

KLEIBERIT 703.5.09

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
- Contains UV tracer

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: 10,000 ± 2,000 mPa s

at 140°C: 5,500 ± 1,500 mPa s

Identification: 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 703.5.09 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

KLEIBERIT 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: 120-130°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 703.5.09 empty the applicator, draw off the residual hotmelt EVA hotmelt - KLEIBERIT 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 703.5.09:

drum, 50 kg net
drum, 190 kg net

KLEIBERIT 761.7:

metal pail, 15 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 703.5.09 can be stored in originally closed containers as follows:

drum, approx. 12 months

Protect from humidity!

Version 02/08/2022 ga; replaces previous versions

Adhesive and Waste Disposal

Waste Code 080409
080410 - adhesive fully cured

Our containers are made of recyclable material. Well drained containers can be recycled.

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.