

# Reactive PUR Hotmelt 709.3

**Reactive hotmelt based on polyurethane (PUR) for surface lamination of high gloss materials.**

## Fields of application

- Surface lamination
- Good adhesion to various materials, such as polystyrene, wood, plaster, woven material, wood material, PVC, aluminium and metal plate (dependant upon the material used, pre-treatment could be necessary)
- Suitable for bonding thin high gloss foils (thickness < 0.7 mm)

## Advantages

- Following cross-linking, a highly warmth-resistant, watertight and extremely cold-resistant bond is attained
- Low processing temperature
- Long open time
- Homogeneous application properties
- High roller stability

## Properties of the adhesive

<b>Base:</b>	polyurethane
<b>Specific weight:</b>	approx. 1.1 g/cm <sup>3</sup>
<b>Viscosity</b> (on the day of production)	
<b>Brookfield HBTD 10 rpm:</b>	
at 120° C	8,000 ± 2,000 mPa s
at 140° C	4,000 ± 1,500 mPa s
<b>Identification:</b>	identification required according to the German hazardous substances regulations GefStoffV; 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

In order to bond large surface areas with KLEIBERIT 709.3, a melting plant can be used with a roller-application plant, suitable for PUR hotmelt adhesives.

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/m<sup>2</sup> for laminate  
 from 40-50 g/m<sup>2</sup> for foils (e.g. high gloss foils)

Open time under named conditions: up to 3 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 litre containers
- Suitable roller-application plant

## Cleaning

Following completion of the work with **KLEIBERIT PUR Hotmelt 709.3**, 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 PUR Hotmelt 709.3:**

Carton with 4 pouch packs at 18 kg net each

Pouch pack, 18 kg net

Metal drum, 190 kg net

#### **KLEIBERIT Cleaning Agent 761.8:**

Plastic pail, 20 kg net

Fibre drum, 136 kg net

Additional packaging sizes available upon request.

### Storage

KLEIBERIT PUR Hotmelt 709.3 can be stored in factory sealed containers as follows:

Pouch pack, approx. 12 months

Metal drum, approx. 12 months

Protect from humidity!

EX0211; 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.