

# KLEIBERIT 725.9

## PO Hotmelt Adhesive

### Fields of application

- Manufacture of filters for motor vehicle interiors

### Advantages

- Good melting characteristics
- Suitable for continual, thread-form and surface application using round and/or slot nozzles
- Processable from 160 °C
- Low fogging value

### Properties of the bond

- Tough-elastic joint, good bond strength
- Good resistance to ageing, no brittleness
- Good temperature resistance

### Properties of the adhesive

<b>Base:</b>	polyolefin
<b>Density:</b>	approx. 0.92 g/cm <sup>3</sup>
<b>Colour:</b>	white
<b>Viscosity</b>	
- <b>Brookfield HBTD:</b>	
	at 160 °C: 40,000 ± 8,000 mPa·s
	at 180 °C: 20,000 ± 5,000 mPa·s
<b>Softening point (ring + ball):</b>	125 ± 5 °C
<b>Open time:</b>	approx. 22 sec at 160 °C on insulating substrates, e.g. filter paper (see "Processing")
<b>Delivery form:</b>	granulate
<b>Identification:</b>	identification is not required according to the EU regulations (See our safety data sheet)

When hot melt 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 methods

- hot-melt adhesive application device fitted with a nozzle application system for processing highly viscous hot-melt adhesives
- mainly using tank devices fitted with a cogwheel pump or a suitable extruder

### Processing

The most favourable processing temperature is from 160 – 180 °C. Processing up to 200 °C is possible.

The adhesive is applied to one side of the substrate only.

The **open time** is dependant upon the thermal conductivity of the substrate, the application temperature and volume of the hot-melt adhesive applied (dot/point, film, bead).

**Measured example:** 2 mm bead diameter, temperature of the hot-melt adhesive immediately after the nozzle 160 °C, substrate = filter paper; **open time 22 sec.**

An air jet mounted after the application nozzle will accelerate the curing process.

### Cleaning

For regular cleaning of the hot-melt adhesive application device, please observe the cleaning instructions provided by the manufacturer of the device.

### Packaging

PE bag, 20 kg net

Additional packaging sizes upon request.

### Storage

KLEIBERIT 725.9 can be stored for approx. 24 months. Keep cool and dry!

Version 07/12/2018 xv; replaces previous versions

## KLEIBERIT 725.9

### **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.