

# KLEIBERIT 464.8

**Special glue for surface laminating with PVC foils and decorative paper and wrapping drawer frames with PVC foils**

## Fields of application

- Surface lamination of PVC furniture foils and decorative papers onto chipboard, work boards, plywood and fibre boards as well as plaster cardboard's and fibrous gypsum boards
- Wrapping of drawer frames with PVC foils

## Advantages

- Easily measured out, low consumption
- Good flowing properties in four roller glue spreaders
- May be pumped as well as gravity fed from containers placed at a higher level

## Properties of the bond

- High green strength on surfaces as well as when wrapping drawers
- Good green strength and high bonding also on plywood and work boards
- Heat resistance of up to more than 110 °C depending on material
- Cold resistant - dependent on the foil type - down to -15 °C.

## Properties of the glue

<b>Base:</b>	EVA copolymers
<b>Density:</b>	approx. 1.3 g/cm <sup>3</sup>
<b>ph-value:</b>	approx. 8
<b>Colour:</b>	White
<b>Viscosity at 20 °C</b>	
- Brookfield RVT 20 rpm:	14,000 ± 2.000 mPa.s
<b>Consistency:</b>	medium viscosity
<b>Open time at 20°C:</b>	approx. 5 minutes
<b>Identification:</b>	identification not required according to the EU regulations (see our safety data sheet)

## Application methods

- Four roller glue spreaders
- Manual application devices (glue roller) and toothed spatula can only be used to a limited extend for small surfaces

## Application techniques

Foils, substrates and glue have to be acclimatised to room temperature. Do not process below a room and material temperature of +15 °C. The ideal moisture content of the wood is 8-10 %. Use chipboard with an even surface layer (for other chipboard qualities, please make own tests). Processing always has to be done in rooms, which are free from dust. Brush substrates before applying the glue.

## Application quantity: 60 - 120 g/m<sup>2</sup>

The quantity to be applied is dependent on the surface quality of the substrates. Because of the easy measuring of the glue, pay attention that the above mentioned minimum application quantity is adhered to - especially when using application machines equipped with smooth rolls.

## Open time: up to 5 minutes

The open time is dependent on the absorption properties 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 applied within the time indicated. Subsequent corrections are possible.

**Pressing:** In general, PVC and other foils are roller coated using a rubber-coated roller press and afterwards are stacked one upon the other with the edges carefully aligned. The application of weights to the stack is recommended 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 bonding strength can only be judged after 1 day.

## Cleaning

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

# KLEIBERIT 464.8

## Packaging

one-way container, 1,300 kg net

Additional packaging available upon request.

## Storage

KLEIBERIT 464.8 can be stored in factory sealed containers at 20 °C for approx. 12 months.  
Protect from frost!

Version 0815

### 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.