

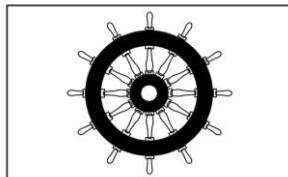
KLEIBERIT 706.1

Reactive PUR Hotmelt Adhesive

Fields of application

- General surface lamination
- Bonding in Shipbuilding

KLEIBERIT 706.1
complies with IMO
FTP-Code Part 5
& Part 2. Approval
according to test
certificate BG Verkehr
(department maritime
safety)



for international use according to Module B)

Approval no.: 118387-03

Certified application quantity: 85 g/m²

Advantages

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

Properties of the adhesive

Base: polyurethane
Specific weight: approx. 1.1 g/cm³
Colour: yellowish

Viscosity (on the day of production)

Brookfield HBTD 10 rpm:

at 120°C 12,000 ± 3,000 mPa s

at 140°C 6,000 ± 2,000 mPa s

Identification: see our safety data sheet

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

For surface lamination, KLEIBERIT 706.1 is processed with melting equipment and application systems suitable for PUR hotmelt adhesives, such as roller coater application units. Alternatively, nozzle application systems or spray application systems can be used. The user is responsible for checking and ensuring the respective suitability.

Climatise 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. for laminates: from 80 g/m²

Adhesive application qty. for foils: from 50 g/m²

Open time under named conditions: up to 4 minutes

Chemical cross linking of PUR hotmelts requires moisture. Therefore sufficient air humidity has to be present during processing. Preferably, at least one of the materials to be bonded should also have a sufficiently high permeability for humidity. Depending on the moisture supply, the chemical crosslinking process is completed within a few days. For the climate mentioned above, this is the case after about 3-4 days.

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

KLEIBERIT 706.1

Cleaning

Following completion of the work with KLEIBERIT 706.1, 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:

Carton with 4 pouch packs at 1.8 kg each net
Carton with 12 cartridges at 300 g net each
Metal pail, 18.0 kg net
Metal drum, 50 kg net
Metal drum, 190 kg net

Cleaning Agent

KLEIBERIT 761.8:

Plastic pail, 20.0 kg net
Fibre drum, 136.0 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 706.1 can be stored in factory sealed containers for approx. 12 months

Protect from humidity!

Version 24/08/2023 lz; replaces previous versions

Adhesive and Waste Disposal

Waste Code 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.

Restricted to professional users

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