

Technical Data Sheet

Version 05/2025

BondTec AC-Montage 255 (Montagekleber TK)

Produkt Description

Physically drying, solvent-free, acrylic dispersion building adhesive based on synthetic resin dispersion. Cures by drying.

Standards, tests and specifications

- EN 13501: Fire behavior class E
- DGNB/ÖGNI: Q4 in line 42 / Q2 in line 13
- GISCODE: D2



Product Properties

- water-soluble when fresh - tools are easy to clean
- fire behavior according to EN 13501-1: class E
- universally applicable
- simple processing for repair and touch-up work
- paintable
- can be applied with a spatula
- ageing and UV-resistant
- ready-to-use
- almost odorless

Areas of Application

Outdoors, facade construction, window sills, signs, floorings and skirtings, doors, interior constructions, wood construction, repair and reconditioning works.

Not suitable for continuous exposure to moisture.

Form of Delivery

Cartridge:	300 ml
Bucket:	5 kg
Bucket:	14 kg
Packing unit:	20 pieces per box

Substrates

Suitable substrates:

plaster, concrete, aerated concrete, mortar, masonry, brick, clinker, cement, fiber cement, plasterboard, wood, wood chipboard, lacquered, glazed or impregnated wood, wood fiber boards, corrosion-protected metals, corrosion-protected zinc sheet, tiles, polystyrene, many plastics

Unsuitable substrates:

tar, bitumen-containing substrates, EPDM, PIB, PTFE, PP, PE, gypsum, silicone, blank zinc sheet, iron, steel, copper, brass, lead

Instructions for Use

The adhesive surfaces must be clean, dry, free from release agents and firm. Dust, grease, oil and loose parts must be removed before processing. The substrate may be moist but must not be wet. For porous and absorbent substrates, the adhesive surfaces should be precoated with water diluted adhesive (1 part of adhesive and 2 parts of water). Allow this primer coating to dry, and apply the adhesive onto the still slightly moist substrate. When using one-sided lacquered wood (visible surface) use a suitable primer for the unpainted side (bonding surface) to prevent water absorption by the wood.

We advise to carry out a suitability test for the large number of substrates, building materials and/or coatings used today, especially for plastics, paintings and powder coatings. Tar and bitumen-containing substrates can lead to color changes of the mass and affect the adhesion. In case of rain or threat of rain, do not carry out any gluing outdoors. Curing is prolonged by excessively high air humidity. Protect against continuous exposure to water when used outdoors. Avoid water vapor condensation in the bonding area.

Cut off the cartridge nipple with a sharp knife. Screw the nozzle onto the cartridge and cut it to the desired width. Insert the cartridge into the ejector gun and apply the adhesive in the form of strings or in a punctiform manner, never on full-faced. When working from buckets, use a notched trowel and apply glue dots in the size of a hand. Bond immediately while pressing firmly. Do not expose the bonding surfaces to any load before full drying.

It is necessary to check whether a subsequent application of paint on the adhesive is compatible. Some paints can lead to changes of the color of the glue and affect the adhesion. The material consumption depends on the texture/roughness of the bonding surfaces/substrates. Guidance value: 250 up to a maximum of 500 g/m². Adhesive thickness: min. 2 mm. The reaction time depends on temperature as well as air and substrate humidity. The final strength of the bond is achieved after several days.

Do not use the adhesive in earth or permanent moist areas. Since the full hardening of the adhesive depends on the evaporation of the content water, it must be guaranteed that at least one of the bonding surfaces is sufficiently absorbent or that air channels are present so that the content water can evaporate.

Store cartridges cool and dry. Higher temperatures shorten shelf life.

Technical Data

Characteristics	Standard	Value
Density	EN 1183-1	1.65 ± 0.1 g/cm ³
Fire behavior	EN 13501-1	class E
Shore A hardness	EN ISO 868	30 – 50
Skin formation time (normal climate 23/50)		6 - 10 min
Curing (normal climate 23/50, depending on substrate)		ca. 0.5 - 4 mm/day
Temperature resistance (cured mass)		-20 to +80 °C
Processing temperature		+5 to +40 °C
Shelf life (dry, at +10 to +25 °C)		24 months

Safety Instructions

Please refer to our safety data sheet and the product label for further information on product safety and handling. Current safety data sheets and further information on our products can be found at www.insebo.com.

Service

Upon request, our trained sales representatives are always at your disposal.

Disposal

For disposal instructions please refer to our safety data sheet and product label.

Additional Information

This technical data sheet advises without obligation and guarantee. The mentioned processing instructions have to be adapted to the prevailing conditions. The user is obliged to check the suitability and application by own experiments in order to avoid failures.

All given descriptions, data, ratios, weights, etc. can change without notice and do not represent contractually agreed properties of the product. Existing laws, standards and regulations are to be observed by the recipient of our products in their own responsibility.

Due to the large number of possible influences during processing and application, a guarantee of certain properties or suitability for a specific application can not be made, own tests are necessary.

The right to make technical changes is reserved.