

KLEIBERIT 707.9

Reactive hotmelt adhesive in cartridges for highly durable edge bonds

Field of application

- Solid wood edges
- HPL edges in strips
- PVC edges, extruded/calandered, as strips or rolls (primed)
- Veneer edges
- Duroplastic and thermoplastic edges in rolls

Advantage

- Heat resistance up to +150°C
- Cold resistance up to - 30°C
- Excellent bond strength even when exposed to steam

Properties of the adhesive

Basis: Polyurethane
Specific gravity: approx. 1.3 g/cm³
Color: 00 ivory
 10 white

Viscosity (day of production)

- Brookfield HBTD 10 rpm:

at 140°C: 80,000 ± 20,000 mPa·s

at 160°C: 45,000 ± 10,000 mPa·s

Identification: identification required according to EU regulations; contains diphenylmethane – 4,4 diisocyanate (see our safety data sheet)

Note: Intended for commercial use only.

Hotmelt adhesives release vapors, even if the described working temperature is being observed. When hotmelt adhesives are molten and applied, vapors are set free and an unpleasant odor can occur, even if the recommended working temperature has been observed.

If 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 vapors, e.g. by using a suitable ventilation system.

Application techniques

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

Processing temperature: 130 - 150°C

Time required for heating up the cartridge:

Depending on the heating capacity 2-10 minutes

During work pauses reduce the temperature to 100°C. Temperature control is of utmost importance when bonding HPL and solid wood edges. Long and thick work pieces need to be processed in the upper temperature range. Low temperatures reduce the wetting of the edges. Application quantity and pressure have to be adjusted in such a way that the application glue lines are crushed and the adhesive slightly pearls out on the margins. This can be easily checked by using a transparent test edge.

Reactive polyurethane hotmelts have a slightly lower initial strength compared to usual EVA hotmelts. Therefore consider the following:

- Use only recently sawed solid wood edges with good fit. Curved or twisted edges are unsuitable.
- Work precisely when preparing the substrate edges.
- PUR hotmelts allow considerably tighter joints compared to EVA hotmelts.
- Proceed very cautiously with thick PVC-edges in roll form due to deformation.
- Pay attention to a maximum roll pressure.

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Special recommendations for processing:

Separate instructions for an immediately glue system change from PUR to eg. EVA and back are available. These must be considered.

General recommendations

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

Cross-linking of the adhesive film takes approx. 1 - 2 days, depending on humidity. Final bond strengths are reached after approx. 7 days.

Packaging

KLEIBERIT 707.9:

Carton with 6 aluminum cans at 1.56 kg net each

Cleaner

KLEIBERIT 761.0:

Carton with 6 aluminum cans at 1.2 kg net each

Additional packaging sizes available upon request.

Storage

KLEIBERIT 707.9 can be stored in factory sealed packaging for approx. 12 months.

Protect from humidity!

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Klebstoff- und Gebinde-Entsorgung

Abfallschlüssel 080409

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

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.