

KLEIBERIT 706.7

Reactive PUR-hotmelt

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

Advantages

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

Properties of the adhesive

Base:	polyurethane
Specific weight:	approx. 1.1 g/cm ³
Viscosity (on the day of production)	
Brookfield HBTD 10 rpm:	
at 120° C	20,000 ± 4,000 mPa s
at 140° C	9,000 ± 2,000 mPa s
Identification:	identification required according to the German hazardous substances regulations GefStoffV; contains diphenylmethane-4,4'-diisocyanate, (see our safety data sheet)

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 706.7 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 5 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

Cleaning

Following completion of the work with KLEIBERIT 706.7 either run the application empty or drain off the remaining contents. Immediately afterwards apply melted 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.

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Packaging

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carton with 12 cartridges at 300 g net each
carton with 4 aluminum bags in fiber drums at 2 kg
net each
metal pail, 18 kg net

KLEIBERIT 761.8:

plastic pail, 20.0 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 706.7 can be stored in factory sealed
containers as follows:

aluminum bag in fiber drum (2 kg), approx. 12
months
cartridge, approx. 12 months
metal pail, approx. 12 months

Protect from humidity!

Version 11/10/21 ga; replaces previous versions

Waste Disposal

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.