

KLEIBERIT 750.6

Polyolefine hotmelt adhesive

Fields of application

- Wrapping of profiles made of wood, wood based materials, e.g. solid wood, chipboard or MDF boards with CPL, decorative papers and veneers
- Pre-coating of papers for the following laminating purpose (via reactivation)

Because of the diversity of wrapping materials, testing with the individual materials is recommended.

Advantages

- Very good application properties, also for extended periods - no stringing
- Variable application temperature, depending on the wrapping material
- Very high green strength together with very good wetting
- Good bond with varied feed rates

Properties of the bond

- Very high heat resistance up to 120 °C, depending on wrapping material and profile diameter
- Very good cold resistance down to -30 °C, depending on the wrapping material
- Good ageing resistance

Properties of the adhesive

Base:	polyolefin
Specific weight:	approx. 0.95g/cm ³
Colour:	yellowish
Softening point (ring and ball):	160 ± 5 °C
Viscosity Brookfield HBTD:	
at 180 °C:	13,000 ± 3,000 mPa s
at 200 °C:	8,000 ± 2,000 mPa s
Working temperature:	170 °C-180 °C when pre-coating paper from 180 °C for veneers and decor papers
Identification:	identification not required according to EU regulations (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

Working temperatures:

- 170 - 180 °C for paper pre-coating
- from 180 °C for coating with veneers and decorative papers

Rate of feed:

- 20-50 m/min.

Application Quantities:

- 60 – 80 g/m² for decorative papers
- 90 – 110 g/m² for micro-veneers

The rate of feed is dependent upon the materials used and the shape of the profile.

The materials must be dry, free from dust and acclimatised.

The high green strength makes a high rate of feed possible; however depending on the profile type, sufficient post-activation in the wrapping zone should be provided.

At a feed rate of less than 20 m/min the adhesion film has to be kept "open" by radiant heat; profile preheating also ensures an optimum bond.

Cleaning

While still hot, working tools can be cleaned with a spatula.

Otherwise use KLEIBERIT 827.0.

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Packaging

KLEIBERIT 750.6:

PE bag, 20 kg net

Cleaner

KLEIBERIT 827.0:

metal can, 4.5 kg net

carton with 12 bottles at 700 g net each

Additional packaging sizes available upon request.

Storage

KLEIBERIT 750.6 can be stored at room

temperature for approx. 2 years.

Keep in a cool and dry place.

Version xv 0716; replaces previous versions

Adhesive and Waste Disposal

Waste Code 080410

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.