

KLEIBERIT 257.7

Non-flammable solvent adhesive

Fields of Use

- Wrapping plastic window profiles with PVC foils and veneers
- Wrapping decorative and construction profiled mouldings made of wood-fibre materials, plastics and metal, to plastic foils, resin-impregnated papers and veneers
- Bonding thermoplastic and duroplastic foils to each other, as well as to wooden materials, rigid PVC, melamine resin surfaces and metals

Advantages

- Good spreading, rolling properties, can be applied with a doctor-knife
- Single-sided application in case of heat activation, economical consumption
- Good heat resistance as one-component adhesive
- Very high heat resistance when used with **KLEIBERIT 870.0**
- Certified in accordance with RAL-GZ 716 (by adding 5 % KLEIBERIT 870.0)

Properties of the Bond

- Good green strength, even for difficult profiles
- Good adhesion to solid wood and plastics
- When used with **KLEIBERIT 870.0**, heat resistance above 100 °C
- Good ageing resistance, insensitive to the influence of water and moisture

Properties of the Adhesive

Base: Polycondensation resin
Solvents: Chlorinated hydrocarbons
Specific weight: Approx. 1.3 g/cm³
Colour: Colourless to slightly yellowish, transparent

Viscosity at 20 °C: 2,000 ± 300 mPa·s

- Brookfield RVT Sp. 4/ 10 rpm -

Hardener: **KLEIBERIT 870.0**
 added quantity: 2.5-5 %

Maturing time following

addition of hardener: 1/2 to 3 hours

Pot Life (with hardener): approx. 24 hours

Open time: without hardener, 6-7 min.
 with hardener, 4-6 min.

Thinner: **KLEIBERIT 821.0**

Identification: See our safety data sheet.

The solids content, viscosity and specific weight are subject to slight variation when containers are open, due to volatile solvents. The values shown can be exactly adjusted by the addition of methylene chloride.

Application Techniques

The materials to be bonded must be dry, free from dust, oil and grease and acclimatised. Moisture content of the substrates: 8-10 %. The most favourable processing temperature is 20 °C. Do not process below 15 °C!

Stir well before use!

Attention!

Pay particular attention to a low moisture content of the materials when wrapping veneers and resin-impregnated paper foils. High moisture content together with the isocyanate content of the hardener may lead to bubbles forming in the adhesive film.

Wrapped profiles must be dried sufficiently prior to packing.

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Application Methods:

- brush or brush gun
- special roller coating machine for products containing solvents
- with spreading head (doctor-knife application)

Application Quantity:

90-130 g/m² one-sided application (continuous wrapping and deep-drawing work)

Continuous Wrapping:

(see also latest separate processing notes)

Pre-treat plastic and metal profiles with fluorescent **KLEIBERIT Primer 831.0**. The application of this primer can be easily checked with the aid of an ultra-violet lamp.

Adhesive Application

The adhesive is applied to the rear side of the foil or veneer strip.

Knife setting = Foil thickness + 0.07-0.10 mm.

Evaporation in a drying channel up to approx. 40°C.

Possible feed-rate up to 20 m/min.

Activation by hot-air stream and radiator, (surface temperature approx. 50° C).

Surface temperature of adhesive approx. 50° C.

Continuous-Cycle Deep-Drawing: Single-sided adhesive application to the foil.

Evaporation time between adhesive application and bonding, 2-3 minutes.

Foil temperature during deep-drawing process: 100-120° C.

Cleaning

Working tools can be cleaned with **KLEIBERIT Thinner 821.0**.

Packaging

KLEIBERIT 257.7:

Metal pail 25 kg net

Hardener

KLEIBERIT 870.0:

Carton containing 12 metal bottles, each 1 kg net

Thinner

KLEIBERIT 821.0:

Metal can 35 kg net

Primer

KLEIBERIT 831:

Metal can 35 kg net

Metal drum 250 kg net

Additional packaging sizes upon request

Storage

KLEIBERIT 257.7 can be stored in factory-sealed containers at 20° C for approx. 1 year.

Container can be under pressure, especially at higher temperatures (>25°C) as well as after transport. Therefore, warm slowly to room temperature, open carefully and stir well before use.

To ensure homogeneity of the hardener with the adhesive, the temperature of the adhesive must be >20°C. The adhesive can develop a jelly-like consistency when kept at lower temperatures, but this will disappear when warmed.

Version 15.07.2021 lz; replaces previous editions

Adhesive and Waste Disposal

Waste Code 080409

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.