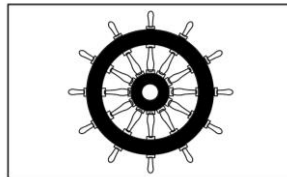


KLEIBERIT 706.1.50 ME

Reactive PUR Hotmelt Adhesive

Fields of application

- Surface laminating
- Good adhesion to various materials, such as wood, wood based material, PMMA, PC, GRP, aluminum and metal plate (dependent upon the material used, pre-treatment could be necessary)
- The long open time allows large surfaces areas to be bonded
- Bonding in shipbuilding
KLEIBERIT 706.1.50 ME corresponds to IMO FTP-Code part 5 approval according to test certificate BG Verkehr (Ship Safety Department) for international use according to module B)



Approval number:
118493-01
Certified application quantity: 100 g / m²

Advantages

- Very high green strength
- Following cross-linking, a highly warmth-resistant, watertight and extremely cold-resistant bond is attained

Properties of the adhesive

Base: polyurethane
Specific weight: approx. 1.1 g/cm³
Viscosity (on the day of production)
Brookfield HBTD 10 rpm:
 at 120 °C 18,000 ± 4,000 mPa s
 at 140 °C 9,000 ± 2,000 mPa s

Identification: see our safety data sheet

- ME Product (micro emission)
residual monomer content < 0,1 %

Attention

When hotmelt adhesives are melted and applied, vapors are set free and an unpleasant odor 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 vapors, e.g. by using a suitable ventilation system.

Application techniques

In order to bond large surface areas with KLEIBERIT 706.1.50 ME a melting plant can be used with a roller-application plant, suitable for PUR hotmelt adhesives.

Climatize substrate to room temp. before processing. The following parameters are the minimum requirements for processing:

Room climate: from 20°C/40% RH
 Substrate temp: from 20°C
 Adhesive application temp: 120 – 130°C
 Adhesive application qty:
 from 80 g/m² for laminate
 from 50 g/m² for foils

Open time under named conditions: up to 8 minutes

In general, the optimal conditions for the respective applications must be determined on-site by the user with preliminary testing, documentation and continuous control.

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

Application devices

- Tank device with a nitrogen blanket
- Barrel melting plant for 20 liter containers
- Suitable roller-application plant

KLEIBERIT 706.1.50 ME

Cleaning

Following completion of the work with KLEIBERIT 706.1.50 ME either run the application empty or drain off the remaining contents. Immediately afterwards apply melted Cleaning Agent KLEIBERIT 761.8 and reverse the direction of the rollers until the last traces of PUR hotmelt have been removed. Hotmelt adhesive which has already cross-linked can only be removed mechanically.

Packaging

KLEIBERIT 706.1.50 ME

aluminum bag in fiber drums, 20 kg
metal drum, 200 kg net

Cleaning Agent

KLEIBERIT 761.8:

plastic pail, 20.0 kg net
fiber drum, 136 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 706.1.50 ME can be stored in factory sealed containers for approx. 12 months

Protect from humidity!

Version 02.12.22 lz; replaces previous version

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 obligation.