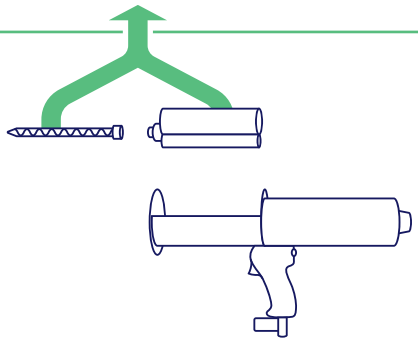
KL 25 Hard Joint

Application Instructions

IMPORTANT: New cartridge = new mixing nozzle!

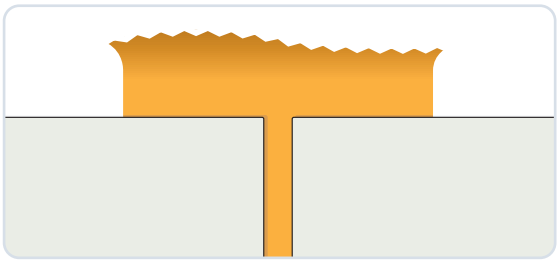


Before starting joint sealing:

Discard at least one mixing nozzle length (10 g; walnut-sized).
This is also required after longer pauses when using a cartridge. Otherwise, incorrect mixing ratios may occur, significantly impairing the curing of the joint compound.

Preparation

Substrate Preparation for GRP Direct Bonding



- For directly installed GRP panels, three-sided adhesion in the joint area must be avoided
- To achieve this, apply a separating layer (e.g. a strip of adhesive tape) to the joint substrate
- The separating layer prevents bonding of the joint compound to the rigid substrate without impairing adhesion to the GRP flanks

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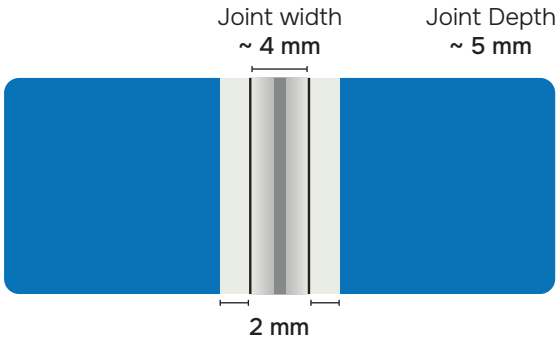
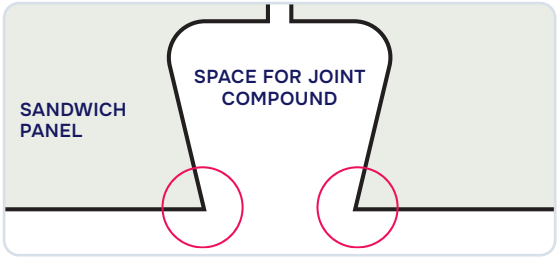
Oberflächenvorbereitung



- GRP surfaces must be load-bearing, dry, clean, and free of grease and dust
- A roughened or milled substrate improves adhesive strength
- Sufficient volume ensures uniform curing and long-term durability
- Apply the joint compound evenly and smooth it off
- Protect the joint area and masking tape edges from construction dust if jointing is not carried out immediately after installation

Edge preparation



- Due to the manufacturing process, glass fibers or foil residues may protrude from the GRP edges. Before jointing: carefully inspect the edges and, if necessary, deburr/smooth them, e.g. using a sanding block or a sharp blade.
- Important: untreated residues can form sharp projections in the joint → risk of injury.

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Material preparation

18 °C – 23 °C
Recommended ideal temperature

- The cartridge and surface should be at room temperature (approx. 18–23 °C) for easy application and optimal curing
- Heat accelerates curing, while cold temperatures delay it
- Application below 15 °C does not produce a suitable result
- Store in a warm room; if necessary, bring to the appropriate temperature using a water bath
- Place the mixing nozzle on top of the cartridge and secure it with the white plastic cap

Execution

Processing time

The processing time varies depending on the temperature of the room and material. The joint cross-section also influences the reaction time – larger cross-sections accelerate curing.

The following data provide an overview of the processing times for KL 25 based on standard joint widths (guide values):

Temperature	16°C	24°C	27°C
KL 25 workable up to	13 min	6 min	5 min
KL 25 firm from	31 min	14 min	9 min
KL 25 tack-free from	24 h	5 h	4 h

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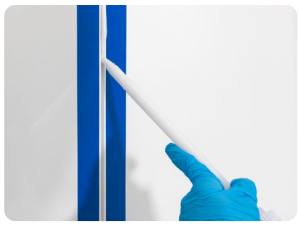
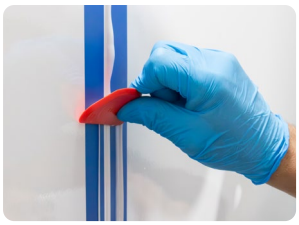
Work sequence

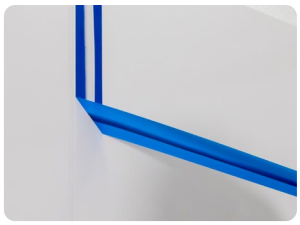
After each nozzle change, extrude and **discard the first 10 g** of material. Only then is the required complete mixing of both components ensured.
Interruptions of more than 5 minutes during extrusion require a nozzle change!



Apply KL 25 joint compound evenly into the joint and fill completely.



Smooth out in a continuous movement using a plastic spatula without smoothing agents to achieve a high-quality result.



Immediately remove the masking tape after smoothing and allow the joint compound to cure (48–72 hours).

Storage and Reuse

- Store opened cartridges with the mixing nozzle attached.
- Before reuse: attach a new mixing nozzle, clean the cartridge opening, and discard the first 10 g of material (to ensure the correct mixing ratio).

For smoothing, we recommend using a plastic jointing tool.
Finish the joint using the straight edge.

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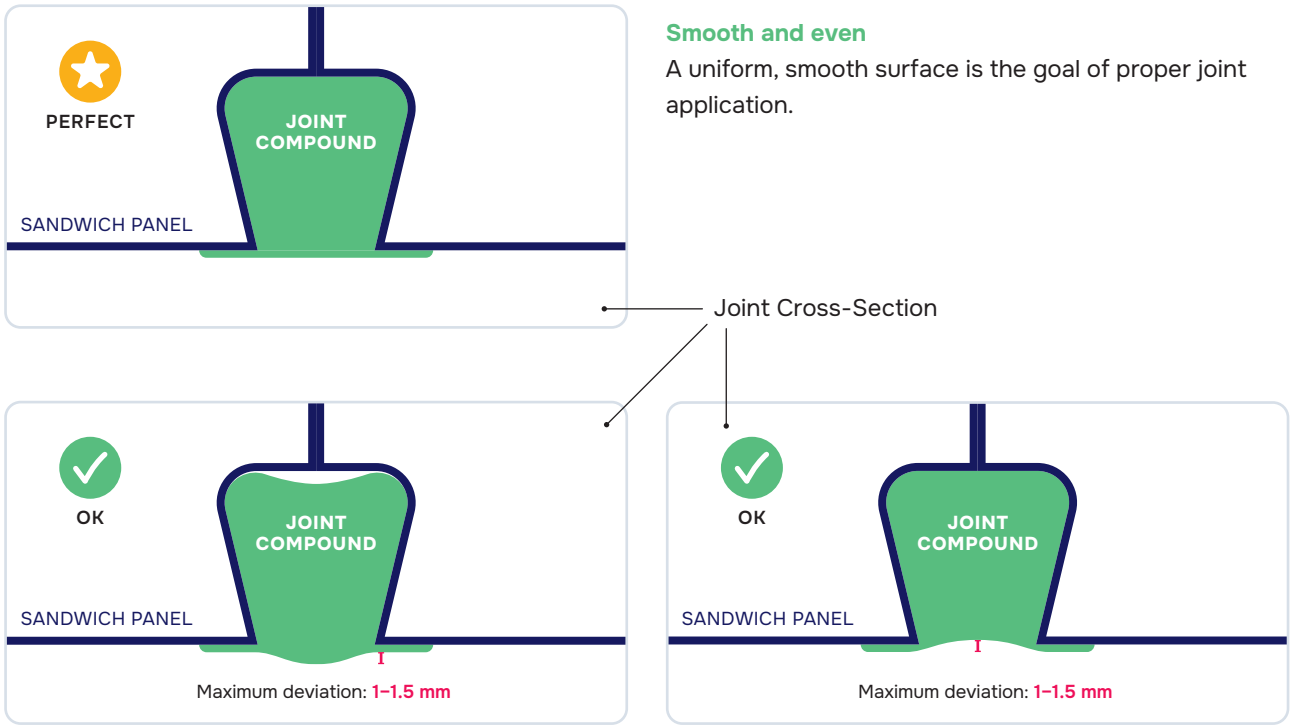
Result

The visual appearance of the joint may vary depending on the area of application (wall or ceiling) and external factors such as room temperature, humidity, and the temperature of the joint compound. The key factor for functionality is the consistent tightness of the joint.



Smooth and even

A uniform, smooth surface is the goal of proper joint application.

Raised and bumpy

Especially in ceiling applications, the joint compound may slightly protrude. In such cases, re-smoothing may be necessary.

Sunken

If the compound is applied too quickly or in insufficient quantity, a visible depression may form. If the depression is too deep, the joint must be refilled and smoothed again.

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