

# KLEIBERIT 261.7

**Special polyester-based adhesive with extremely high green tack for wrapping and laminating. Excellent adhesion properties for wrapping pre-treated metal profiles and duroplastic materials.**

## Fields of Use

- Covering panels with PVC and resin-impregnated paper foils
- Wrapping wood and plastic profiles, including window profiles, with PVC foils
- Wrapping PVC profiles and surface pre-treated aluminium profiles with PVC foils, resin-impregnated paper or doubled veneer
- Covering duroplastic substrates with PVC foils

## Advantages

- Good spreading, rolling and knife-coating properties
- Single-sided application in case of heat activation, economical consumption
- Heat resistant to +80° C without hardener
- Heat resistant to +120° C when **KLEIBERIT Hardener 870.0** is added

## Properties of the Bond

**Processing:** Immediately following bonding - high green strength

**Final Strength:** Is achieved after approx. 3 days

**Temperature Resistance:**  
-30° C to +80° C

**Permanent Loading:**  
With hardener, up to +120° C.  
Resistance to permanent load is very much dependent upon the materials used.

**Resistance:** Waterproof, **resistant to plasticizers**, insensitive to oil, petrol and various solvents

**Ageing:** Does not become brittle, adhesive film remains tough-elastic

## Properties of the Adhesive

**Base:** Polycondensation resin  
**Solvents:** Chlorinated hydrocarbons  
**Specific Weight:** Approx. 1.3 g/cm<sup>3</sup>  
**Colour:** Colourless to slightly yellowish-transparent

**Viscosity at 20° C**

- Brookfield RVT, Sp. 4/10 rpm - :

2.000 +/- 400 mPa·s

**Hardener:** **KLEIBERIT Hardener 870.0**,  
quantity to be added: 3-5 %

**Maturing Time after addition of Hardener:**  
30 minutes to 3 hours

**Pot Life** (with hardener):

approx. 24 hours

**Open time:** without hardener: 3-5 minutes  
with hardener: 1-2 minutes

**Thinner:** **KLEIBERIT Thinner 821.0**

**Identification:** identification is required according to EU regulations, contains methylene chloride  
(see our safety data sheet)

The solids content, viscosity and density of adhesive in open containers are subject to slight variation due to the volatile properties of the solvent. The values can be precisely set by adding methylene chloride.

## Application Methods

- With doctor-knife coating heads in wrapping and laminating plants

## Processing

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!

## 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 can cause bubbles to form in the adhesive film.

**Wrapped profiles must be dried sufficiently prior to packing.**

## KLEIBERIT 261.7

### Application quantity:

90-130 g/m<sup>2</sup> (one-sided application and deep-drawing).

### Continuous Wrapping:

(see also our latest separate processing guide)

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 reverse side of the foil or veneer.

Doctor-knife setting = foil thickness + 0.07-0.10 mm.

Evaporation in a drying channel to approx. 50° C.

Possible feed-rate up to 20 m/min.

Activation by hot-air stream and radiator.

**Surface temperature: Maximum 70° 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 261.7:

Metal pail 25 kg net

#### KLEIBERIT Hardener 870.0:

Carton containing 12 metal bottles, each 1 kg net

#### KLEIBERIT Thinner 821.0:

Metal can 35 kg net

#### KLEIBERIT Primer 831.0:

Metal can 35 kg net

Metal drum 250 kg net

Additional packaging sizes available upon request.

### Storage

**KLEIBERIT 261.7** 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 data sheets

#### 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.