

# Edge and Foil Glue 466.0

## Edge and foil glue for highest bonding quality

### Fields of application

- PVC furniture foils (all types)
- Flexible PVC-foils, including those with fabric layer
- Resin impregnated surface foils on cellulose base
- For primed PVC, ABS, PMMA and PP edge banding

### Advantages

- Good flowing properties when used in four-roller glue-spreaders
- Good dosing properties, low consumption
- Can also be processed under unfavourable temperature conditions
- Suitable for pump as well as gravity fed from containers placed at a higher level

### Properties of the bond

- High joint strength
- Good temperature resistance with all types of foils and edges
- Good water resistance of the glue film, also with bonding to substrates which are not water resistant
- Good cold resistance of the bond

### Properties of the glue

|                             |                                                                      |
|-----------------------------|----------------------------------------------------------------------|
| <b>Base:</b>                | EVA copolymers                                                       |
| <b>Specific gravity:</b>    | approx. 1.2 g/cm <sup>3</sup>                                        |
| <b>ph-value:</b>            | 6 ± 1                                                                |
| <b>Colour:</b>              | blue-green                                                           |
| <b>Viscosity at 20° C</b>   |                                                                      |
| - Brookfield, sp. 6/20 rpm: | 10.000 +/- 2.000 mPa·s                                               |
| <b>Consistency:</b>         | medium viscosity, good application properties                        |
| <b>Open time:</b>           |                                                                      |
| for foil bonding            | 3-4 minutes                                                          |
| for edge bonding            | 10-12 minutes                                                        |
| <b>Identification:</b>      | not required according to EU regulations (see our safety data sheet) |

### Application methods

- Four-roller glue-spreaders
- Manual application devices (glue rollers), toothed spatula and brush

### Application techniques

Foils, edges and substrates and glue have to be acclimatised to room temperature.

Do not process below room temperature of 15°C.

The ideal moisture content of the wood is 8-10%.

For foil bonding, do not use chipboards with a coarse surface layer. Processing always has to be effected in dust free rooms which are free from dust. Brush substrates before applying the glue:

### Consumption:

|                  |                          |
|------------------|--------------------------|
| for foil bonding | 80-120 g/m <sup>2</sup>  |
| for edge bonding | 150-200 g/m <sup>2</sup> |

The quantity to be applied is dependent on the quality of the substrates.

Especially when using application machines equipped with smooth rollers, the quantity applied should not fall below the above mentioned minimum application quantity.

### Open time:

|                                           |               |
|-------------------------------------------|---------------|
| application qty. 80-120 g/m <sup>2</sup>  | 3-4 minutes   |
| application qty. 150-200 g/m <sup>2</sup> | 10-12 minutes |

The open time depends on the properties of the substrates, the room temperature and the quantity applied. The foil/edge has to be fed continuously from the roll, or pre-cut pieces must be manually laid within the time indicated.

Subsequent corrections are possible.

### Pressing: for foil bonding

In general, foils should only be roller-coated using a rubber-coated roller press and afterwards should be stacked one upon the other with the edges carefully aligned. The application of weights to the stack is recommended in order to ensure that the foil sticks well at the edges.

Subsequent work may be carried out after a stacking time of approx. 2-3 hours. The bond strength can only be judged after 1 day.

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### Stationary pressing of PVC edges and surface bonding

#### 1. Plastic Edge Bonding

Apply the adhesive with a brush to the edge of the particle board. Place the edge material on the edge and press. In order to apply sufficient pressure to develop an adequate bond screw clamps or similar must be applied.

The press times can be accelerated with the addition of heat.

Maximum temperature +40°C.

Further processing of the piece can be done after curing time of 24 hours.

#### Press time for edge bonding:

Normal temperature (+20°C): at least 60 minutes

With addition of heat (+40°C): at least 30 minutes

#### 2. Manual Surface Laminating

Manual lamination is only possible with relatively small pieces (due to short open time of glue). After the adhesive is applied lay the film on top and apply pressure with a felt pad, hand roller or similar. Manual operations are usually done around 20°C to a maximum of 40°C with low pressure of 0.1 N/mm<sup>2</sup>.

#### Press time for surface lamination:

Stacking pressure: 2-3 hours

Stationary press (+20°C): 20 minutes

Stationary press (+40°C): 10 minutes

Care should be paid that no air is trapped under the foil. After joining the pieces should be stacked.

### Cleaning

Machines, application devices and containers can be cleaned with water.

### Packaging

KLEIBERIT Foil Glue 466.0:

box with 4 tins of 0.9 kg net

plastic bucket, 10 kg net

plastic bucket, 34 kg net

container, 600 kg net

Different sizes upon request

### Storage

KLEIBERIT Foil Glue 466.0 can be stored for approx. 1 year in factory-sealed containers at 20° C. Temperature resistance during transport and storage should not be under +5°C. Before use bring up to room temperature (20°C) and stir well to homogenise.

Version KH 0613; 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.