

# KLEIBERIT 728.5

## Pressure Sensitive Hotmelt

### Fields of application

- Assembly bondings of baseboards, covers and decorative mouldings to furniture fronts etc.
- Bonding of covering fabrics to loudspeaker boxes (cabinet construction)
- Bonding of upholstery

### Advantages

- Good adhesion to wood materials, cardboard as well as to many thermoplastic and thermosetting plastics, foam plastics
- Very good thermal stability, no cold flow
- Long permanent tack and long open time

### Properties of the adhesive

<b>Base:</b>	thermoplastic rubber
<b>Specific gravity:</b>	approx. 0.95 g/cm <sup>3</sup>
<b>Color:</b>	brownish-yellow
<b>Viscosity (Haake Rotovisko RV 2):</b>	
at 180° C:	23,000 ± 4,000 mPa·s
at 200° C:	12,000 ± 3,000 mPa·s
<b>Softening point (ring and ball):</b>	115 ± 5° C
<b>Working temperature:</b>	180 - 200 °C

**Identification:** identification not required according to EU regulations (see our safety data sheet)

On melting and applying hot melt adhesives, vapors are set free even when the recommended working temperature has been observed and an unpleasant odor can sometimes occur.

Moreover, there is the danger of forming decomposition products injurious to health if the prescribed working temperature is exceeded considerably for a longer time. Precautions should be taken for eliminating the vapors, i.e. by an appropriate ventilation/exhaust device.

### Application techniques

The adhesive can be applied with roller application units and nozzle application units with pump. The working temperature should be between 180 °C and 200 °C.

The higher the temperature the lower the viscosity of the hot melt adhesive, thus the wetting of the material surface to be bonded is improved.

The application quantity is dependent on the surface quality of the materials and the existing joint tolerance.

Usual consumption: 100-200 g/m<sup>2</sup>

If a long waiting time between application of the adhesive and bonding is desired the film should be covered with silicone paper.

Because of the wide range of silicone paper available, no general recommendation can be made regarding suitability for covering the adhesive film. Individual tests dependent upon later requirements must be performed by the user.

The bonding process must be carried out under pressure in order to guarantee a good wetting of the face to which no adhesive has been applied.

For bonding upholstery with high stresses double-sided application is recommended.

A pressing time of a few seconds is sufficient.

For rigid materials (e.g. decorative mouldings) the pressure should be as high as possible.

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### Cleaning

When cleaning application devices, please observe the manufacturer's instructions.

### Packaging

Carton with 24 cubes, total net weight 13 kg

Carton with 9 cubes, total net weight 14 kg

Additional packaging sizes available upon request.

### Storage

KLEIBERIT 728.5 can be stored under proper storage conditions for approx. 2 years.

Keep in a cool and dry place.

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#### Disposal of containers and contents

Waste disposal key **080410**

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.