

KLEIBERIT 702.7.09

Reactive PUR Hotmelt Adhesive

Fields of application

For highly durable in bonding of:

- Wood based materials for interior area

General edge banding in the furniture industry

PVC and wood based profiles with:

- PVC foils
- CPL, thick decor paper
- Veneer

Yellow chromated aluminium profiles

For interior finishing of motor vehicles:

- lamination of cloth/carpet or PVC foils to substrates made from wood based materials or plastic

Advantages

- Very high green strength with high tack
- Heat resistance more than 150 °C
- Cold resistance up to -40 °C
- For application control adjusted fluorescent

Properties of the adhesive

Basis: Polyurethane
Specific gravity: approx. 1.04 g/cm³

Viscosity (on the day of production)

-Brookfield HBT10 10 rpm (mPa·s):

at 120 °C 100,000 ± 25,000 mPa·s
 at 140 °C 60,000 ± 15,000 mPa·s
 at 160 °C 35,000 ± 10,000 mPa·s

Identification

Identification required according to the EU regulations; contains Diphenylmethane-4,4'-diisocyanate (see our health and safety data sheet)

When hotmelt adhesives are melted and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working temperature is being observed. If the recommended working temperatures are being exceeded for a longer period of time there is a danger of formation of harmful decomposing products. Precautions to eliminate vapours such as suitable ventilation systems must be taken.

Application techniques

PUR- hotmelts react with ambient air humidity. KLEIBERIT 702.7.09 is available in tightly closed metal containers suitable for platen melters. The package should only be open immediately before use.

The melting equipment must be constructed in such a way that the adhesive is protected from ambient air humidity. It is important that the temperature can be controlled accurately.

Yellow chromated aluminium profiles must be preheated to approx. 40 °C immediately before bonding. The chrome coating must not be older than 4 weeks.

The application temperature for profile wrapping is from 140 °C to 160 °C. For edge banding the application temperature is in the range from 120 °C. (veneer and resin paper can have higher application temperatures)

The required coat weight depends on the material:

E.g. Profile wrapping:

- PVC-Foil	40 - 60 g/m ²
- Decor papers	
(Incl. CPL-Material and thick papers)	50 - 70 g/m ²
- Veneers	80 - 120 g/m ²

E.g. Edge banding onto:

- Particle board and MDF	from 140 g/m ²
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The speed, depending on the materials and the profile geometries used, is between 10-60 m/min and can be even higher. The final bond strength is reached after approx. 7 days.

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

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Application equipment

- Cartridge guns for manual use
- Tank melter with nitrogen blanket
- Drum melting systems for 20 and 200 litre drums

Cleaning

After finishing work with KLEIBERIT 702.7.09 empty the content from the application equipment and drain off any remaining adhesive. Place the EVA KLEIBERIT PUR HM Cleaner 761.7 immediately afterward into the equipment, melt and purge through, until all traces of the PUR hotmelt are gone. Cross linked PUR adhesive can only be removed mechanically.

Packaging

KLEIBERIT 702.7.09:

Aluminum bag in fiber drum	18 kg net
Metal drum	190 kg net

Cleaner

KLEIBERIT 761.7:

Carton with 6 pouches, 1.5 kg net each
 Metal pail, 15 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 702.7.09 can be stored in factory sealed packages approx. 12 months.

Store protected from humidity at 0-35°C!

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Adhesives and Waste Disposal

Waste code 080409
 080410 – Adhesives fully cured

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.