

KLEIBERIT 703.8

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

Fields of application

- Door panelling, e.g. bonding retainers and clips).
- Highly stressed assembly bonding.
- Lamination of textiles/ carpets or PVC foils to wood based and plastic substrate materials.

Advantages

- Good adhesion to plastics, wood materials and metals (Due to the large number of different material compositions, however, own tests are necessary).
- No stringiness when applied in bead form
- No jamming of robot devices
- Very good stability of the glue beads when applied to inclined surfaces
- Application temperature of 120-140°C
- Very high initial tack, connected with distinct stickiness
- Heat resistance of more than 100°C (depending upon the material used)
- Temperature resistance down to -40°C (depending upon the material used)
- Low emission and fogging

Properties of the adhesive

Base:	Polyurethane
Specific gravity:	about 1.1 g/cm ³
Viscosity (on the day of production) (Brookfield HBTD 10 rpm)	
	at 120°C: 48,000 ± 10,000 mPa s
	at 140°C: 23,000 ± 5,000 mPa s

Identification: see our safety data sheet

Attention:

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

Application techniques

Bonding of clips

KLEIBERIT 703.8 is supplied in sealed metal containers suited for melting systems. The application equipment for the hotmelt adhesive should be such that the adhesive is protected from humidity of the air. Particular attention has to be paid to a precise temperature control of the entire work system. (Inspect first run and record result.)

The adhesive is applied to the substrate material by means of slot nozzles connected to cartridges or robot devices. The application temperature ranges from 120-140°C.

The stability of the bond against shifting depends on the material and the application quantity and is achieved after 60 seconds at the earliest. The cross-linking reaction takes place - depending on the exposure to moisture - within 1 to 3 days from time of application. The final strength is achieved after about 7 days.

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

Assembly bonding

The small amounts can be processed by means of an application pistol connected to a cartridge. Higher quantities such as 2 kg metal cans, 18 kg and 200 kg steel drums can be processed by means of melting units. In order to economize material, the adhesive can also be processed by means of foaming units (FoamMelt®).

FoamMelt® is a registered trademark of Nordson Corporation

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Application devices

- cartridge pistols for manual use
- bulk melting systems with nitrogen blanket
- barrel melting systems for 20 and 200 litre barrels

Cleaning

After finishing work with KLEIBERIT 703.8 empty the contents of the unit or drain off the remaining adhesive. Use EVA hotmelt - KLEIBERIT Cleaner SM 761.7 - immediately feeding, melting and flushing off the emptied unit, until all remainders of KLEIBERIT 703.8 have been removed.

Already cross-linked hotmelt adhesive can only be removed mechanically.

Packaging

KLEIBERIT 703.8:

carton with 12 cartridges at 300 g net each
carton with 5 fiber drums with aluminium bags at 3 kg net each
metal pail, 18 kg net

KLEIBERIT Cleaner SM 761.7:

Carton with 12 cartridges at 250 g net each
Carton with 4 bags at 1.5 kg net each
Metal pail, 15 kg net

Storage

KLEIBERIT 703.8 can be stored in factory sealed containers for the following periods:

cartridges, approx. 12 months
fiber drums with aluminium bags, approx. 12 months
pails, approx. 9 months

Protect from humidity and direct exposure to the sun!

Version 01.07.2022 Iz, 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.