KLEIBERIT 704.8

Reactive PUR-Hotmelt Adhesives

Fields of application

- Wrapping PVC foils, pre-treated aluminium profiles and wood based profiles with PVC foils, primed acrylate film, décor paper and veneers (also fleece-backed)

Advantages

- Suitable for outdoor application
- Very high initial strength as well as pronounced tackiness
- Very fast setting
- Heat resistance (depending on the substrate) up to 150 °C
- Cold resistance (depending on the substrate) to – 40°C
- Approved according to requirements of RAL GZ 716

Preliminary tests are necessary due to different PVC-profile formulations

Properties of the adhesive

Base: polyurethane
Specific gravity: approx. 1.1 g/cm³

Viscosity
(on the day of production)
(Brookfield HBTD 10 rpm)
at 120°C: 38,000 ± 6,000 mPa s
at 140°C 20,000 ± 3,000 mPa s

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

Attention:
Hotmelt adhesives release vapours, even if the described working temperature is observed. 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, there is a danger of decomposition products forming which are harmful. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

Application techniques

KLEIBERIT 704.8 is available in tightly fitting metal containers, suited for melting systems.

The application aggregate for the hotmelt adhesive should be such that the adhesive is protected from humidity.

Particular attention has to be paid to a precise temperature control of the entire working system. (Inspect first run and record result.)

Application of the adhesive to the back of the films or the veneer section by means of a roller, doctor blade, or slot nozzle.

Application temperature: 120 - 150°C
The application quantity depends on the surface structure of the materials to be bonded.
The following details should serve as a guide:

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

Line speed: 5 - 40 m/min

The necessary quantity of adhesives is dependent upon the materials to be bonded and profile geometry.

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

Cross linking of the adhesive film occurs in the course of 1-2 days, depending on humidity.

Following types of Primer are available for PVC window foils:

Primer KLEIBERIT 831.0 – solvent primer, not flammable
Primer KLEIBERIT 840 – VOC reduced
Primer KLEIBERIT 842 – VOC reduced
Primer KLEIBERIT 848 – solvent primer, flammable

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Primer order.
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 or hot air blowers which must be installed in front of the wrapping zone.

Special notes 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)

Special notes on acrylate foils:
Primer KLEIBERIT 831.4 is suitable.
The primer application – in a very thin film - needs to be dried off completely before coating.
Additional notes see separate application guidelines.

Application devices

- cartridge pistols for manual use
- bulk melting systems with carbon-dioxide blanket
- barrel melting systems

Cleaning

After finishing work with KLEIBERIT 704.8 empty contents of aggregate or drain off the remaining adhesive. Use Cleaner KLEIBERIT 761.7 immediately feeding, melting and flushing out the emptied aggregate, until all traces of PUR hotmelt have been removed.

Already cross-linked hotmelt adhesive can only be removed mechanically.

Packaging

KLEIBERIT 704.8:
carton with 6 aluminium bags in fiber drums, 2 kg net each
aluminium bag in fiber drum, 20 kg net

Cleaner
KLEIBERIT 761.7:
carton with 12 aluminium cartridges, 0.25 kg net each
carton with 6 foil bags in fiber drums, 1.5 kg net each
metal pail, 15 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 704.8 can be stored in factory sealed containers for approx. 12 months.

Protect from humidity!

Version 14/07/20 ga; replaces previous versions

Adhesives 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.

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