

KLEIBERIT 704.6.09

Reactive PUR Hotmelt Adhesive

Fields of application

- Highly stressed membrane, leather and textile lamination
- Lamination of foamed materials on textile
- Lamination in reactivation process

Advantages

- Very high initial strength
- Fluorescent – enables application quantity to be checked
- Long reactivation
- Free of harmful substances, tested and certified in accordance with OEKO-TEX®
(valid ECO passport ZHXA 101889)



Properties of the bond

- Very high bond strength after cross-linking
- Excellent heat and cold resistance

Properties of the adhesive

Base: polyurethane
Density: approx. 1.1 g/cm³

Viscosity (on the day of production)
(Brookfield HBTD 10 rpm)

at 120°C: 70,000 ± 10,000 mPa s
 at 140°C: 40,000 ± 10,000 mPa s

Identification: identification required according to EU regulations; contains diphenylmethane-4,4'-diisocyanate (see our safety data sheet)

Note:

ended for commercial use Int only.

Hotmelt adhesives release vapors, even if the described working temperature is observed. When hot melt 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, there is a danger of decomposition products forming which are harmful. Precautions should be taken to eliminate the vapors, e.g. by using a suitable ventilation system.

Application techniques

KLEIBERIT 704.6.09 is available in tightly fitting metal containers, suited for melting systems. The application aggregate for the Hotmelt adhesive should be such that the adhesive is protected from humidity.

Particular attention has to be paid to a precise temperature control of the entire working system. (Inspect first run and record result.)

Application of the adhesive by means of slot nozzle, doctor blade or roller.

Application temperature: 120 – 140 °C

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

Cross linking of the adhesive film occurs in the course of 7 - 14 days, depending on humidity.

Application devices

- cartridge pistols for manual use
- bulk melting systems with carbon-dioxide blanket
- barrel melting systems

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Cleaning

After finishing work with KLEIBERIT 704.6.09 empty contents of aggregate or drain off the remaining adhesive. Use EVA Hotmelt - Cleaner KLEIBERIT 761.7 immediately feeding, melting and flushing out the emptied aggregate, until all traces of PUR Hotmelt have been removed. Clean the rollers with Cleaner KLEIBERIT 761.8.

Cross-linked Hotmelt adhesive can only be removed mechanically.

Packaging

KLEIBERIT 704.6.09:

Carton with 6 aluminum bags in fiber drums at 2 kg net each
Metal pail, 200 kg net

Cleaning Agent

KLEIBERIT 761.7:

Carton with 12 cartridges at 0.25 kg net each
Carton with 6 bags at 1.5 kg net each
Metal pail, 15 kg net

Cleaning Agent

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 for approx. 12 months

Protect from humidity!

Version 30/08/2018 XI; replaces previous versions

Disposal of containers and contents

Waste disposal key 080409
080410 – Adhesive fully cured

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.