

# KLEIBERIT 706.4.54 ME

## Reactive PUR-Hotmelt Adhesive

### Fields of application

- Surface lamination
- Good adhesion to various materials, such as polystyrene, wood, plaster, woven material, wood material, PVC, aluminium and metal plate (dependant upon the material used, pre-treatment could be necessary)
- The open time allows large surfaces areas to be bonded

### Advantages

- Very high initial strength
- Following cross-linking, a highly warmth-resistant, watertight and extremely cold-resistant bond is attained

### Properties of the adhesive

<b>Base:</b>	polyurethane
<b>Density:</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	12,000 ± 3,000 mPa s
at 140°C	6,000 ± 1,500 mPa s

**Identification:** see our safety data sheet

**- ME Product (micro emission)**  
**residual monomer content < 0,1 %**

### 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

In order to bond large surface areas with KLEIBERIT 706.4.54 ME, a melting plant can be used with a roller-application plant, suitable for PUR hot melt adhesives.

**Reference value for open time for application on chip boards:** approx.. 3 minutes  
 for a

**Application quantity:** 100 g/m<sup>2</sup>

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

**Room temperature:** 20 °C

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

### Application devices

- Tank device with a nitrogen blanket
- Barrel melting plant for 20 litre containers
- Suitable roller-application unit

### Cleaning

Following completion of the work with KLEIBERIT 706.4.54 ME, either run the application empty or drain off the remaining contents. Immediately afterwards apply melted KLEIBERIT 761.8 and reverse the direction of the rollers until the last traces of PUR hot melt have been removed.

Hot melt adhesive which has already cross-linked can only be removed mechanically.

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## Packaging

### KLEIBERIT 706.4.54 ME:

Drum 190.0 kg net

## Cleaning Agent

### KLEIBERIT 761.8:

Plastic pail 20.0 kg net

Fibre drum 136.0 kg net

Additional packaging sizes upon request

## Storage

KLEIBERIT 706.4.54 ME can be stored in factory sealed containers for approx. 12 months.

Protect from humidity!

Version 25.06.24 lz

#### Adhesives 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.