

KLEIBERIT 457.7

High quality dispersion adhesive for laminating 3D shapes for automotive interiors

Fields of application

- Laminating of PVC, other decorative films, foam, and textile to PVC and ABS substrates.
- Laminating of PVC and other decorative films to wood, wood based, and textile based materials
- Laminating of textiles with or without foam to substrates for headliners

Advantages

- Aqueous dispersion adhesive, solvent free
- Single-sided application possible
- Immediate high initial tack
- Very good heat resistance
- Meets P1200 Climate Cycle Test requirements
- Slight changes to standard equipment required
- Long reactivation time up to 24 hours (without hardener), reactivation with hardener 8 hours
- Very good resistance to humidity

Properties of the glues

Base	polyurethane dispersion
Density:	approx. 1.1 g/cm ³
ph-value:	approx. 7
Colour:	white
Colour after drying:	transparent
Viscosity at 20° C	
Brookfield RVT	
sp. 6/20 rpm:	2.200 ± 300 mPa s
Hardener:	5% KLEIBERIT Hardener 807.0
Pot life with hardener:	8 hours at normal temperature
Identification:	identification not required according to EU regulations (see our safety data sheet)

Application methods

- Single-sided application by spraying
- Double-sided application in machined areas increases green strength

Application techniques

Data regarding the laminating process

Processing of KLEIBERIT 457.7 is always done with the addition of 5 % KLEIBERIT hardener 807.0. The pot life of the adhesive/hardener mixture is -8 hours at room temperature.

Data for spray application

Pressure of material	
in the pressure vessel:	1.0 - 2.0 bar
spray pressure:	4 - 6 bar
optimum nozzle diameter:	1.7 - 2 mm

1. Plastic lamination

ABS or PVC parts can be primed for example with our KLEIBERIT primer 831.0 to increase adherence; PP and PE substrates must be pre-treated with flame or corona treatment.

Application quantity:	80 - 100 g/m ²
Reactivation temperature:	from 50°C glue film must be virtually dry before reactivation
Press time:	15 - 30 seconds depending on memory

2. Lamination to wood, wood based and textile based materials

Pre-treatment is not required.

Application quantity:	100 - 120 g/m ² glue film must be virtually dry before reactivation
Reactivation temperature:	from 50°C glue film must be virtually dry before reactivation
Press time:	15 - 30 seconds depending on memory

Pressure must be applied equally throughout the piece being bonded. High initial strength is achieved (test the build-up of glue threads).

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Cleaning

Equipment and tools can be cleaned with cold water.

Packaging

KLEIBERIT 457.7:

plastic pail, 10 kg net

KLEIBERIT Hardener 807.0:

carton with 6 bottles, 0.5 kg net each

KLEIBERIT Primer 831.0:

tin can, 35 kg net

Additional packaging sizes upon request

Storage

KLEIBERIT 457.7 can be stored at 20°C and in factory-sealed containers for approx. 9 months.

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

Protect from frost!

After being exposed to frost, adhesive and hardener cannot be processed anymore.

Version XI 0815

Adhesives and Waste Disposal

Waste Code 080410

Our containers are made of recyclable material. Well drained containers can be recycled.

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.

Restricted to professional users

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