

# KLEIBERIT 433 Supratherm

## Water-based PUR adhesive

**One/two-component laminating glue for deep drawing, membrane and multiform pressing as well as for heat sealing processes.**

### Fields of application

- Three-dimensional bondings of thermoplastic furniture foils to MDF-boards or other fine-grained wood-based materials

### Advantages

- Long pot life of up to 8 hours
- Very good sprayability
- Good reactivation properties
- Very smooth surfaces
- Can also be used as one component

### Properties of the glue

**Base:** polyurethane dispersion  
**Specific weight:** approx. 1.05 g/cm<sup>3</sup>  
**pH-value:** 7.5 ± 0.5

**Cross linking agent / hardener:** 2 - 5 % KLEIBERIT 807.0

**Pot life:** approx. 8 hours  
**Drying time:** 30-60 minutes at normal temperature

**Reactivation time:** 8 hours

**Identification:** not required according to EU regulations (see our safety data sheet)

### Properties of the bond

- High heat resistance up to 110°C with hardener
- Cold resistance to -40°C
- Very resistant to moisture and steam

Product no.	Colour of dispersion	Colour after drying	Viscosity at 20°C (mPa·s)*	Optim. nozzle Ø (mm)	Spray pressure (bar)**	Reactivation temp. depending on climate (C°)	Temp. Resistance (°C)	
							1-C	2-C
433.2	blue	bluish transp	800 ± 200	1.2 1.7	3.0 4.0	from 55°	up to 80	110
433.3	white	transp	800 ± 200	1.2 1.7	3.0 4.0	from 55°	up to 80	110
433.6	Blue	bluish transp	2.200 ± 300	1.7 2.0	4.0 6.0	from 55°	up to 80	110
433.7	white	transp	2.200 ± 300	1.7 2.0	4.0 6.0	from 55°	up to 80	110

\*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 materials to be bonded must be dry and free from dust and grease. Processing should generally take place at 20°C.

When hardener is being used, the glue and hardener must be thoroughly mixed together. Gradually add hardener and stir well. At normal temperatures the mixture can be processed for approx. 8 hours.

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. 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.

# KLEIBERIT 433.x.3002 Supratherm

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

## Application quantity:

Depending on MDF quality  
approx. 50 g/m<sup>2</sup> to smooth surfaces  
approx. 100 g/m<sup>2</sup> to cutouts or curves

Let the adhesive film dry. (Drying can be accelerated by means of heat supply if desired.)  
The drying time at normal temperature is at least 30 minutes, can be reactivated.  
The subsequent bonding is achieved by means of thermal activation in the deep drawing or membrane pressing process.

Depending on the material the sealing time required is between 30-60 seconds.  
Membrane and multiform pressing usually requires press times of 30-90 seconds.

**Attention:**  
**maintain sufficient pressure (4-5 bar)!**

After sealing observe an additional setting time of min. 6-24 hours prior to subsequent processing.

## Cleaning

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

## Packaging

### KLEIBERIT 433.x.3002 Supratherm

plastic canister, 10 kg net  
plastic canister, 26 kg net  
one-way drum, 120 kg net

## Hardener

### KLEIBERIT 807.0:

carton with 6 alu bottles at 0.5 kg net each  
carton with 12 bottles at 1.0 kg net each  
metal canister, 6.0 kg net

Additional packaging available upon request.

## Storage

KLEIBERIT 433.x.3002 Supratherm can be stored for approx. 9 months at normal temperature (20°) and in well closed containers.

Do not store or transport under +5°C and over +30°C.

Protect from frost!  
When exposed to frost KLEIBERIT 433.x.3002 Supratherm can no longer be used.

Version 30/03/21 lz; replaces previous versions

## Disposal of containers and contents

### Waste disposal key 080410

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.