

Industrial Adhesive 265.0

Polyurethane adhesive for wrapping frames and profiles with PVC foils and resin impregnated paper foils. May be knife-coated. High initial green strength.

Fields of application

- Covering panels
- Wrapping profiles
- Covering cabinets by means of a rotational wrapping system
- Covering wood, wood based materials and plastics (such as PVC and ABS) with PVC furniture foils and resin impregnated paper foils

Advantages

- Fast drying, high line-speed possible
- High heat resistance when used with hardener

Properties of the bond

- Good adhesion to chipboard, MDF-board and solid timber
- Good initial tack, high peel strength
- Temperature resistant to approx. 100°C when used with 4-5 % KLEIBERIT Hardener F
- addition of hardener.
- Temperature resistant to approx. 70°C without hardener.
- No embrittling of PVC foils.
- Very good ageing resistance

Properties of the adhesive

Base:	polyurethane
Solvent:	chlorinated hydrocarbons
Specific gravity:	approx. 1.3 g/cm ³
Colour:	yellowish transparent
Viscosity at 20°C	
Brookfield sp. 6/20 rpm:	5,000 ± 500 mPa·s
Consistency:	may be knife-coated
Hardener:	KLEIBERIT Hardener F 802.0 (mixing ratio: 4 to max. 5 %)
Pot life (with hardener):	approx. 2 days at 20°C
Thinner:	KLEIBERIT Thinner 821.0
Identification:	identification required according to EU regulations, contains methylene chloride (see our safety data sheet)

Application methods

- Wrapping and laminating machines with knife-coaters
- Cabinet coating machines

Application techniques

The materials to be bonded must be dry, free from dust and grease and must be acclimatised. Moisture content of the substrates 8-10 %. The most favourable working temperature is 20°C; do not process below +15°C.

Adhesive preparation:

The adhesive should preferably be used with hardener (quantity to be added: 4 to max. 5 % KLEIBERIT Hardener F 802.0). Pot life: 2 days. Process old adhesive mixture together with fresh mixture, mixing ratio approx. 1:1. Maturing time of the adhesive hardener mixture: approx. 30 minutes.

Covering panels and wrapping profiles:

Apply adhesive to the foil. The correct adjustment of the knife-coater is 80-100 µ + foil thickness. Coarse and very absorbent chipboards require a slightly higher application quantity, solid timbers and MDF substrates a lower one.

Drying, activation:

The correct adjustment of the drying tunnel must be established by trials. A drying temperature between 40 and 60°C has proved to be favourable. The perfect state of the adhesive is when the applied film is nearly solvent-free but still quite tacky. Fine-pored solid timber requires especially careful drying. To assist activation, the substrates can be pre-heated to 40-50°C. Line speed: approx. 20 m/min. possible.

Rotating cabinet coating:

Apply adhesive to the foil
The adjustment of the knife-coater is (as above panel covering) for a consumption of approx. 120 g/m²

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Drying, bonding:

At normal room temperature and air humidity the drying time is 1-2 minutes, so that 1-2 wrapping lengths can be put forward depending on the working cycle. Cutting off the butt joints is possible within approx. 5 minutes after the bonding process. After that time difficulties might arise in removing the cut off overlapping foil due to the fact that the adhesive has already cured. We recommend you carry out your own trials before starting production and also if you change materials.

Cleaning

Tools can be cleaned with
KLEIBERIT Thinner 821.0.

Packaging

KLEIBERIT Industrial Adhesive 265.0:

metal pail, 25 kg net
metal drum, 240 kg net

KLEIBERIT Hardener F 802.0:

carton with 12 bottles at 1 kg net each
metal canister, 4.8 kg net

KLEIBERIT Thinner 821.0:

metal can 35 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT Industrial Adhesive 265.0 can be stored for approx. 12 months in factory-sealed containers at 20°C. Before use warm to room temperature and stir.

EX1111; replaces previous versions

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.