

KLEIBERIT 700.7

Reactive PUR Hotmelt Adhesive

Fields of application

- For assembly bonding
- Good adhesion to different materials such as polystyrene, wood, wood based materials, PVC, aluminium, sheet metal (depending on the material a pre-treatment is necessary)
- Bonding pre-treated PE foils on W&H heavy bag packaging machines

Advantages

- Following cross-linking highly stressed bondings are achieved; they are very resistant to heat, water and cold
- Low processing temperature
- Long open time
- High green strength

Properties of the adhesive

Base: polyurethane
Density: approx. 1.1 g/m³

Viscosity (on the day of production)

Brookfield HBTD 10 rpm:
 at 120 °C 13,000 ± 3,000 mPa·s
 at 140 °C 6,000 ± 2,500 mPa·s

Identification: identification required according to EU regulations; contains diphenylmethane-4,4'-diisocyanate (see our safety data sheet)

Attention

When hotmelt adhesives are melted and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working temperature has been observed. Moreover if the prescribed working temperature is exceeded over a longer period, harmful decomposition products can develop. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

Application techniques

For assembly bonds the adhesive is applied by means of nozzles, slot nozzles or sprayed. Guns suitable for PUR Hotmelts may be used or pre-melting systems with heated hoses and application heads.

The bonded substrates should be stored at room temperature (20 - 25 °C) and with sufficient humidity. At a storage temperature of less than + 10 °C, the crosslinking process is slowed down substantially or at lower temperatures doesn't occur at all.

On subsequent storage at room temperature (20 - 25 °C) and sufficient humidity, the crosslinking process continues normally

Application temperature: 110-130 °C.

Open time: up to 10 minutes (depending upon application method, application quantity and substrate)

Press time: 10 - 30 seconds

Reaction time: up to 7 days (depending on material and ambient temperature)

Chemical cross linking of PUR hotmelts requires moisture. Therefore sufficient air humidity has to be present during processing

The glue joint will not withstand oxidant material, strong acid or alkaline, as well as strong and prolonged UV exposure. We recommend therefore to conduct outside storage test when bags are filled with sensitive materials. Generally use top sheets when bonding PE heavy bags which will protect the glue joint from UV exposure.

Application devices

- Cartridge hand pistol for manual application
- Melting tanks with nitrogen protection
- Bulk melters for 20 and 200 litre drums
- Sealed roller systems, nozzle applicators and slot die extruders

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Cleaning

When finished working with KLEIBERIT 700.7 empty the application aggregate or drain off the remaining PUR hotmelt. Immediately insert EVA hotmelt cleaning compound KLEIBERIT 761.7 - melt and discharge it until the last traces of PUR hotmelt have been removed.

Cured hotmelt can only be removed mechanically.

Packaging

KLEIBERIT 700.7:

carton with 12 cartridges at 300 g net each

carton with 6 pouch packs, 2 kg net

metal pails, 20 kg net

metal drum, 200 kg net

Cleaning Compound

KLEIBERIT 761.7:

metal pail, 15 kg net

Additional packaging sizes available.

Storage

KLEIBERIT 700.7 can be stored in factory sealed containers for approx. 12 months.

Protect from humidity!

Version 08/08/2017 XI; replaces previous versions

Disposal of containers and contents

Waste disposal key 080409

080410 – Adhesive fully cured

Disposal of contents and/or containers should comply with all applicable federal, state and local regulations.

Our containers are made of recyclable material.

Service

Our application department may be consulted at any time without obligation. The statements made herein are based on our experience gained to date. They are to be considered as information without obligation. Please test and establish for yourself the suitability of our products for your particular purposes. No liability exceeding the value of our product can be derived from the foregoing statements. This also applies to the technical consultancy service which is rendered free of charge and without obligation.