

Reactive PUR Hotmelt 703.5

Reactive hotmelt adhesive based on polyurethane (PUR) for automotive interiors

Fields of application

- Door paneling; for example bonding retainers and clips
- Most resistant assembly bonding

Advantages

- Low melting temperature
- Creep resistance is achieved after a short time
- Good adhesion to many plastics (e. g. ABS), wood, wood fiber boards, aluminum
- No stringing

Properties of the bond

- Extremely high joint strength after curing
- Excellent resistance to heat, more than 100°C (depending upon the material used)
- Resistance to cold temperature as low as -40°C (depending upon the material used)

Properties of the adhesive

polyurethane Base: Density: approx. 1.1 g/cm3 Viscosity (on the day of production)-**Brookfield HBTD 10 rpm:**

at 120° C: $11,000 \pm 4,000$ mPa s at 140° C: $6,000 \pm 2,000$ mPa s

Identification: identification required according to EU

regulations; contains

diphenylmethane-4,4'-diisocyanate (see our safety data sheet)

Note: Intended for commercial use only.

Attention

When hotmelt adhesives are melted and applied, vapors are set free and an unpleasant odor 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 vapors, e.g. by using a suitable ventilation system.

Application techniques Clips bonding

KLEIBERIT PUR Hotmelt 703.5 is supplied in tightly closed metal containers suitable for use in melting devices. The hotmelt applicators should be designed to protect the hotmelt from being directly exposed to humidity. Special care is to be taken for precise temperature control of the equipment (record starting data of the machine).

The adhesive is usually applied to the base material with nozzles from cartridges or robots. The application temperature ranges between 120-130°C. Setting time depends on material and glue quantity; it begins at 60 seconds onwards. The cross-linking of the adhesive film occurs within 1-3 days according to humidity. Weather tests should be performed only three days after bonding.

Assembly bonding

PUR Hotmelt 703.5 is applied by means of a hand applicator from a cartridge (smallest packing size) or for higher consumption from 2 kg metal tins, 18 kg or approx. 200 kg metal drums. In this case you need appropriate melting systems. It is also possible to apply it with the swirl-spray method (Foam-Melt®)

FoamMelt® is a registered trademark of Nordson GmbH

Application temperature: 120-140°C

Open time:

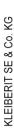
up to 30 sec for a bead thickness of 2 mm on particle board. Open time is influenced by substrates, working temperature, temperature of material, as well as method of application (swirlsprayed or not)

Pressing time:

from 3 seconds onwards. The better the heat dissipation, the shorter the pressing time.

Chemical cross linking of PUR hotmelts requires moisture. Therefore sufficient air humidity has to be present during processing.

Restricted to professional users





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Application devices

- Cartridge pistol for manual application
- Melting tanks with a nitrogen blanket, also with foaming capabilities
- Bulk melter systems for 20 liter drums

Cleaning

After finishing the work with KLEIBERIT PUR Hotmelt 703.5 empty the applicator, draw off the residual hotmelt EVA hotmelt - KLEIBERIT Cleaning Compound 761.7 - should be melted and discharged until the last residue of PU hotmelt has been removed. Cured hotmelt can only be removed mechanically.

Packaging KLEIBERIT PUR Hotmelt 703.5:

carton with 12 cartridges, 300 g net each carton with 5 metal cans, 2 kg net each carton with 4 fiber drums with aluminum bags at 2 kg net each fiber drum with aluminum bag, 18 kg net

KLEIBERIT Cleaning Compound 761.7:

carton with 12 cartridges at 250 g net each carton with 4 bags at 1.5 kg net each metal drum, 15 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT PUR Hotmelt 703.5 can be stored in originally closed containers as follows:

cartridges, approx. 12 months cans, approx. 12 months fiber drum with aluminum bag (2kg), approx. 12 months fiber drum with aluminum bag (18 kg), approx. 12 months

Protect from humidity!

Version KH 0213; 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 your self 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.

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