

Supratherm 430

One-component laminating adhesive, resistant to high temperatures; for deep drawing, membrane and multiform pressing, as well as for hot sealing.

Fields of application

- 3D bonding of thermoplastic furniture foils to MDF or other fine-grained wood-based materials

Advantages

- Very good spraying properties
- Good activation
- Good temperature resistance up to 90 - 120 °C (depending upon the processing conditions and the profile shape) – according to an in-house test method
- No mixing required
- Good reactivation properties: reactivation time up to 72 hours
- No pot life as with two component adhesives

Properties of the glue

Base:	polyurethane dispersion
Specific weight:	approx. 1.1 g/cm ³
pH value:	approx. 7
Drying time:	30-60 minutes at normal temperature
Identification:	not subject to identification according to EU regulations (see our safety data sheet)

Properties of the bond

- High heat resistance
- Resistant to cold temperatures down to -40 °C
- Can be reactivated up to 72 hours

Product no.	Color of dispersion	Color after drying	Viscosity, 20°C (mPa·s)*	Optim. nozzle Ø (mm)	Spray pressure (bar)**	Reactivation temp. depending on	Temp. Resistance (°C)
430.2	blue	bluish transp	800 ± 200	1.2 1.7	4.0	from 50°C	up to 120
430.3	white	transp	800 ± 200	1.2 1.7	4.0	from 50°C	up to 120
430.4	white	white opaque	800 ± 200	1.2 1.7	4.0	from 50°C	up to 120
430.6	blue	bluish transp	2,500 ± 300	1.7 2.0	4.0 6.0	from 50°C	up to 120
430.7	white	transp	2,500 ± 300	1.7 2.0	4.0 6.0	from 50°C	up to 120
430.8	white	white opaque	2,500 ± 300	1.7 2.0	4.0 6.0	from 50°C	up to 120
430.9	white	fluorescent	2,500 ± 300	1.7 2.0	4.0 6.0	from 50°C	up to 120

*Brookfield RVT

**Determined at the output point of the pressure line

Nozzle diameter and pressure values were determined with a Sata Jet NR95.

Application techniques

The parts to be bonded must be dry and free from dust and grease. For application purposes, the environmental temperature and the temperature of the glue must both be approx. 20° C

Supratherm 430 should be filtered before further use, especially before spray application, in order to remove any polymer particles which may have formed during drying.

The adhesive is applied with a spray pistol, usually to one side of the material to be processed. If the diameter of the hose is too small, a decrease in pressure can occur.

Further information and suitable equipment can be obtained from the pistol manufacturer.

When using a pressure vessel, the spray pressure and the diameter of the nozzle must be adjusted.

Supratherm 430

In this case, the user must check to see which nozzle diameter and spray pressure is suitable. The surface quality after the spray application is always also dependent on the quality of the MDF.

It is recommended that two coats be applied to rounded edges and routed areas due to absorbency of the material.

Application quantity:

Smooth surfaces approximately 40-80 g/m²
 Rounded edges and routed areas approximately
 100 - 120 g/m² (depending on MDF quality)

Allow the adhesive to dry. Exposure to heat will accelerate the process. Drying time at normal temperatures is approximately 30 minutes. The adhesive can be used for up to 72 hours. Subsequent application (bonding) is performed by deep-draw or membrane-press thermal activation.

The necessary sealing time is dependant upon the material and ranges between 30 - 60 seconds. For membrane and multiform pressing, a sealing time of 30 - 90 seconds is usual.

Pay attention that sufficient pressure is applied (4-5 bar!)

Following sealing, allow the adhesive to set for at least 6 hours before processing further.

Cleaning

Application tools and equipment can be cleaned with water. Equipment must be dry before being filled again.

Packaging

KLEIBERIT Supratherm 430:

plastic canister, 10 kg net
 plastic canister, 26 kg net

Additional packaging available upon request.

Storage

KLEIBERIT Supratherm 430 can be stored in factory sealed containers at normal temperatures (approx. 20° C) for approx. 6 months. Protect from heat and sun light!

Do not store or transport at temperatures below +5°C and above +30 °C. Increased storage temperature decreases shelf life of the product greatly and can lead to pressure build up in the packaging.

Protect from frost! Frozen adhesive and cannot be used any more.

Version KH 0615; 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.