# Reactive PUR Hotmelt 703.5

## Reactive hotmelt adhesive based on polyurethane (PUR) for automotive interiors

## Fields of application

- Door paneling; for example bonding retainers and clips
- Most resistant assembly bonding

## Advantages

- Low melting temperature
- Creep resistance is achieved after a short time
- Good adhesion to many plastics (e. g. ABS), wood, wood fiber boards, aluminum
- No stringing

## Properties of the bond

- Extremely high joint strength after curing
- Excellent resistance to heat, more than 100°C (depending upon the material used)
- Resistance to cold temperature as low as -40°C (depending upon the material used)

## Properties of the adhesive

**Base:** polyurethane

**Density:** approx. 1.1 g/cm³

**Viscosity (on the day of production)-**
**Brookfield HBTD 10 rpm:**
at 120°C: 11,000 ± 4,000 mPa s
at 140°C: 6,000 ± 2,000 mPa s

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

**Note:** Intended for commercial use only.

### Attention

When hotmelt adhesives are melted and applied, vapors are set free and an unpleasant odor 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 vapors, e.g. by using a suitable ventilation system.

## Application techniques

### Clips bonding

KLEIBERIT PUR Hotmelt 703.5 is supplied in tightly closed metal containers suitable for use in melting devices. The hotmelt applicators should be designed to protect the hotmelt from being directly exposed to humidity. Special care is to be taken for precise temperature control of the equipment (record starting data of the machine).
The adhesive is usually applied to the base material with nozzles from cartridges or robots. The application temperature ranges between 120-130°C. Setting time depends on material and glue quantity; it begins at 60 seconds onwards. The cross-linking of the adhesive film occurs within 1-3 days according to humidity. Weather tests should be performed only three days after bonding.

### Assembly bonding

PUR Hotmelt 703.5 is applied by means of a hand applicator from a cartridge (smallest packing size) or for higher consumption from 2 kg metal tins, 18 kg or approx. 200 kg metal drums. In this case you need appropriate melting systems. It is also possible to apply it with the swirl-spray method (Foam-Melt®)

FoamMelt® is a registered trademark of Nordson GmbH

**Application temperature:** 120-140°C

**Open time:**
up to 30 sec for a bead thickness of 2 mm on particle board. Open time is influenced by substrates, working temperature, temperature of material, as well as method of application (swirl-sprayed or not)

**Pressing time:**
from 3 seconds onwards. The better the heat dissipation, the shorter the pressing time.

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





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## Application devices

- Cartridge pistol for manual application
- Melting tanks with a nitrogen blanket, also with foaming capabilities
- Bulk melter systems for 20 liter drums

## Cleaning

After finishing the work with KLEIBERIT PUR Hotmelt 703.5 empty the applicator, draw off the residual hotmelt EVA hotmelt - KLEIBERIT Cleaning Compound 761.7 - should be melted and discharged until the last residue of PU hotmelt has been removed. Cured hotmelt can only be removed mechanically.

## Packaging

**KLEIBERIT PUR Hotmelt 703.5:**
carton with 12 cartridges, 300 g net each
carton with 5 metal cans, 2 kg net each
carton with 4 fiber drums with aluminum bags at 2 kg net each
fiber drum with aluminum bag, 18 kg net

**KLEIBERIT Cleaning Compound 761.7:**
carton with 12 cartridges at 250 g net each
carton with 4 bags at 1.5 kg net each
metal drum, 15 kg net

Additional packaging sizes available upon request.

## Storage

KLEIBERIT PUR Hotmelt 703.5 can be stored in originally closed containers as follows:

cartridges, approx. 12 months
cans, approx. 12 months
fiber drum with aluminum bag (2kg), approx. 12 months
fiber drum with aluminum bag (18 kg), approx. 12 months

Protect from humidity!

Version KH 0213; replaces previous versions



**Waste Disposal**
Disposal of contents and/or containers should comply with all applicable federal, state and local regulations.
Our containers are made of recyclable material.





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