

KLEIBERIT 711.3.57 - ME -

Reactive Hotmelt Adhesive

Fields of application

- Surface lamination
- Good adhesion to different materials, such as wood, wood-based materials, PVC

(Depending on the material pretreatment is necessary)

Advantages

- Following cross-linking, a highly heat resistant, water resistant and extremely cold resistant heavy duty bond is attained
- Very high initial 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 12,000 ± 3,000 mPa s

at 140° C 6,000 ± 2,000 mPa s

Identification: see our safety data sheet

– ME-Product (Micro-Emission),

Restmonomergehalt < 0,1 %

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.

Processing

For surface lamination, KLEIBERIT 711.3.57 ME 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:

Application temp: 120 – 130°C

Room climate: from 20°C/40% RH

Adhesive application qty:

from 80 g/m² for laminate

from 50 g/m² for foils

Open time under above mentioned conditions up to 6 mins.

In general, the optimum conditions for the respective application must be determined on site by the user by means of preliminary tests, documented and continuously monitored.

The cross-linking of KLEIBERIT 711.3.57 ME takes 3 - 5 days, depending on temperature, humidity and substrate.

Application devices

- Tank device with nitrogen blanket
- Drum melting systems for 20 and 200 litre drums
- Suitable roller application systems

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Cleaning

Following completion of the work with KLEIBERIT 711.3.57 ME allow the application plant to run dry of adhesive, or drain off the remaining adhesive. Immediately following, apply Cleaning KLEIBERIT 761.8, allow to melt and apply by reversing the direction of the rollers and cleaning surfaces thoroughly until all traces of PUR hotmelt have disappeared.

Deposits of PUR hotmelt which have already cured can only be removed mechanically.

Packaging

KLEIBERIT 711.3.57 ME:

Aluminum bag in fiber drum	20 kg net
Metal drum	190 kg net

Cleaning Agent

KLEIBERIT 761.8:

Plastic pail	20 kg net
Fibre drum	136 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 711.3.57 ME can be stored in factory sealed containers for approx. 12 months
Protect from humidity!

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Disposal of containers and contents

Waste disposal key 080410

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.