

KLEIBERIT 707.9.54 ME

Reactive PUR Hotmelt

Field of application

Edging of panel materials with:

- ABS, PMMA, PVC and PP edgebands (with suitable bonding agent)
- CPL and HPL edgebands (adhesion promoter may be required)
- Paper edgebands
- Veneer and solid wood edges

Advantage

- Suitable for BAZ
- Heat resistance edge-dependent up to 140°C
- Cold resistance up to 30°C
- Excellent bond strength even when exposed to steam

Properties of the adhesive

Basis:	Polyurethane
Density:	approx. 1.1 g/cm ³

Viscosity (day of production)

- Brookfield HBTD 10 Upm: at 120 °C: 120,000 ± 25,000 ·mPa·s at 140 °C: 75,000 ± 15,000 ·mPa·s

Identification: see our safety data sheet

-ME product (Micro-Emission) Residual monomer content < 0.1%

Hotmelt adhesives release vapours, even if the described working temperature is being observed. When hotmelt adhesives are molten and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working observed. temperature has been lf the recommended working temperature is exceeded over a longer period of time, there is a danger of decomposition products forming which are harmful. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

Application techniques

PUR Hotmelts react with humidity, even from the air.

KLEIBERIT 707.9.54 ME is distributed in tightly sealed metal containers suitable for the melting units.

Open and unwrap the PUR Hotmelt only immediately before processing.

The Hotmelt Adhesive application unit should be set up in a way that the Hotmelt Adhesive is protected from exposure to humidity.

Special attention to be paid to precise temperature control of the overall system.

The substrates should be freshly cut at right angles and should be free from dust. Boards and edge material have to be tempered to room temperature. Maintain room temperature of at least 18°C, avoid draughts.

Application

The adhesive application temperature (roller) is normally 140 °C

The adhesive application quantity is in principle depending upon the surface structure of the substrates to be bonded.

As an indicator for MDF stands 140 g/m².

The usual feed rate range is between 8 and 40 m/min.

Reduce the temperature to approx. 100°C during work breaks.

Particular attention should be paid to the accurate temperature control when bonding HPL and solid wood edges. Work at the upper temperatures when bond and thick substrates. Low temperature reduces the wetting of the edges. Coat weight and pressures should be adjusted so that the applied adhesive pearls are slightly pressed out at the edges. Effective pressing out can be checked with a transparent test edge.

Reactive PUR hotmelts have a slightly lower green strength compared to EVA hotmelts. Therefore:

Restricted to professional users



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- Only use recently prepared solid wood edges, with perfect fit. Curved edges are not suitable
- Ensure that the base substrate has perfect edges too.
- PUR hotmelt adhesives, compared to EVA hotmelt adhesives, achieve significantly closer joints.
- Thick PVC edges in rolls have to be treated with care as they are under high tension.
- Ensure that the press roller apply maximum pressure.

The green strength ensures that the product is durable and has a close joint and allows for further processing, such a flush milling of the edges. Chemical cross linking of PUR hotmelts requires moisture. Therefore sufficient air humidity has to be present during processing.

The cross linking of the product, depending on the humidity will occur in 1-2 days.

The final strength is reached after 7 days.

Cleaning

After finishing work with KLEIBERIT 707.9.54 ME empty the content of the melting vessel and drain of the remaining adhesive in the system. Immediately afterwards use Cleaner KLEIBERIT 761.7, melt the cleaner and then allow the cleaner to push the remaining PUR hotmelt out of the system until all PUR hotmelt has been removed. Cross linked PUR hotmelt can only be removed mechanically.

Packaging

KLEIBERIT 707.9.54 ME:

Carton with 12 aluminium cartridges, 0.3 kg net each Carton with 18 bags, 0.4 kg net each Carton with 6 aluminum bags in fiber drums, 2.0 kg net each Metal drum, 200 kg

Cleaner

KLEIBERIT 761.7: Carton with 12 aluminium cartridges, 0.25 kg net each Carton with 6 aluminum bags in fiber drums, 1.5 kg net each Carton with 6 bags, 0.22 kg net each Metal pail, 15.0 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 707.9.54 ME is dispatched in tightly sealed packaging. A temperature controlled transport is not necessary.

The product can be stored in factory sealed packaging between 0 °C und 35 °C for approx. 12 months

Protect from humidity!

Version 08/05/2025 lz; replaces previous version

Klebstoff- und Gebinde-Entsorgung

Abfallschlüssel

080409 080410 – Klebstoff vollständig ausreagiert

Unsere Gebinde sind aus recyclingfähigem Material. Gut entleerte Gebinde können der Wiederverwertung zugeführt werden.

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Service

Unser anwendungstechnischer Beratungsdienst steht Ihnen jederzeit zur Verfügung. Unsere Angaben beruhen auf unseren bisherigen Erfahrungen und sind keine Eigenschaftszusicherungen im Sinne der BGH-Rechtsprechung. Prüfen Sie selbst, ob sich unser Produkt für Ihre Zwecke eignet. Eine Haftung, die über den Wert unseres Produktes hinausgeht, kann aus den vorliegenden Ausführungen nicht hergeleitet werden, auch nicht aus der Inanspruchnahme unseres kostenlos und unverbindlich zur Verfügung gestellten Beratungsdienstes.