



Kisling AG

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TECHNICAL DATA SHEET

ergo® 6615 Hybrid-Polymer

(two-component grade out of ergo.® 6613 and hardener ergo.® 6614)

ergo.® 6615 belongs to the newest generation of fast curing, permanently elastic Hybrid-Polymer adhesives. The universal product shows excellent adhesion to a wide range of materials, like plastics (ABS, PMMA, PC,...) and allows combinations with metals, glass and ceramics, too. Common applications are:

Horizontal flexible potting, covering and sealing of plates, metal sheets, boxes and containers, cabins, disguises, sandwich components, bottom covers, frames, panels, coverings.....

Elastic bonding in fields of metal construction, machine and apparatus building, electro-, plastic-, ventilation technologies as well as in automotive-, freight car-, waggon-, container- and solar industry.

Advantages

- Neutral curing system
- Does not contain solvents, silicones or isocyanates
- Low odor
- Reliable fast curing (0,5 N/mm² tensile strength already after 20 minutes)
- Suitable for gaps up to 2mm (optimum 0,5mm – 2mm)
- Permanently elastic, covers tensions
- No tension cracks in combination with ABS
- Good adhesion, even without primer
- Good compatibility with thermoplastics, varnished or galvanized surfaces
- Also suitable as potting compound
- Very low loss of volume

Properties of liquid product

Chemical base	Hybrid-Polymer
Appearance	slightly thixotropic
Colour, ergo.® 6613	pale grey
ergo.® 6614	black
mixture	dark grey
Density at 23°C, mixture	1,34 – 1,44 g/cm ³
Mixture ratio	1 : 1 (v : v)

Typical properties of cured product

Tensile strength (DIN 53504 S2)	
after 20 minutes at 23°C/50%rh	~ 0,5 N/mm ²
after 60 minutes at 23°C/50%rh	~ 1,0 N/mm ²
after 7 days at 23°C/50%rh	~ 3,0 N/mm ²
Elongation at break (DIN 53504 S2)	> 250 %



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Modulus at 100% elongation(DIN 53504 S2)
After 7 days at 23°C/50%rh

~ 1,0 N/mm²

Loss of volume acc. to DIN 52451

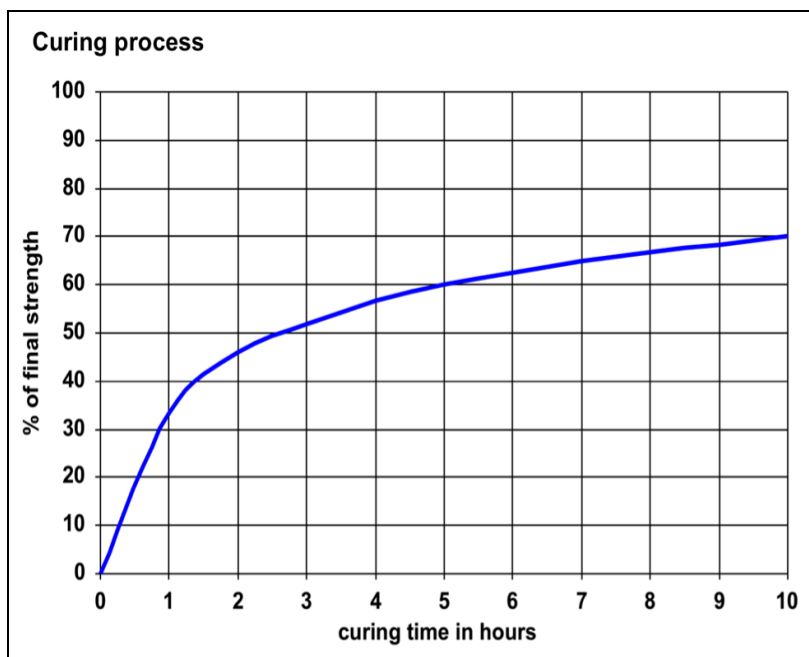
~ 5 %

Shore-A-hardness (DIN 53505)
after 21 days at 23°C/50%rh

40 – 50

Processing (tooling) time
at 23°C/50%rh

~ 10 minutes



at 23°C/50%rh

Thermal range

-40°C up to +90°C
(20 minutes at +180°C is possible)

Processing temperature

+5°C up to +35°C

Packaging

2 x 200ml double cartridge
(20 liter hobbocks on demand)

Storage conditions

cool and dry

Shelf live

6 month in closed original packaging

Chemical resistance

good:
against wheathering, water, aliphatic solvents, oils, grease, diluted anorganic acids and alcalines.

moderate:
against esters, ketones and aromatics

bad:
against concentrated acids and halogenated hydrocarbons



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Instructions for use

Using the double cartridge system

1. Remove the closing plug and insert the cartridge to the gun.
Press pistol as long as both components start flowing out.
Wipe off excess.
2. Put on the static mixer tube
3. Press out product, until the outcoming mass shows homogeneous colour
4. The first 5 cm are to be wasted
5. Do not use pneumatic pistols with pressure above 3 bar

How to remove excess or squeeze-out ?

Liquid product may be removed by using iso-propanol with absorbent paper.
Cured product must be removed mechanically

ergo® 6615 is paintable

Because of the diversity of varnishes and paints on the market, we recommend a preliminary test. After cleaning with acetone, joints can be varnished again at any time.

WARRANTY INFORMATION - PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that KISLING products are safe, effective, and fully satisfactory for the intended end use. KISLING sole warranty is that the product will meet the KISLING sales specifications in effect at the time of shipment. Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. KISLING specifically disclaims any other express or implied warranty of fitness for a particular purpose or merchantability. Unless KISLING provides you with a specific, duly signed endorsement of fitness for use, KISLING disclaims liability for any incidental or consequential damages. Suggestions of uses should not be taken as inducements to infringe any particular patent.