

Hotmelt Adhesive 724.1

Highly heat resistant adhesive for finishing of motor vehicle interiors

Fields of application

- Bonding foamed plastics and textiles to wood and wood-based materials as well as various plastics in automotive applications

Advantages

- High initial strength
- Very good activation properties
- High initial stickiness with very good wetting properties
- Long open time
- Heat resistance depending on the substrate up to 90°C

Properties of the bond

- Good ageing resistance
- Tough-elastic joint, good bonding strength
- High heat resistance

Properties of the adhesive

Base:	polyolefin
Density:	approx. 0.95 g/cm ³
Colour:	light yellow
Softening point ring and ball:	155 ± 5°C
Viscosity Brookfield HBTD:	
at 180°C	8,000 ± 2,000 mPa s
at 200°C	5,000 ± 1,000 mPa s
Working temperature:	180-200 °C
Identification:	not required according to EU regulations (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 devices

- Hotmelt applicators with heated tank
- Hotmelt applicators with piston or gear pump
- Hand guns

Application techniques

The materials to be bonded must be dry and free from dust and grease.

Acclimatisation to room temperature is necessary.

Metal parts should be pre-heated to 30-40°C.

The adhesive is applied to one surface, preferably to the material which is most difficult to bond. A double-sided contact adhesion is also possible with this foaming adhesive, (longer open time).

Open time:

The open time is dependent on the amount of adhesive applied, the temperature of the material, and the temperature of the room.

Cleaning

With a spatula when hot.

Working tools can be cleaned with KLEIBERIT Cleaner 827.0.

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Packaging

KLEIBERIT HM 724.1:

Carton with 24 cubes at 0.5 kg each

PE bag, 20 kg net

Container, 500 kg net

KLEIBERIT Cleaner 827.0

Metal canister, 4.5 kg net

Additional sizes available upon request.

Storage

KLEIBERIT Hotmelt Adhesive 724.1 can be stored for approx. 2 years at room temp.

Keep in a cool and dry place.

Version XI 0316; 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.