Reactive PUR Hotmelt 709.1

Reactive hotmelt based on polyurethane (PUR) for flat lamination

Fields of application

- Flat lamination
- Bonding aluminium and metals to wood based materials
- Good adhesion to various materials, such as wood, wood material, PMMA, PC, GRP, ABS, aluminium, steel (dependant upon the material used, pre-treatment could be necessary)
- The long open time allows large surface areas to be bonded
- One of the materials to be bonded must be permeable

Advantages

- Following cross-linking, a highly heat-resistant, watertight, extremely cold resistant and durable bond is attained
- Long open time
- High green strength

Properties of the adhesive

Base: polyurethane
Specific weight: approx. 1.1 g/cm³
Viscosity (on the day of production**)**
Brookfield HBTD 10 rpm:
at 120° C 10,000 ± 2,000 mPa s
at 140° C 5,000 ± 1,500 mPa s

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

Attention
When hotmelt 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

For flat lamination, KLEIBERIT PUR Hotmelt 709.1 is processed with melting equipment (suitable for PUR hotmelt adhesives) on a roller coater application unit.

Climatise 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 4 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 and 200 litre containers
- Suitable roller-application plant

Cleaning

Following completion of the work with KLEIBERIT PUR Hotmelt 709.1, either run the application empty or drain off the remaining contents. Immediately afterwards apply melted KLEIBERIT Cleaning Agent 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

KLEIBERIT 709.1:
Carton with 4 fiber drums with aluminium bags at 2 kg net each
Metal drum, 190 kg net

KLEIBERIT Cleaning Agent 761.8:
Plastic pail, 20.0 kg net
Fibre drum, 136.0 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 709.1 can be stored in factory sealed containers as follows:
Fiber drums with aluminium bags, approx. 12 months
Drum, approx. 12 months

Protect from humidity!

Version KH 0213; 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.

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