

KLEIBERIT 713.7.84 LE

Reactive PUR-Hotmelt Adhesive

Fields of application

- Laminating of fabric/carpet onto carrier components of wood based materials or plastics (e. g. door panels, roof linings or trunk base plates and for bonding retainers and natural fibre materials)
- Lamination of automotive interior parts

Advantages

- >38% from non-petroleum raw materials
- High green strength
- Heat resistance (depending on the substrate used) up to 150 °C
- Cold resistance (depending on the material used) up to -40 °C
- Fluorescent for application control
- Low content of monomers, MDI < 1,0 %

Due to different formulas of the substrates preliminary tests are necessary

Properties of the adhesive

Base: polyurethane
Density: approx. 1.1 g/cm³

Viscosity (on the day of production)

-Brookfield HBTD 10 rpm:
 at 120 °C: 50,000 ± 10,000 mPa s
 at 140 °C: 25,000 ± 5,000 mPa s

Identification: see our safety data sheet

Note: Only for industrial use

When hotmelt adhesives are melted and applied, vapors are set free and an unpleasant odor 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 vapors, e.g. by using a suitable ventilation system.

Application techniques

Clip bonding:

KLEIBERIT 713.7.84 LE is supplied in factory sealed metal containers suitable for use in melting devices.

The hotmelt applicators should be designed to protect the hotmelt from being directly exposed to humidity.

Special care is to be taken for precise temperature control of the equipment, (record start operation data of the machine).

The adhesive is usually applied to the substrate with nozzles from cartridges or robots.

Application temperature: 120 - 140 °C

Application: depending on the substrate 50 - 120 g/m²

Chemical cross linking of PUR hot melts requires moisture. Therefore sufficient air humidity has to be present during processing.

The post cross-linking reaction of the adhesive film takes place within 3 – 5 days, depending on the humidity available.

Application devices

- Cartridge hand pistol for manual application
- Melting tanks with nitrogen cover
- Bulk melters

Cleaning

When having finished work with KLEIBERIT 713.7.84 LE, empty the applicator, draw off the residual hotmelt and insert cleaning compound KLEIBERIT 761.7, melt the cleaning compound and flush until the last residues of PUR hotmelt have been removed.

When using roller application clean the rollers with cleaning compound KLEIBERIT 761.8.

Cured hotmelt can only be removed mechanically.

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Packaging

KLEIBERIT 713.7.84 LE:

aluminum bag in fiber drum, 2 kg

Cleaning Compound

KLEIBERIT 761.7:

metal bucket, 15 kg net

Cleaning Compound

KLEIBERIT 761.8:

plastic bucket drum, 20 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 713.7.84 LE can be stored in factory sealed containers for approx. 12 months

Protect from humidity!

Version 23.10.23 lz

Adhesive and Waste Disposal

Waste code 080409

080410 – Adhesive reacted completely

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.