KLEIBERIT 707.9

Reactive PUR Hotmelt

Field of application
Edging of carrier panels with:
- 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
- All of the raw materials used meet the Directive 2002/72/EG for products intended to come into contact with food.

Properties of the adhesive
Basis: Polyurethane
Specific gravity: approx. 1.3 g/cm³
Colour: 00 ivory
10 white
12 vanilla

Viscosity (day of production)
- Brookfield HBTD 10 Upm:
at 120°C: 160.000 ± 50.000 mPa·mPa·s
at 140°C: 80.000 ± 20.000 mPa·mPa·s
at 160°C: 45.000 ± 10.000 mPa·s

Identification: identification required according to EU regulations; contains diphenylmethane – 4,4 diisocyante
(see our safety data sheet)
Note: Intended for commercial use only

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 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 vapours, e.g. by using a suitable ventilation system.

Application techniques
PUR Hotmelts react with humidity, even from the air.
KLEIBERIT 707.9 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.
The following information is based on experience and is to be understood as an indication. Due to the large number of different materials and technical process parameters of the respective user, the values mentioned may vary within a certain range. If necessary, they must be adjusted accordingly by the user and checked for suitability on his own responsibility.

Application
The adhesive application temperature (roller) is normally between 120 – 160 °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:

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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 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:
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
Aluminum bag in fiber drum, 18.0 kg
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 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 13/07/2020 lz; replaces previous versions

Adhesives and Waste Disposal

Waste code adhesive 080409
080410 – Adhesive fully cured

Our containers are made of recyclable material. Well drained containers can be recycled.

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.

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