

# KLEIBERIT 704.6

## Reactive Polyurethane Hotmelt Adhesive for profile wrapping

### Fields of application

- Wrapping PVC profiles with PVC foils

### Advantages

- Suitable for outdoor use
- 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)
- Approved according to RAL GZ 716

Due to the different types of PVC used for the profiles, preliminary tests are necessary.

### Properties of the adhesive

<b>Base:</b>	polyurethane
<b>Specific weight:</b>	approx. 1.1 g/cm <sup>3</sup>
<b>Viscosity</b> (on the day of production)	
<b>Brookfield HBTD 10 rpm:</b>	
at 120°C	60,000 ± 15,000 mPaxs
at 140°C	35,000 ± 10,000 mPaxs
<b>Identification:</b>	identification required according to EU regulations; contains diphenylmethane-4,4'-diisocyanate, (see our safety data sheet)
<b>Note:</b>	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 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:

PVC general	40 ± 10 g/m <sup>2</sup>
PVC-Folie	50 ± 10 g/m <sup>2</sup>
decorative papers	50 ± 20 g/m <sup>2</sup>
veneers	90 ± 10 g/m <sup>2</sup>

**Line speed:** 5 - 40 m/min

The rate of feed is dependent upon the materials used and the shape of the profile.

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 1-2 days depending on the moisture available.

For priming PVC window profiles, the following types of primer are available:

KLEIBERIT Primer 831.0 – solvent primer, not flammable  
 KLEIBERIT Primer 840 – VOC reduced  
 KLEIBERIT Primer 848 – solvent primer, flammable

The primer dries fairly quickly. The primer application - a very thin film - is performed by a continuous system in the primer station of the wrapping machine. To reduce the risk of insufficient priming, the primer can be applied in a double priming station.

## KLEIBERIT 704.6

The drying process may be supported by heating devices such as hot air blowers, infrared lamps, ceramic heaters, etc. which must be installed in front of the wrapping zone.

The surface of the PVC must be warmed to 40°C immediately before the first laminating roller.

### Special note on PVC window profiles:

Wait two weeks after wrapping before performing weatherproofing tests or a glycerine test (5 minutes in a bath of glycerine heated to 130°C) (see also the special processing guide)

### Special note on acrylate foils:

KLEIBERIT 831.4 is available for priming. The primer is applied in a very thin layer and must be fully dry before wrapping. See the separate Application Guide for further details.

### Application devices

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

### Cleaning

After finishing work with KLEIBERIT 704.6 empty the applicator or draw off the remaining hotmelt. Immediately insert EVA hotmelt - KLEIBERIT Cleaning Compound HM 761.7 - melt and discharge until the last residues of PUR hotmelt have been removed. Cured hotmelt can only be removed mechanically.

### Packaging

#### KLEIBERIT 704.6:

carton with 12 cartridges, 0.3 kg net each  
 carton with 6 fiber drums with aluminium bags at 2.0 kg net each  
 fiber drum with aluminium bag, 20 kg net  
 metal drum, 200 kg net

#### KLEIBERIT Cleaning Compound 761.7:

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

Additional packaging sizes available upon request.

### Storage

KLEIBERIT PUR Hotmelt 704.6 can be stored in factory sealed containers for approx. 12 months

Protect from humidity!

Version XI 0616; replaces previous versions

#### Adhesive and Waste Disposal

Waste Code 080409  
 080410 - Adhesive fully cured

Our containers are made of recyclable material. Well drained containers can be recycled.

#### 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.