

KLEIBERIT 705.7

Reactive PUR-Hotmelt Adhesive

Fields of Application

- Two-layer parquet manufacture in continuous production
- Good adhesion to various materials, such as polystyrene, wood, wood material, PVC, aluminium and metal plate (pre-treatment necessary according to the material used)
- For highly stressed assembly bonding

Advantages

- Following cross-linking, a highly heat-resistant, watertight, extremely cold-resistant and highly stressed bond is attained
- Very good ageing resistance
- No stringing

Properties of the Adhesive

Base: polyurethylene

Density: approx. 1.1 g/cm³

Viscosity: (on the day of production)

Brookfield HBTD 10 rpm:

at 120°C: approx. 60.000 ± 15.000 mPa·s

at 140°C: approx. 45.000 ± 10.000 mPa·s

Identification: refer to our safety data sheet

Note: Intended for industrial use only

Even when the prescribed working temperatures are observed, hot melt adhesives release vapours which can often cause unpleasant odours. If the working temperature shown is considerably exceeded for an extended period of time, harmful decomposition products can develop. Therefore suitable measures for the elimination of vapours must be taken, e.g. a suitable extraction ventilator.

Application

The adhesive is applied in bead form to the reverse side of the surface layer, or to the upper surface of the supporting layer. This is performed by passing several surface layers or supporting layers through an application plant, which is fitted with a battery of nozzles arranged to evenly spray the adhesive.

Application temperature: 130 – 150 °C

A lifting device fitted with suction pads lifts a layer sheet, swings it through a 90 ° angle and places it onto the corresponding sheet, which has already been coated with adhesive. The two layers are bonded together and transported further to a pressing plant which operates as soon as it is loaded. This cycle requires only a few seconds. In a rotational plant, several presses are arranged together, and according to the order in which pressing is performed the press time required per item is 15 -30 seconds. Once the pressing cycle is complete, the plant releases the finished parquet, which is removed on a conveyor belt to a stacking plant where it is automatically stacked.

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

The cross-linking reaction of the PUR adhesive takes place within 24 and 72 hours, depending on the room conditions and the humidity available in the wood.

Processing of the bonded parts is possible after cross-linking.

Application Methods

- Hand cartridge pistol for manual application
- Melting tanks with a nitrogen blanket
- Bulk melter systems for 20 and 200 litre drums
- Sealed roller systems, nozzle and slot nozzle application machines

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Cleaning

Following completion of the work with KLEIBERIT 705.7 either run the application plant until empty or drain off the remaining contents. Immediately afterwards apply melted KLEIBERIT 761.7, until the PUR Hotmelt Adhesive is completely removed without traces remaining. Hot melt adhesive which has already cross-linked can only be removed mechanically.

Small parts such as application nozzles, modules, etc., which bear traces of hardened PUR can be boiled in KLEIBERIT 826.0 and cleaned (see our technical data sheet).

Packaging

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Pouch packs, 20 kg net
 Drum, 50kg net
 Drum, 190kg net

Cleaning Agent

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Carton with 12 Alu cartridges, 0.25 kg net
 Carton with 6 foil pouches, 1.5 kg net
 Metal bucket, 15 kg net
 Bag, 20 kg net
 Drum, 150kg net

Cleaner

KLEIBERIT 826.0

Metal canister, 4.5 kg net
 Metal can, 32 kg net
 Metal drum, 215 kg net

Storage

KLEIBERIT 705.7 can be stored in unopened original factory containers for approx. 12 months.
 Protect from moisture!

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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 any obligation.