KLEIBERIT 713.4.04 LE

Reactive PUR Hotmelt Adhesive

Fields of application
- Laminating of fabric/carpet onto carrier components of wood based materials or plastics (e. g. door panels, roof linings or trunk base plates and for bonding retainers and natural fibre materials)
- Laminating for interior finishing motor vehicles

Advantages
- High green strength
- Heat resistance to 150°C (according to the material used)
- Cold resistance down to -40°C (according to the material used)
- Fluorescent - enables application quality to be checked
- Low content of monomers, MDI <1.0%

Due to different formulas of the substrates 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	30,000 ± 5,000 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)
Note:	Intended for commercial use only.

Attention
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, harmful decomposition products can develop. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

Application techniques
KLEIBERIT 713.4.04 LE is supplied in tightly closed containers suitable for use in melting units. The hotmelt application aggregate should be designed to protect the hotmelt 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 slotted nozzle, knife coating, spraying or roller application.

Application temperature: 120 – 140°C

Consumption:
Depending on substrate 50 – 120 g/m²

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

Cross-linking of the adhesive film takes place within 3-5 days depending on the moisture available.

Application devices
- Cartridge hand pistol for manual application
- Melting tanks with nitrogen induction blanket
- Drum melters

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Cleaning
After finishing work with KLEIBERIT 713.4.04 LE empty the applicator or draw off the remaining hotmelt. Immediately insert EVA hotmelt - KLEIBERIT Cleaning Compound HM 761.7 - melt and discharge until the last residues of PUR hotmelt have been removed.
For roller application, clean the roller with KLEIBERIT Cleaning Compound 761.8.
Cured hotmelt can only be removed mechanically.

Packaging
KLEIBERIT 713.4.04 LE:
aluminium bag in fiber drum, 20 kg net
drum, 190 kg net

Cleaning Compound KLEIBERIT 761.7:
metal pail, 15 kg net
Cleaning Compound KLEIBERIT 761.8:
plastic pail, 20 kg net

Additional packaging sizes available upon request.

Storage
KLEIBERIT 713.4.04 LE can be stored in factory sealed containers for approx.12 months

Protect from humidity!

Version 20/07/2018 XI; replaces previous versions

Disposal of containers and contents

Waste disposal key 080409

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

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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