Kisling AG
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TECHNICAL DATA SHEET

ergo.® 6565 contact adhesive

Fast curing, elastic single-component contact adhesive based on a hybrid-polymer.

Advantages

- low viscosity, may be sprayed
- good flowing behaviour, self levelling
- ductile elastically
- fast curing behaviour
- quick initial adherence
- re-adjustable
- neutral polymerization
- nearly odourless
- free of solvents, silicones and isocyanates.

Application

Bonding in sectors of construction and industry for metal (steel, alu,…), wood, laminate, plastics (PVC etc.). Suitable for elastic bonding in car bodywork and vehicle bodies, in automotive, wagon and container manufacturing, in metal construction, apparatus and mechanical engineering, electrical engineering, ventilation engineering, air-conditioning and plastics technology.
ergo.® 6560 is suitable everywhere, where fast assembling and high initial mechanical consistency is required

Processing

ergo® 6565 may be applied by either using a scraper blade or a spray gun. Best results will be obtained, if the adhesive is applied on both surfaces. The parts may be pressed together either immediately after the glue has been applied or, for best strength, after a 7-8 minutes of pre-curing.
Apply only on clean, dry, fat free surfaces in perfect structural condition. **ergo.® 6565** adheres to various substrates without Primer, but for best results, we recommend the use of Primer ergo.® 6950 on non absorbent and ergo.® 6960 on absorbent surfaces. Bonded metal parts can be spot welded and also be painted with powder coatings. **ergo.® 6565** resists against the baking process conditions
(approx. 20 minutes up to 200°C).
For any application, we recommend preliminary tests.

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Properties of liquid product

Chemical Base	Hybrid-Polymer
Colour	grey
Density at 23°C	1,29 – 1,31 g/cm³
Consitency	low viscous, self levelling liquid
Skinning time at 23°C/50%rh	< 5 minutes
Open time at 23°C/50%rh	< 8 minutes
Change of Volume acc. to DIN 52451	~ 5 %
Working temperature	+5°C to +40°C
Storage conditions	cool (+5°C up to +25°C) and dry
Storage stability	12 month in closed original packaging

Properties of cured product

Tear Strength (DIN 53504 S2) storage 7 days at 23°C/50%rh	~ 2,8 N/mm²
Elongation at break (DIN 53504 S2) storage 7 days at 23°C/50%rh	> 200 %
Modulus at 100% elongation and 23°C (DIN 53504 S2) storage 7 days at 23°C/50%rh	~ 1,0 N/mm²
Shore-A-hardness (DIN 53505) storage 21 days at 23°C/50%rh	~ 40 - 50
Thermal range	-40°C to +90°
Chemical resistance	**good:** against water, aliphatic solvents, oil, greases, diluted inorganic acids and alkalines. **absolutely weather - resistant** **moderate:** against diesel, fuel, esters, ketones **bad:** against concentrated acids and halogenated hydrocarbons