

# KLEIBERIT 708.0

## Reactive PUR Hotmelt Adhesive

### Fields of application

- Wrapping PVC profiles and yellow-passivated Aluminium with PVC foils

### Advantages

- Very high green strength
- Very good setting properties
- Heat resistance to 150° C (according to the material used)
- Cold resistance down to -40° C

Due to the different types of PVC used for the profiles, preliminary tests are necessary.

### Properties of the adhesive

<b>Base:</b>	polyurethane
<b>Specific weight:</b>	approx. 1.15 g/cm <sup>3</sup>
<b>Viscosity</b> (on the day of production)	
<b>Brookfield HBTD 10 rpm:</b>	
at 120° C	32,000 ± 5,000 mPa·s
at 140° C	17,000 ± 3,000 mPa·s

**Identification:** see our safety data sheet

**Important Note:** only designated for industrial applications

When hot melt 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

### Profile wrapping

KLEIBERIT 708.0 supplied in tightly closed containers suitable for use in melting units. The hot melt application aggregate should be designed to protect the hot melt from being directly exposed to humidity. Special care is to be taken of precise temperature control of the equipment (record start data of the machine).

The adhesive is applied by means of a roll or nozzle system, or with a coating knife, to the reverse side of the foils and veneers.

**Application temperature:** 120 – 140 °C

### Consumption:

PVC foils	30 - 50 g/m <sup>2</sup>
decorative papers	50 - 70 g/m <sup>2</sup>
veneers	80 - 100 g/m <sup>2</sup>

**Line speed:** 5 - 40 m/min

The rate of feed is dependent upon the materials used and the shape of the profile.

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

Cross-linking of the adhesive film takes place within 1-2 days depending on the moisture available.

For priming PVC window profiles, the following types of primer are available:

Primer KLEIBERIT 831.0 – based on artificial resin, dissolved in solvent  
 Primer KLEIBERIT 848 – based on artificial resin, dissolved in solvent mixture

The primer dries fairly quickly. The primer application - a very thin film - is performed by a continuous system in the primer station of the wrapping machine. To reduce the risk of insufficient priming, the primer can be applied in a double priming station.

The drying process may be supported by heating devices such as hot air blowers, infrared lamps, ceramic heaters, etc.

## KLEIBERIT VP 708.0

### Application devices

- Manual cartridge applicators
- Melting tanks with nitrogen induction blanket
- Bulk melters

### Cleaning

After finishing work with KLEIBERIT 708.0 empty the applicator or draw off the remaining hot melt. Immediately insert EVA hot melt Cleaning Compound - KLEIBERIT 761.7 - melt and discharge until the last residues of PUR hot melt have been removed. Cured hot melt can only be removed mechanically.

### Packaging

**KLEIBERIT 708.0:**  
pail, 18 kg net

### Cleaning Compound

**KLEIBERIT 761.7:**  
carton with 6 bags, 1.50 kg net  
metal pail, 15 kg net

Additional packaging on request

### Storage

KLEIBERIT 708.0 can be stored in factory sealed containers approx. 12 months

Protect from humidity!

Version 18/02/2022 ga; replaces previous versions

#### Disposal of containers and contents

Waste disposal key **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.