KLEIBERIT 704.3

Reactive PUR Hotmelt Adhesive for window profile wrapping

Fields of application

- Wrapping PVC profiles, pretreated aluminium profiles, and wood based profiles with PVC window foils, primered acrylic foils, decorative papers and veneers (also fleece laminated)

Advantages

- Suitable for outdoor use
- Very high green strength
- Very good setting properties
- Heat resistance to 150 °C, (according to the material used)
- Cold resistance down to -40 °C, (according to the material used)
- Approved according to RAL GZ 716

  (because of the different types of PVC used for the profiles preliminary tests are necessary)

Properties of the adhesive

Base:	polyurethane
Specific weight:	approx. 1·1 g/cm³
Viscosity (on the day of production**)**	
Brookfield HBTD 10 rpm:	
at 120 °C	33,000 ± 4.000 mPa×s
at 140 °C	17,000 ± 3.000 mPa×s
Identification:	identification required according to EU regulations; contains diphenylmethane-4,4'-diisocyanate, (see our safety data sheet)

Attention
When hot melt 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

KLEIBERIT 704.3 is supplied in tightly closed containers suitable for use in melting units. The hot melt application aggregate should be designed to protect the hot melt from being directly exposed to humidity. Special care is to be taken of precise temperature control of the equipment (record start data of the machine).
The adhesive is applied by means of a roll or nozzle system to the reverse side of the foils and veneers.

Application temperature: 120 – 140 °C

Consumption:
The quantity applied depends on the surface structure of the materials to be glued. The following information should serve as a guide.

Plastic foils general	30 - 50 g/m²
Plastic foils window	45 - 60 g/m²
Decorative papers	30 - 70 g/m²
Veneers	80 - 100 g/m²

Line speed: 5 - 40 m/min
The rate of feed is dependent upon the materials used and the shape of the profile.

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

Cross-linking of the adhesive film takes place within 1-2 days depending on the moisture available.

For priming PVC window profiles, the following types of primer are available:

KLEIBERIT Primer 831.0 – solvent primer, non flammable
KLEIBERIT Primer 840 – VOC reduced
KLEIBERIT Primer 842 – VOC reduced
KLEIBERIT Primer 848 – solvent primer, flammable

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Primer application:

The primer application - a very thin film - is performed by a continuous system in the primer station of the wrapping machine. To reduce the risk of insufficient priming, the primer can be applied in a double priming station.

The drying process may be supported by heating devices such as hot air blowers, infrared lamps, ceramic heaters, etc. which must be installed in front of the wrapping zone.

Special note on PVC window profiles:

Wait two weeks after wrapping before performing weatherproofing tests or a glycerine test (5 minutes in a bath of glycerine heated to 130 °C)
(see also the special processing guide)

Special note on acrylic flois:

KLEIBERIT 831.4 is available for priming. The primer is applied in a very thin layer and must be fully dry before wrapping.
See the separate Application Guide for further details.

Application devices

- Manual cartridge applicators
- Melting tanks with nitrogen induction blanket
- Bulk melters for 20 and 200 litre drums

Cleaning

After finishing work with KLEIBERIT 704.3 empty the applicator or draw off the remaining hot melt. Immediately insert KLEIBERIT Cleaning Compound HM 761.7 - melt and discharge until the last residues of PUR hot melt have been removed. Cured hot melt can only be removed mechanically.

Packaging

KLEIBERIT 704.3:
pouch pack, 20 kg net

KLEIBERIT Cleaning Compound 761.7:
carton with 12 Aluminium cartridges, 0.250 kg net each
carton with 6 foil bags, 1.50 kg net
metal pail, 15 kg net
bag, 20 kg net
drum, 150 kg net

Storage

KLEIBERIT 704.3 can be stored in factory sealed containers for approx. 12 months

Protect from humidity!

Version 04/06/20 ga; replaces previous versions

Adhesive and Waste Disposal

Waste Code 080409
08410 - 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.

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