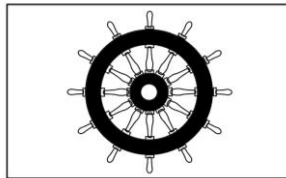


KLEIBERIT 711.3

Reactive PUR-Hotmelt Adhesive

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)
- The long open time allows large surfaces areas to be bonded
- Bonding in shipbuilding (According IMO FTPC Part 5 & Part 2 / Approval per SeeBG test certificate for international use according to Module B)
Registration number 118350-02
Certified ordered quantity:
Max. 115 g/m²



Advantages

- Following cross-linking, a highly warmth-resistant, watertight and extremely cold-resistant bond is attained
- Low processing temperature
- Long open time
- Very high green strength
- excellent suitability for bonding impermeable substrates to each other
- Residual monomer content < 1 %

Properties of the adhesive

Base:	polyurethane
Specific weight:	approx. 1.1 g/cm ³
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

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 711.3**, a melting plant can be used with a roller-application plant, suitable for PUR hot melt adhesives.

Reference value for open time for application on chip boards: 2-3 minutes

for a

Application quantity: 100 g/m²

Application temperature: 120 °C

Room temperature: 20 °C

Chemical cross linking of PUR hot melts 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 unit

Cleaning

Following completion of the work with **KLEIBERIT 711.3**, either run the application empty or drain off the remaining contents. Immediately afterwards apply melted **Cleaning Agent KLEIBERIT 761.8** and reverse the direction of the rollers until the last traces of PUR hot melt have been removed. Hot melt adhesive which has already cross-linked can only be removed mechanically.

KLEIBERIT 711.3

Packaging

KLEIBERIT 711.3:

Carton with 6 aluminum bags in fibre drums	2.0 kg net each
Aluminum bag in fiber drum	18.0 kg net
Drum	190.0 kg net

Cleaning Agent

KLEIBERIT 761.8:

Plastic pail	20.0 kg net
Fibre drum	136.0 kg net

Storage

KLEIBERIT 711.3 can be stored in factory sealed containers for approx. 12 months.

Protect from humidity!

Version 02/03/2023 al, 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.