

KLEIBERIT 707.9.50 ME

Reactive PUR-Hotmelt Adhesive

Field of application

Edging of panel materials with:

- ABS-, PMMA-, PVC- and PP-edges (with suitable bonding agent)
- CPL- and HPL-edges (may require bonding agent)
- Paper-edges
- Veneer and solid wood edges

Advantage

- Heat resistance edge-dependent up to +150°C
- Cold resistance up to -30 °C
- Excellent bond strength even when exposed to steam
- Very good stability in open melting tanks (at normal climate 20/65 min. 24 hours)

Properties of the adhesive

Basis: Polyurethane

Density: approx. 1.3 g/cm³

Colour: ivory

Viscosity (day of production)

- Brookfield HBTD 10 Upm:

at 140 °C: 80.000 ± 20.000 mPa·mPa·s

at 160 °C: 45.000 ± 10.000 mPa·s

Working temperature:

140 - 160 °C

Identification: see our safety data sheet

-ME product (Micro-Emission)

Residual monomer content < 0.1%

Hotmelt adhesives release vapours, even if the described working temperature is being observed. When hotmelt adhesives are molten and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working temperature has been observed. If the recommended working temperature is exceeded over a longer period of time, 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

The substrates should be freshly cut at right angles and should be free from dust. Boards and edge material have to be acclimatized to room temperature. Maintain room temperature of at least 18 °C, avoid draughts.

Working temperature:

Roller application 140 - 160 °C

Reduce the temperature to approx. 100 °C during work breaks.

Particular attention should be paid to the accurate temperature control when bonding HPL and solid wood edges. Work at the upper temperatures when bond and thick substrates. Low temperature reduces the wetting of the edges. Coat weight and pressures should be adjusted so that the applied adhesive pearls are slightly pressed out at the edges. Effective pressing out can be checked with a transparent test edge.

Reactive PUR hotmelts have a slightly lower green strength compared to EVA hotmelts. Therefore:

- Only use recently prepared solid wood edges, with perfect fit. Curved edges are not suitable
- Ensure that the base substrate has perfect edges too.
- PUR-hotmelt adhesives, compared to EVA hotmelt adhesives, achieve significantly closer joints.
- Thick PVC edges in rolls have to be treated with care as they are under high tension.
- Ensure that the press roller apply maximum pressure.

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

The green strength ensures that the product is durable and has a close joint and allows for further processing, such a flush milling of the edges. The cross linking of the product, depending on the humidity will occur in 1-2 days. The final strength is reached after 7 days.

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Cleaning

After finishing work with KLEIBERIT 707.9.50 ME empty the content of the melting vessel and drain of the remaining adhesive in the system. Immediately afterwards use KLEIBERIT 761.7, melt the cleaner and then allow the cleaner to push the remaining PUR hotmelt out of the system until all PUR hotmelt has been removed. Cross linked PUR hotmelt can only be removed mechanically.

Packaging

KLEIBERIT 707.9.50 ME:

carton with 6 pouch packs, 2 kg net each
pouch pack, 20 kg

Cleaner

KLEIBERIT 761.7:

carton with 12 cartridges, 0.25 kg net each
carton with 6 bags, 1.5 kg net each
metal pail, 15 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 707.9.50 ME can be stored in factory sealed packaging approx. 12 months

Protect from humidity!

Version 08.05.25 lz; replaces previous versions

Klebstoff- und Gebinde-Entsorgung

Abfallschlüssel 080409

080410 - Adhesive fully cured

Unsere Gebinde sind aus recyclingfähigem Material. Gut entleerte Gebinde können der Wiederverwertung zugeführt werden.

Service

Unser anwendungstechnischer Beratungsdienst steht Ihnen jederzeit zur Verfügung. Unsere Angaben beruhen auf unseren bisherigen Erfahrungen und sind keine Eigenschaftszusicherungen im Sinne der BGH-Rechtsprechung. Prüfen Sie selbst, ob sich unser Produkt für Ihre Zwecke eignet. Eine Haftung, die über den Wert unseres Produktes hinausgeht, kann aus den vorliegenden Ausführungen nicht hergeleitet werden, auch nicht aus der Inanspruchnahme unseres kostenlos und unverbindlich zur Verfügung gestellten Beratungsdienstes.

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Page 2 of 2