

KLEIBERIT 702.8.09

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

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

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

The required coat weight depends on the material:

- | | |
|---|-------------------------|
| - 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 |

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

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Cleaning

After finishing work with KLEIBERIT 702.8.09 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 702.8.09:

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 702.8.09 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 28/05/2019 xv

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.

Restricted to professional users

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