# KLEIBERIT 702.8.08

## Reactive PUR-Hotmelt Adhesive

## Fields of application
Bonding of
- Wood based materials
- PVC-Foil
- CPL, thick decor paper
- Veneer

## Advantages
- Very high green strength with high tack
- Heat resistance more than 150°C
- Cold resistance up to -40°C
- Fluorescent setting for application control

## Properties of the adhesive
**Basis:** Polyurethane
**Specific gravity:** approx. 1,04 g/cm³

**Viscosity (on the day of production)**
**-Brookfield HBTD 10 rpm (mPa.s):**
120 °C: 60,000 ± 15,000 mPa.s
140 °C: 35,000 ± 10,000 mPa.s
160 °C: 20,000 ± 5,000 mPa.s

**Identification**
Identification required according to 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 702.8.08 is available in tightly closed metal containers suitable for platen melters. The package should only be open immediately before use.

The melting equipment must 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 chromatised aluminium profiles must be preheated to approx. 40ºC immediately before bonding. The chrome coating must not be older then 4 weeks.

Application temperature:
from 140° C to 160° C.
(veneer and resign paper can have higher application temperatures)

The required coat weight depends on the material:
- PVC-Foil 40- 60 g/m²
- Decor papers (incl. CPL-Material and thick papers ) 50- 70 g/m²
- Veneers 80-120 g/m²

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.

## Application equipment
- Cartridge guns for manual use
- Tank melter with nitrogen blanket
- Platen melter for 20 and 200 litre barrels





**KLEIBERIT SE & Co. KG**, Max-Becker-Str. 4, 76356 Weingarten/Germany
Phone: +49 7244 62-0, Fax: +49 7244 700-0
Email: info@kleiberit.com, **www.kleiberit.com**

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## Cleaning
After finishing work with KLEIBERIT 702.8.08 empty the content from the application equipment and drain off any remaining adhesive. Place the EVA Cleaner KLEIBERIT 761.7 immediately afterward into the equipment, melt and purge through, until all traces of the PUR hotmelts have gone.
Cross linked PUR adhesive can only be removed mechanically.

## Packaging
**KLEIBERIT 702.8.08:**
Fiber drum with aluminium bag, 20 kg net
Metal drum, 190 kg net

**Cleaner**
**KLEIBERIT 761.7:**
Metal drum, 15 kg net

Additional packaging sizes available upon request.

## Storage
KLEIBERIT 702.8.08 can be stored in un-opened factory sealed packages:
Fiber drum with aluminum bag, approx. 12 months
Drum, approx. 12 months

Protect from humidity!

Version 14/10/24 ga; replaces previous version



**Adhesives and Waste Disposal**

**Waste code 080409**
**080410 – Adhesives 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.



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