

KLEIBERIT 754.1

PO Hotmelt Adhesive

Fields of application

- Direct-post-forming of veneer, multi layer papers and melamine papers
- Bonding of straight edges made of solid wood, paper and melamine edges
- Veneer and plastic edges on CNC machines

Advantages

- Very high green strength
- Depending on the material used, heat resistance up to 140 °C and cold resistance down to - 30 °C are possible.
Due to the variety of the materials that can be used own experiments are recommended.
- Good wetting on paper, veneer and melamine

Properties of the adhesive

Basis:	polyolefin
Specific weight:	approx. 1.17 g/cm ³
Colour:	ivory – 00 White - 10
Softening point (ring and ball):	165 ± 5 °C
Viscosity Brookfield HBTD:	
at 180°C	100,000 ± 20,000 mPa.s
at 200°C	60,000 ± 10,000 mPa.s
Melting index acc. to DIN EN ISO 1133 (MFI/190°C/1,2kg)	150 g ± 30 g/10 minutes
Identification:	identification not required according to EU regulations (see our safety data sheet)

Hotmelt adhesives release vapours, even if the prescribed working temperature is observed. 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, there is a danger of decomposition products forming which are harmful. Precautions must be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

Application machinery

- Edge banding machines
- Direct- post-forming installations
- Application equipment: roller, nozzle
- CNC machines

Application techniques

Application techniques:	
Direct post-forming direct:	190 - 200 °C
Straight edge:	200 - 210 °C
Line speed:	20 m/min

The substrates must be dry, free from dust and acclimatised.

Application Quantity:

The quantity applied should be adjusted in such a way that the adhesive slightly shows on the edge of the part to be glued. In order to check whether the adhesive film is continuously applied, a strip of transparent rigid PVC can be used.

Post-Treatment:

The glued material can be further processed immediately after bonding (sawing, routing, planing etc.)

KLEIBERIT 754.1

Cleaning

With spatula when the glue is still hot.
Tools can be cleaned with KLEIBERIT 827.0.

Packaging

KLEIBERIT 754.1:
Plastic bag, 20.0 kg

Cleaner

KLEIBERIT 827.0:
Metal canister, 4.5 kg

Additional packaging sizes upon request

Storage

KLEIBERIT 754.1 can be stored for approx.
24 months. Keep in a cool and dry place.

Version 08/09/2017 XI; replaces previous versions

Adhesive and Waste Disposal

Waste Code 080410

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.

KLEIBERIT 754.1

Adhesive and Waste Disposal

Waste Code 080410

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.