

KLEIBERIT 702.0.50 ME

Reactive PUR Hotmelt

Fields of application

- Wrapping wood based materials and PVC profiles with PVC foils and decorative papers, for indoor use
- For laminating carrier boards with decor papers and PVC films

Advantages

- Very high initial tack as well as pronounced stickiness
- Heat resistance of more than 140 °C (depending on the material used)
- Cold resistance down to - 40 °C (depending on the material used)

Properties of the adhesive

Base: polyurethane
Specific gravity: approx. 1.1 g/cm³

Viscosity (on the day of production) (Brookfield HBTD 10 rpm)

at 120 °C: 30.000 ± 5.000 mPa·s
 at 140 °C: 15.000 ± 3.000 mPa·s

Identification: identification not required according to the EU regulations; (see our safety data sheet)

**- ME-Product (Micro-Emission),
Residual monomer content < 0.1 %**

Attention:

Hotmelt adhesives release vapours, even if the described working temperature is observed. When Hotmelt adhesives are melted and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working temperature has been observed. Moreover if the prescribed working temperature is exceeded over a longer period, there is a danger of decomposition products forming which are harmful. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

Application techniques

The application machines for the Hotmelt adhesive should be such that the adhesive is protected from humidity. Particular attention has to be paid to a precise temperature control of the entire working system. (Inspect first run and record result.) The adhesive is applied to the back of the PVC or paper webs by means of a roller or nozzle.

Application temperature of approx. 120 - 140 °C.

The necessary quantity of adhesive is dependent upon the materials to be bonded. As a reference the following values can be used:

- | | |
|---------------------|--------------------------|
| - PVC foils | 40 - 60 g/m ² |
| - Decorative papers | 50 - 70 g/m ² |

Different application quantities are to be examined by means of own tests.

The rate of feed is dependent upon the materials used and the shape of the profile and ranges between 20 - 100 meters/minute.

Chemical cross linking of PUR hotmelts requires moisture. Therefore sufficient air humidity has to be present during processing.

Cross-linking takes place within 1-2 days and is dependent upon the quantity of humidity. Final strength is reached after approx. 7 days.

Application devices

- cartridge pistols for manual use
- bulk melting systems with carbon-dioxide blanket
- barrel melting systems for 20 and 200 litre barrels

KLEIBERIT 702.0.50 ME

Cleaning

After finishing work with KLEIBERIT 702.0.50 ME the remaining adhesive. Use EVA Hotmelt Cleaner - KLEIBERIT 761.7 immediately feeding, melting and flushing out the emptied aggregate, until all traces of the PUR Hotmelt adhesive have been removed.

Already cross-linked Hotmelt adhesive can only be removed mechanically.

Packaging

KLEIBERIT 702.0.50 ME:

Aluminum bag in fiber drum, 2 kg net
Steel drum, 50 kg net

Cleaner

KLEIBERIT 761.7:

carton with 12 aluminium-cartridges, at 0.25kg net
steel pails, 15 kg net
bag, 20 kg net

Additional packaging sizes upon request

Storage

KLEIBERIT 702.0.50 ME can be stored in factory sealed containers for approx. 1 year

Protect from humidity!

Version 22/11/2019 XI

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.