

# KLEIBERIT 711.9

## Reactive PUR-Hotmelt Adhesive

### Fields of application

- Very good adhesion to wood, wood based materials, foam, polystyrene, HPL, aluminium and metal (dependant upon the material used, pre-treatment could be necessary)
- The long open time allows large surfaces areas to be bonded

### Advantages

- Following cross-linking, a highly heat resistant, watertight, extremely cold resistant and highly durable bond is attained
- Very high green strength
- Excellent flowing properties for roller application
- High resistance to creeping
- Low odour

### Properties of the adhesive

**Base:** polyurethane  
**Specific weight:** approx. 1,1 g/cm<sup>3</sup>

**Viscosity** (on the day of production)

**Brookfield HBTD 10 rpm:**  
 at 160 °C: 8,000 ± 2,000 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 surface lamination, KLEIBERIT 711.9 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 melting temp: 160 – 165 °C  
 Adhesive application temp: 140 – 160 °C  
 Adhesive application qty:  
     from 80 g/m<sup>2</sup> for laminate  
     from 50 g/m<sup>2</sup> for foils

Open time under named conditions:  
 approx. 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 and 200 litre containers
- Suitable roller application systems

### Cleaning

Following completion of the work with KLEIBERIT 711.9, 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 Hotmelt have been removed. Hotmelt adhesive which has already cross-linked can only be removed mechanically.

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## Packaging

### KLEIBERIT 711.9:

aluminium bag in fibre drums at 20 kg net  
metal drum, 190.0 kg

## Cleaning Agent

### KLEIBERIT 761.8:

plastic pail, 20.0 kg net  
fibre drum, 136 kg

Additional packaging sizes available upon request.

## Storage

KLEIBERIT 711.9 can be stored in unopened  
factory sealed containers as follows:  
for approx. 12 months

Protect from humidity!

Version 17/03/2020 ki; replaces previous versions

#### Adhesive and Waste Disposal

##### Waste disposal code 080409

080410 Adhesive fully cured

Our containers are made of recyclable material. Well drained containers can be recycled.

#### 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.