

KLEIBERIT 716.4

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

Advantages

- Following cross-linking, a highly heat resistant, watertight, extremely cold resistant and durable bond is attained
- Low processing temperature
- Long open time

Properties of the adhesive

Base: polyurethane

Specific weight: approx. 1.1 g/cm³

Viscosity (on the day of production)

Brookfield HBTD 10 rpm:

at 100° C 6,000 ± 1,500 mPa s

at 120° C 2,500 ± 1,000 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

For surface lamination, KLEIBERIT 716.4 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 application temp: 100 – 130°C

Adhesive application qty:

from 80 g/m² for laminate

from 50 g/m² for foils

Open time under named conditions:
up to 10 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 716.4, 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 716.4:

pouch pack, 20 kg net
metal drum, 200 kg net

Cleaning Agent

KLEIBERIT 761.8:

paper bag, 20.0 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 716.4 can be stored in factory sealed
for approx. 12 months.

Protect from humidity!

Version 26.01.2022 lz; 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.