

KLEIBERIT 641.0

1 component, moisture curing and solvent-free polyurethane adhesive for high gloss lamination.

Fields of application

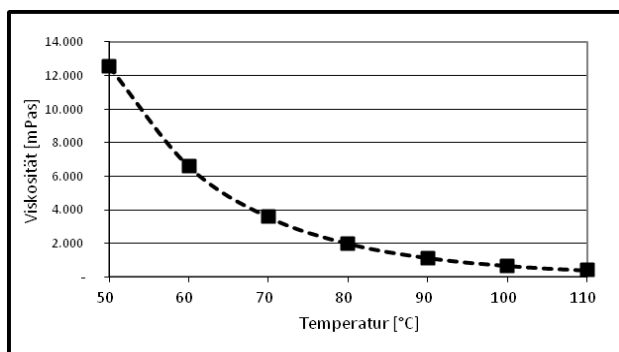
- KLEIBERIT 641.0 is suitable for high gloss lamination consisting of paper and film, for example book and magazine covers.

Fields of application

- Low processing temperature
- After cross linking high heat resistance, waterproof, very cold resistant and high strengths bonding
- The composition of KLEIBERIT 641.0 complies with FDA regulation 21CFR § 175.105, and EU regulations 10/2011

Properties of KLEIBERIT 641.0

Base:	polyurethane
Cross-linking system:	cure under influence of humidity
Specific gravity:	approx 1.10 g/cm ³
Viscosity (on day of production)	
-Brookfield HBTD 10 rpm:	
	at 80°C: 1,800 ± 500 mPas
	at 100°C: 1,000 ± 500 mPas



Identification:	identification required according to EU regulations; contains diphenylmethane-4,4'-diisocyanate (see our safety data sheet)
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One component PUR adhesives set free vapors and an unpleasant odor can occur, even if the recommended working temperature has been observed. Moreover if the prescribed working temperature is exceeded over a longer period, harmful decomposition products can develop. Precautions should be taken to eliminate the vapors, e.g. by using a suitable ventilation system.

Application techniques guidelines

KLEIBERIT 641.0 must be warmed up prior to processing in order to reduce the viscosity so that the material can be pumped.

Pre-heating temperature: 60 - 80 °C

KLEIBERIT 641.0 is a moisture curing system and should therefore be handled without exposure to moisture before processing.

A standard multi-roller system is used for processing.

The roller temperature should be adjusted to the processing conditions (usually 60 - 100 °C).

The roller temperature is highly influenced by the porosity of the paper, line speed and substrate thickness and should therefore be adjusted accordingly (starting temp. ca. 60 °C)

In the event of extended downtime, the application system must always be thoroughly cleaned.

The coat weight depends on the substrates, the application as well as the print color. Typical coat weight is 2 - 5 g/m².

Cleaning

Clean un-cured adhesive in the application and processing units immediately and if necessary wide with a cloth.

After the rollers cooled down completely they can be polished for example with KLEIBERIT Cleaner 828.1

The cleaner must be tested for suitability beforehand. Especially when used on rubber rollers.

Wear suitable protective equipment and ensure sufficient ventilation when working with cleaners (see the safety data sheet).

KLEIBERIT 641.0

Packaging

KLEIBERIT 641.0

fiber drum with aluminum liner, 18 kg net
metal pail, 25 kg net
metal drum, 190 kg net

KLEIBERIT Cleaner 828.1

carton with 4 bottles at 0.75 kg net each

Additional packaging sizes available upon request.

Storage

KLEIBERIT 641.0 can be stored in factory sealed containers at 20°C approx. 9 months. The ideal storage temperature is 15-25°C. Higher temperatures shorten the shelf life.

KLEIBERIT 641.0 is not frost sensitive at temperatures above -20°C

Version xv 0616, replaces previous versions

Adhesives and Waste Disposal

Waste disposal code 080409

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.