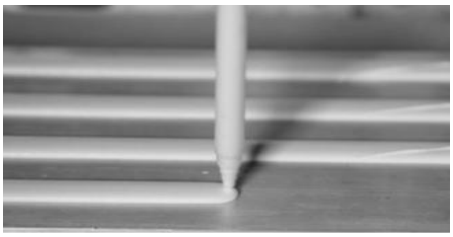
KLEBER KB-XBOND AA230 Acrylic Adhesive

Product Introduction

KLEBER KB-XBOND AA230 is a two-component acrylic adhesive designed for general application. It can provide excellent bonding to automotive sheet metal (aluminum alloy, electrogalvanizing, hot-dipping zinc, cold-rolled steel). The product can be cured quickly at room temperature and has the best performance after high temperature curing.

Features and Benefits

- Good adhesion，oil surface bonding resistance
- High impact resistance
- Reliable for environment test



Typical Properties

Properties	Unit	Part A	Part B	Mixed
Appearance	-	Off-white Paste	Grey Paste	Grey Paste
Viscosity @ 25°C	Pa·s	200-400	200-400	200-400
Specific Gravity	g/cm^3	1.18	1.49	-
Mix Ratio by Volume	-	4	1	-
Working Time @ 25°C	min	-	-	15-20
Curing Time @ room temperature + high temperature curing	min	-	-	25℃*60min+170℃*20min

Properties after bake-curing

Properties	Unit	Test Method	Value
Lap Shear Strength, Aluminum @ 25°C	MPa	ASTM D1002	> 13
T-peel Strength, Aluminum @ 25°C	N/mm	ASTM D1876	> 4

Application

- Door cover edge bonding
- Sunroof edge bonding
- Fender edge bonding

Operation Process

- Mixing: mix the two parts at a ratio of 4:1 by volume, handheld cartridges or automatic dispense are recommended for accurately mixing.
- Applying: apply the mixed adhesive to bond surfaces, join the parts and add enough pressure until the handling strength is reached.
- Curing: the mixed adhesive will cure quickly , initially curing at room temperature, and then the best strength is reached after high temperature curing.

Shelf Life/Storage

- Shelf life of each component is 6 months from date of manufacture when stored under 25℃ in original unopened container.

Cautions：
The information provided in the Technical Data Sheet (TDS) (including product use and application recommendations) is based on our knowledge and experience of Kleber products. The data contained in this TDS is for reference only and is considered reliable. We cannot be held responsible for the results of others as a result of methods beyond our control. This product can have a variety of different applications and different working conditions in your environment, which is beyond our control. Therefore, Kleber assumes no responsibility for whether the product is suitable for your production process and conditions as well as the expected applications and results. We strongly recommend that you test the product before use to confirm the applicability of the product.

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