

KLEIBERIT 702.8.04

Reactive PUR Hotmelt Adhesive

Fields of application

- Wrapping PVC films and decorative paper on wood-based materials, corresponding to pretreated PVC and aluminum profiles for interior use

Advantages

- Very high initial tack as well as pronounced stickiness
- Heat resistance of more than 150°C, depending upon the material
- Cold resistance down to - 30°C, depending upon the material
- Fluorescent for controlling application

Properties of the adhesive

Base: polyurethane
Specific gravity: approx. 1.04 g/cm³

Viscosity

(on the day of production)

(Brookfield HBTD 10 rpm)

at 120°C: 33,000 ± 5,000 mPa s
 at 140°C: 18,000 ± 4,000 mPa s

Identification: identification required according to EU regulations, contains diphenylmethane-4,4'-diisocyanate (see our safety data sheet)

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

KLEIBERIT 702.8.04 is available in tightly fitting metal containers, suited for melting systems.

The application aggregate 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.)

Application of the adhesive to the back of the PVC, CPL, paper or the veneer section by means of a roller or nozzle.

Application temperature: 130 – 150 °C

The necessary quantity of adhesive is dependant upon the materials to be bonded

- PVC foils 40 - 60 g/m²
- thin papers 50 - 70 g/m²

For other quantity of adhesive, tests should be performed.

The rate of feed is dependent upon the materials used and the shape of the profile and ranges between 20 to 50 meters/minute.

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

Cross linking of the adhesive film occurs in the course of 1-2 days, depending on 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

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Cleaning

After finishing work with KLEIBERIT 702.8.04 empty contents of aggregate or drain off the remaining adhesive. Use EVA hotmelt - Cleaner KLEIBERIT 761.7 immediately feeding, melting and flushing out the emptied aggregate, until all traces of PUR hotmelt have been removed. Already cross-linked hotmelt adhesive can only be removed mechanically.

Packaging

KLEIBERIT 702.8.04:

pouch pack, 20 kg net
metal drum, 190 kg net

Cleaner

KLEIBERIT 761.7:

Metal pail, 15 kg net
Carton with 12 aluminium cartridges, 0.25 kg net each
Carton with 6 aluminium bags in fiber drums, 1.5 kg net each
Bag, 20 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 702.8.04 can be stored in factory sealed containers for approx. 12 months.

Protect from humidity!

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Disposal of containers and contents

Waste disposal key 080409

080410 – Adhesive fully cured

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

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