

# KLEIBERIT 704.6.09

## Reactive PUR-Hotmelt Adhesive

### Fields of application

- Laminating fabric/carpet to substrates made of wood based materials or plastics (i.e. for door coverings, headliners or trunk flooring and for natural fiber material)

### Advantages

- Very high green strength
- Very good setting properties
- Heat resistance to 150°C (according to the material used)
- Cold resistance down to -40°C (according to the material used)
- Low emission and fogging

Due to the different types of substrates, preliminary tests are necessary.

### Properties of the adhesive

**Base:** polyurethane

**Specific weight:** approx. 1.1 g/cm<sup>3</sup>

**Viscosity** (on the day of production)

**Brookfield HBTD 10 rpm:**

at 120°C 10,000 ± 2,000 mPa·s

at 140°C 5,000 ± 1,000 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, 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

### Profile wrapping

KLEIBERIT 704.6.09 is supplied in tightly closed containers suitable for use in melting units. The hotmelt application aggregate should be designed to protect the hotmelt from being directly exposed to humidity.

Special care is to be taken of precise temperature control of the equipment (record start data of the machine).

The adhesive is applied by means of a roll or nozzle system to the reverse side of the foils and veneers.

**Application temperature:** 120 – 140°C

### Consumption:

Depending on substrate 50 – 120 g/m<sup>2</sup>

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

Cross-linking of the adhesive film takes place within 3-5 days depending on the moisture available.

### Application devices

- Manual cartridge applicators
- Melting tanks with nitrogen induction blanket
- Bulk melters for 20 and 200 litre drums

## KLEIBERIT 704.6.09

### Cleaning

After finishing work with KLEIBERIT 704.6.09 empty the applicator or draw off the remaining hotmelt. Immediately insert EVA hotmelt - Cleaning Compound KLEIBERIT 761.7 - melt and discharge until the last residues of PUR hotmelt have been removed.

For roller application, clean the roller with Cleaning Compound KLEIBERIT 761.8.

Cured hotmelt can only be removed mechanically.

### Packaging

#### KLEIBERIT 704.6.09:

carton with 12 cartridges, 0.3 kg net each  
carton with 5 metal cans at 2 kg net each  
carton with 6 fiber drums with aluminium bags at 2.0 kg net each  
fiber drum with aluminium bag, 18 kg net  
metal drum, 18 kg net  
metal drum, 200 kg net

### Cleaning Compound

#### KLEIBERIT 761.7:

carton with 12 cartridges, 0.250 kg net each  
carton with 4 bags, 1.50 kg net  
metal pail, 15 kg net

#### KLEIBERIT 761.8:

plastic pail, 20 kg net

Additional packaging sizes available upon request.

### Storage

KLEIBERIT 704.6.09 can be stored in factory sealed containers as follows:

metal cans, approx. 12 months  
fiber drums with aluminium bags (2kg), approx. 12 months  
fiber drums with aluminium bags (18 kg), approx. 12 months  
metal pails, approx. 12 months  
cartridges, approx. 12 months  
metal drums, approx. 12 months

### Protect from humidity!

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#### 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.