

KLEIBERIT 703.3.50 ME

Reactive hotmelt based on polyurethane (PUR) for automotive interiors

Fields of application

- Door panelling; e. g. bonding retainers and clips
- Highly resistant assembly bonding
- Laminating cloth/carpet or PVC foils to wood based materials or plastic substrates

Advantages

- High green and creep strength
- Low melting and reactivity temperature
- Good adhesion to many plastics (e. g. ABS), wood, wood fibre boards, aluminium
- No stringing
- Good bead stability on slanted surfaces

Properties of the bond

- Extremely high joint strength after curing
- Excellent resistance to heat, to more than 120°C (depending upon the material used)
- Cold resistant down to -40°C (depending upon the material used)

Properties of the adhesive

Base: polyurethane
Density: approx. 1.1 g/cm³
Color: 00 whitish

Viscosity (on the day of production)

-Brookfield HBTD 10 Upm:
 at 120°C: 30,000 ± 6,000 mPa s
 at 140°C: 15,000 ± 3,000 mPa s

Identification: see our safety data sheet

ME-product (micro-emission): MDI <0,1%

Attention:

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, harmful decomposition products can develop. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

Application techniques

Clip bonding:

KLEIBERIT 703.3.50 ME is supplied in factory sealed metal containers suitable for use in melting devices. The hotmelt applicators should be designed to protect the hotmelt from being directly exposed to humidity.

Recommended contact temperature 60 - 120 °C. Special care is to be taken for precise temperature control of the equipment, (record start operation data of the machine).

The adhesive is usually applied to the substrate with nozzles from cartridges or robots.

The application temperature ranges between 120-140°C in the tank, 120 °C to 160 °C in the hose and nozzle - depending on the application.

The creep strength depends on material and glue quantity applied and begins at 30 seconds upwards. Cross-linking of the adhesive film occurs within 1-3 days, depending on the humidity supply.

Assembly bonding:

KLEIBERIT 703.3.50 ME is applied with a hand applicator from a cartridge (smallest packing size), or for higher quantities from 2 kg and 18 kg pouch packs, 18 kg or 200 kg metal drums. Appropriate melting systems are required. It is also possible to apply the adhesive with the swirl-spray method (Foam-Melt®)

FoamMelt® is a registered trademark of Nordson Corporation

Cloth and foil lamination to wood and plastic substrates:

KLEIBERIT 703.3.50 ME can be applied by application rollers, spray nozzles or other nozzles onto wood or foil materials. The application temperature is from 120 °C to 160 °C. After the adhesive has been activated (infra-red light), lamination is carried out in a form press or in a vacuum press.

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Application temperature: 120-140°C tank
120-160°C hose and nozzle

Open time:

up to 30 seconds for a bead thickness of 2 mm on chipboard.

The open time is influenced by substrates, working temperature, temperature of material, as well as the method of application (swirl-sprayed or not)

Pressing time:

from 3 seconds onwards

The better the heat dissipation, the shorter the pressing time. Application devices

- Cartridge pistol for manual application
- Melting tanks with nitrogen protection, also with foaming capabilities
- Bulk melters for 20 and 200 litre drums

Storage

KLEIBERIT 703.3.50 ME can be stored in factory sealed containers for approx. 12 months

Protect from humidity!

Version 19.04.22 ga

Cleaning

When having finished work with KLEIBERIT 703.3.50 ME, empty the applicator, draw off the residual hotmelt and insert KLEIBERIT 761.7, melt the cleaning compound and flush until the last residues of PUR hotmelt have been removed. Cured hotmelt can only be removed mechanically.

Packaging

KLEIBERIT 703.3.50 ME:

carton with 12 cartridges at 300 g net each
carton with 4 aluminium bags in fiber drums at 2 kg net each
aluminium bag in fiber drum, 18 kg net
metal drum, 200 kg net

KLEIBERIT 761.7:

carton with 12 cartridges at 250 g net each
carton with 6 bags at 1.5 kg net each
metal drum, 15 kg net

Additional packaging sizes available upon request.

Adhesive and Waste Disposal

Waste Code 080409
080410 - adhesive 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.