

KLEIBERIT 457.9

Aqueous PUR Adhesives

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.

Advantages

- Solvent free
- High initial tack
- Very good heat resistance
- Meets PV1200 Climate Cycle Test requirements
- Slight changes to standard equipment required

Properties of the glues

Base	polyurethane dispersion
Specific weight:	approx. 1.10 g/cm ³
ph-value:	approx. 8
Colour:	white
Viscosity at 20° C	
Brookfield RVT	
sp. 6/20 rpm:	5,000 ± 500 mPa s
Consistency:	thixotropic
Hardener:	VP 9926/32
Identification:	see our safety data sheet

Application methods

- Double-sided application with spray gun
- One-sided application to the less open-pored substrate

Application techniques

Data regarding the laminating process

Processing of KLEIBERIT 457.9 is always done with the addition of 5.5 % hardener KLEIBERIT VP 9926/32. The pot life of the adhesive/hardener mixture is 6-8 hours at room temperature.

Data for spray application

Pressure of material in the pressure vessel:	1.0-2.0 bar
spray pressure:	2.5-4.0 bar
optimum nozzle diameter:	from 1.8 mm

1. Plastic lamination

ABS or PVC parts can be primed for example with primer KLEIBERIT 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:	up to 8 hours
Reactivation temperature:	from 50 °C
	glue film must be virtually dry before reactivation

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

Pre-treatment is not required.

Application quantity:	100 - 120 g/m ²
	depending on the material
Reactivation:	up to 8 hours
Activation temperature:	from 50 °C
	glue film must be virtually dry before activation

Cleaning

Equipment and tools can be cleaned with cold water.

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Packaging

KLEIBERIT 457.9:

plastic pail, 4.5 kg net

plastic pail, 26 kg net

Hardener

KLEIBERIT VP 9926/32:

aluminium bottle, 1 kg net

Additional packaging sizes upon request

Storage

KLEIBERIT 457.9 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 used any longer.

Version 17/04/2023 al; 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.

Restricted to professional users

Page 2 of 2