

KLEIBERIT 704.1.09

Reactive PUR Hotmelt Adhesive

Fields of application

- Wrapping PVC profiles, yellow chromatised aluminium profiles and wood based profiles with PVC foils, decorative papers and veneers (also fleece laminated)

Advantages

- Suitable for outdoor applications
- Very high initial tack
- Very quick setting properties
- Heat resistance of more than 150°C (according to the material used)
- Low temperature resistance, less than -40°C (according to the material used)
- Resistant to steam and boiling
- For application control set up fluorescent

Because of the variety of PVC profiles, preliminary tests should be done.

Properties of the adhesive

Base: polyurethane
Specific gravity: approx. 1.1 g/cm³

Viscosity (on the day of production)

Brookfield HBTD 10 rpm

at 120 °C: 25.000 ± 5.000 mPa s
 at 140 °C: 16.000 ± 3.000 mPa s

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

Hot melt adhesives release vapours, even if the prescribed working temperature is observed. Consequently, unpleasant odours can occur. If the indicated working temperatures are exceeded for a longer period of time, harmful decomposition products can develop. Therefore, measures for the elimination of the vapours have to be taken, i.e. by means of a suitable ventilation/ exhaust device.

Application techniques

KLEIBERIT 704.1.09 is available in tightly fitting metal containers, suited for melting systems.

The application aggregate for the hot melt adhesive should protect the adhesive from any humidity.

Pay particular attention to a precise temperature control of the entire unit. (Inspect first run and record result.)

The adhesive is applied to the back of the foil or the veneer section by a roller, doctor blade or slot nozzle.

Application temperature: 110 - 140 °C

Application quantity:

PVC foil	30 - 50 g/m ²
decorative papers	50 - 70 g/m ²
veneers	80 - 100 g/m ²

Rate of feed: from 20 m/min

The rate of feed is dependent upon the materials used and the shape of the profile and starts from 20 m/min.

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

The final strength is achieved after approx. 7 days.

For priming PVC window profiles the following primers are available:

KLEIBERIT 831 - based on artificial resin, dissolved in solvent

KLEIBERIT 840 - aqueous polymer

KLEIBERIT 848 - based on artificial resin, dissolved in solvent mixture

The primer dry fairly quickly. The primer application - a very thin film - is performed by a continuous system in the primer station of the wrapping machine.

The drying process takes place in front of the wrapping zone and may be supported by hot air blowers, infrared lamps, ceramic radiators, etc.

When using yellow chromatised aluminium, the chromated surface itself may be not more than 4 weeks old.

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The surface of the PVC or aluminium section must be warmed to 40 °C immediately before the wrapping process is started.

Special notes on PVC window profiles

Wait two weeks after wrapping before performing weatherproofing tests or a glycerine test (5 minutes in a bath of glycerine heated to 130 °C) (see also the special processing guide)

Application devices

- cartridge pistols for manual use
- bulk melting systems with a carbon-dioxide blanket
- barrel melter

Cleaning

After finishing work with KLEIBERIT 704.1.09 empty contents of aggregate or drain off the remaining adhesive. Use EVA hot melt - KLEIBERIT Cleaner SM 761.7 feed immediately, melt and rinse the emptied aggregate, until all traces of KLEIBERIT 704.1.09 have been removed. Cross-linked hot melt adhesive can only be removed mechanically.

Packaging

KLEIBERIT 704.1.09:

- cartons with 6 pouch packs of 2 kg net each
- Pouch bags, 20 kg net

Cleaner

KLEIBERIT 761.7:

- cartons with 12 cartridges of 250 g net each
- cartons with 6 bags 1.5 kg net each
- steel pails with 15 kg net

Storage

KLEIBERIT 704.1.09 can be stored in factory sealed containers for approx. 12 months.

Protect from humidity!

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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.