

Hotmelt Adhesive 796.1

for industrial use

Fields of application

- Bonding of filter paper for the manufacture of pocket filters
- Fixing of filter folds
- Assembly bonding of paper, cardboard, leather, PVC and textiles
- Bonding of underfolds in the automotive field

Advantages

- Very good heat resistance (tested for 20 hours at 120 °C)
- Can easily be processed in tank devices
- Good resistance to chemicals (e.g. diesel or biodiesel)
- Easy, environmentally free disposal

Properties of the adhesive

Base:	polyester
Specific weight:	approx. 1.25 g/cm ³
Colour:	white black
Melt-flow index according to DIN 53 735 (MFI 180/2.16):	
at 160 °C	approx. 160 g/ 10 minutes
Initial viscosity:	
at 160 °C	approx. 80,000 mPa s
After 2 hours in melted state:	
at 180 °C	approx. 45,000 mPa s
Softening point (ring + ball):	approx. 150 °C ± 10 °C
Process temperature:	170-200 °C
Open time:	approx. 30 seconds at 210 °C for a bead diameter of 2 mm
Delivery form:	colour white: granules
Identification:	see our safety data sheet

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 Methods

- Table equipment/ hand guns
- Tank device with gearwheel pump
- Extruders

Application techniques

The temperature should be increased through the zones of pre-melting, principal melting area, hose and nozzle up to the required process temperature. Viscosity, output and open time are influenced by the process temperature.

KLEIBERIT Hotmelt Adhesive 796.1 has little sensitivity to machine stoppage times when below process temperature. After 1 hour the open time is prolonged by about 5 seconds. Even after a stoppage of more than 3 hours there is no fundamental change.

Cleaning

Please observe the cleaning instructions given by the manufacturers of the hotmelt applicators.

Packaging

KLEIBERIT Hotmelt Adhesive 796.1:
paper bag with aluminium liner, 25 kg net

Storage

KLEIBERIT Hotmelt Adhesive 796.1 can be stored for approx. 1 year.
Keep in a cool and dry place.

25/03/22 ga, replaces previous data sheets