

# Foil Glue 453.0

**Special glue for surface bonding of PVC and paper foils by continuous and stationary press-mould method**

## Fields of application

- PVC furniture foils as well as paper foils (decorative papers) on to chipboards, MDF- and fibre boards and plywood
- Also suited for laminating plaster cartons and gypsum fibre boards

## Advantages

- Good flowing properties when used in four-roller glue-spreaders
- Also suited for application by means of GUPFO-gluer and fine-toothed spatula
- Good dosing properties, low consumption
- Best surface quality
- May be pumped as well as gravity fed from containers placed at a higher level

## Properties of the bond

- Good heat resistance with all types of foils up to 100°C
- Good cold resistance depending on type of foil from -15°C down to -25°C
- Good water resistance, also with bonding to substrates which are not water resistant
- High joint strength

## Properties of the glue

|                                     |   |
|-------------------------------------|---|
| <b>Base:</b>                        | EVA copolymers  |
| <b>Specific gravity:</b>            | approx. 1.19 g/cm <sup>3</sup>  |
| <b>ph-value:</b>                    | approx. 6.5   |
| <b>Colour:</b>                      | white   |
| <b>Viscosity at 20° C</b>           |   |
| <b>Brookfield RVT sp. 6/20 rpm:</b> | 30.000 ± 5.000 mPa·s  |
| <b>Consistency:</b>                 | medium viscosity  |
| <b>Open time:</b>                   | 4-5 minutes   |
| <b>Identification:</b>              | not required according to the German hazardous substances regulations GefStoffV (see our safety data sheet) |

## Application methods

- Four-roller glue-spreaders
- Manual applicators

## Application techniques

Foils, substrates and glue have to be acclimatised to room temperature. Do not process below a room temperature of +15°C. The most favourable moisture content of the wood is 8-10 %.

Do not use chipboard with a coarse surface layer. Processing always has to be performed in rooms which are free from dust. Brush off substrates before applying the glue.

**Consumption:** 80-100 g/m<sup>2</sup>

The required quantity depends on the surface quality of the substrates.

Especially when using application machines equipped with smooth rollers, the quantity applied should not fall below the above mentioned minimum application quantity.

**Open time:** 4-5 minutes

The open time depends on the absorbability of the substrates, the room temperature and the quantity applied. The foil has to be fed continuously from the roll, or pre-cut pieces must be manually laid within the time indicated.

Subsequent corrections are possible.

## Pressing:

In general, PVC and other foils should only be roller coated using a rubber-coated roller press and should be stacked afterwards one upon the other with the edges carefully aligned. The application of weights to the stack is re-commended in order to ensure that the foil sticks well at the edges. Subsequent work may be carried out after a stacking time of approx. 2-3 hours. The bond strength can only be checked at the earliest after 1 day.

## Stationary pressing of PVC edges and surface bonding

### PVC Edge Bonding

Apply the adhesive with a brush to the edge of the chipboard. Place the PVC edge material on the edge and press. In order to apply sufficient pressure to ensure an adequate bond screw clamps or similar must be used. Further processing of the piece can be performed 24 hours later.

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### Manual Surface Laminating

Manual lamination is only possible with relatively small pieces (due to short open time of glue).

After the adhesive is applied lay the film on top and apply pressure with a felt pad, hand roller or similar. Manual operations are usually performed around 20°C to a maximum of 40°C with low pressure of 0,1 Nmm<sup>2</sup>. Attention should be paid that no air is trapped under the foil. Following bonding the pieces should be stacked.

### Cleaning

Machines, application devices and containers can be cleaned with water.

### Packaging

#### KLEIBERIT Foil Glue 453:

Plastic canister, 28 kg net

Plastic pail, 34 kg net

Plastic drum, 130 kg net

Disposal container, 1000 kg net

Further packaging upon request

### Storage

KLEIBERIT Foil Glue 453.0 can be stored for approx. 1 year in factory sealed containers at 20°C. Due to its special application, it is recommended to transport and store the glue above +5°C.

EX1109; replaces previous data sheets

#### 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.