KLEIBERIT 707.0

Polyurethane based cross-linking hotmelt adhesive for edge banding

Fields of application

Secure and durable bond - even with subsequent high mechanical or thermal load, combined with high humidity

- Solid wood edges, up to 13 mm thick
- HPL edges in strips
- PVC edges, extruded/calandered, as strips or rolls, (with primer)
- Veneer edges
- Duroplastic and thermoplastic edges in rolls

Advantages

- Optimum bond even on difficult edges
- Heat resistance of up to 140°C
- Cold resistance up to - 40°C
- Excellent bond strength even under the influence of steam

Properties of the adhesive

Base:	polyurethane
Specific gravity:	approx. 1.1 g/cm³
Colour:	00 opaque 10 white

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

at 120°C:	approx. 60,000 ± 15.000 mPa s
at 140°C:	approx. 35,000 ± 10.000 mPa s
Application Temperature:	120 - 130°C (248 to 266°F)
Delivery form:	Special packaging 2 kg aluminium can
Identification:	see our safety data sheet
Note:	Intended for commercial use only.

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

Application techniques

The substrates should be freshly cut at right angles and free of dust. Boards and edges have to be acclimatized to room temperature. Maintain a room temperature of at least 18°C, avoid draughts.

Application temperature: Roller application 120°C - 130°C

Reduce the temperature to approx. 100°C during work breaks.
Particular attention has to be paid to precise temperature range control when bonding HPL and solid wood edges. Work at the upper temperature if you are bonding to long and thick substrates. Low temperatures reduce wetting of the edges. Application quantities and pressures are to be adjusted so that the applied adhesive pearls when pressed out. The easiest way to check this is with a transparent test edge. In comparison to EVA hotmelts, PUR hotmelts have a slightly lower initial tack. Therefore we recommend the following:

- Use only recently prepared solid wood edges, perfectly fitting edges. Curved edges are not suitable.
- Prepare the edges perfectly.
- In comparison to EVA hotmelts, PUR hotmelt adhesives allow for distinctly thicker joints.
- Thick PVC edges in rolls have to be treated with care as they are under high tension.
- Ensure maximum roller pressure.

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Special notes on processing the adhesive
Remove adhesive block from the can, place the block in the melting unit and melt under exclusion of air, (nitrogen blanket).
After finishing work with KLEIBERIT 707.0 empty contents of aggregate or drain off the remaining adhesive. Use EVA hotmelt - KLEIBERIT Cleaner 761 (available in different viscosities) - immediately feeding, melting and flushing out the emptied aggregate, until all traces of KLEIBERIT 707.0 have been removed. Already cross-linked hotmelt adhesive can be removed mechanically.

The initial tack results in a firm and tight bond. The edge is then ready for subsequent processing, such as flush milling of the edges and cutting off of any excess material. The cross-linking reaction of the adhesive film takes place in the course of 1-2 days, depending on the humidity available. Final strength is achieved after approx. 7 days.
Chemical cross linking of PUR hotmelts requires moisture. Therefore sufficient air humidity has to be present during processing.

Packaging
KLEIBERIT 707.0:
carton with 5 metal cans, 2 kg net each

KLEIBERIT Cleaner 761.7:
carton with 4 bags, 1.5 kg net each

Additional packaging available upon request.

Storage
KLEIBERIT 707.0 can be stored in factory sealed containers for the following periods:
cans for approx. 12 months

Protect from humidity!

03/08/2021 lz; replaces previous versions

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.

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