KLEBER KB-XBOND UA307 Urethane Adhesive

Product Introduction

KLEBER KB-XBOND UA307 is a two-component urethane adhesive designed for general application. It can provide excellent bonding to FRP, SMC and other plastic materials with little surface treatment, The adhesive can be cured at room or elevated temperature.

Features and Benefits

- Good adhesion for wide application
- Reliable for environment test

Typical Properties

Properties	Unit	Part A	Part B	Mixed
Appearance	-	Black liquid	Dark Brown liquid	Black Paste
Viscosity @ 25°C	cps	5000-15000	5000-15000	-
Specific Gravity	g/cm^3	1.23	1.38	1.31
Mix Ratio by Volume	-	1	1	-
Working Time @ 25°C	min	-	-	6-8
Curing Time @ 25°C	h	-	-	1-2

Typical Cured Properties

Properties	Unit	Test Method	Value
Lap Shear Strength, CFRP @ 25°C	MPa	ASTM D1002	14
Lap Shear Strength, SMC @ 25°C	MPa	ASTM D1002	SB
Lap Shear Strength, PC/ABS @ 25°C	MPa	ASTM D1002	8
Tensile Strength	MPa	ASTM D638	17
Elongation at Break	%	ASTM D638	65
Glass Trannsition Temperature	°C	DMA	40

Application

- Automotive
- Bus
- Train

Operation Process

- Mixing: mix the two parts at a ratio of 1:1 by volume. Handheld cartridges or automatic dispense are recommended for accurately mixing.
- Applying: clean the substrates and 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 reach cure in 24 hours at room temperature. The curing process can be accelerated by increasing the temperature.

Shelf Life/Storage

- Shelf life of each component is 6 months from date of manufacture when stored at 15-30°C in original unopened container. After opening, protect each component from excessive moisture by using dry nitrogen as an inert cover.

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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