KLEIBERIT 725.4

PO Hotmelt Adhesive

Field of application
- Fixing of folds and bonding of paper bellows for cabin-air filters

Advantages
- Good melting properties
- Suited for continuous thread-shaped application
- Applicable with finest nozzles
- Quick setting properties

Properties of the bond
- Tough-elastic joint, good bond strength
- Good ageing resistance, no brittleness
- Good temperature resistance
- Remains relatively pourable at increased temperature

Properties of the adhesive

Base:	polyethylene
Specific weight:	about 0.95 g/cm³
Colour:	white-transparent
Viscosity (Brookfield HBTD):	
at 180°C:	55.000 ± 10.000 mPa s
at 200°C:	35.000 ± 10.000 mPa s
Softening point (ring and ball):	110°C ± 5°C
Melt-flow index according to DIN EN ISO 1133 (MFI 120°C/2.16g):	50 ± 10 g/10 minutes
Open time:	about 5 seconds for substrates with good thermal conductibility, i. e. metal about 28 seconds for insulating substrates, i. e. filter paper
Delivery form:	granules
Identification:	not required according to EU regulations (see our safety data sheet)

Attention:
Hotmelt adhesives release vapours which can cause unpleasant odours, even if the prescribed process temperature is observed. If the given process temperatures are exceeded for a long period of time, harmful decomposition products can develop.
Therefore measures for the elimination of the vapours have to be taken, e. g. by means of a suitable ventilation/ exhaust device.

Application devices
- Hotmelt application unit with nozzle system for processing very viscous hotmelt adhesives
- Mostly devices with gearwheel pump or tank systems with double piston high pressure pumps

Application techniques
The most favourable process temperature is between 180-210°C.

The adhesive is applied to one side.
When fixing folds the adhesive is applied in thread form over the top of the pleated part of the paper.

The **open time** is dependent on the thermal conductibility of the substrates, on the application temperature of the hotmelt adhesive and on the volume of the dispensed hotmelt adhesive (dot, film or bead form).

Test example:
bead diameter 2 mm, temperature of the hotmelt adhesive immediately after the nozzle of 210°C, substrate = filter paper - **open time 28 seconds**.

An air-shower installed after the application nozzle would accelerate the setting process.

KLEIBERIT SE & Co. KG, Max-Becker-Str. 4, 76356 Weingarten/Germany
Phone: +49 7244 62-0, Fax: +49 7244 700-0
Email: info@kleiberit.com, **www.kleiberit.com**

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Cleaning
Please observe the cleaning instructions given by the manufacturers of the hotmelt applicators.

Packaging
KLEIBERIT 725.4:
plastic bag of 16 kg net

Additional sizes available upon request.

Storage
KLEIBERIT 725.4 can be stored for approx. 2 years.
Keep in a cool and dry place.

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Waste Disposal
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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