values at 20°C:

Mesh (threads/inch)	Time in stretching unit
260 - 40	approx. 7 min.
130 - 70	approx. 10 min.
54 - 140	approx. 15 min.

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

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Although KIWOBOND 2000 COLOR has 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. Depending on the color of the adhesive, various protective lacquers from the ESTELAN range are suitable. Ask your local distributor or KIWO direct for advice. The protective lacquer can be applied after approx. 2 - 3 hours depending on the applied adhesive quantity and drying conditions.

POTLIFE 50 - 75 min. (depending on the room temperature and mixed adhesive quantity)

REDUCING KIWOSOLV L 63

CLEANING

Unhardened:	KIWOSOLV L 63
Hardened:	PREGAN DL

COLOR Slightly turquoise, transparent

FLASH POINT Approx. -65°F / 18°C

HEALTH HAZARDS/ ENVIRONMENTAL When working with KIWOBOND 2000 COLOR and KIWODUR 2000 COLOR ensure sufficient ventilation of the working areas.

PROTECTION Avoid contact with eyes and skin. Keep away from sources of ignition. Do not smoke.

Please follow further information given in the health and safety data sheets.

STORAGE 1 year (at 68 - 77°F / 20 - 25°C and tightly closed in original container)

If affected by frost, the consistency of KIWOBOND 2000 COLOR 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.