

KLEIBERIT 756.3

PO-Hotmelt adhesive

Fields of application

- Laminating for automotive interiors
- Laminating fabric/carpet to substrates made of wood based materials or plastics, TPO and PVC foils (i.e. for door coverings, headliners or trunk flooring and for natural fiber material), as well as for PP supporting parts for dashboards

Advantages

- Very high green strength
- Heat resistance to 120°C (according to the material used)
- Cold resistance down to -40°C (according to the material used)

Due to the different types of substrates, preliminary tests are necessary.

Properties of the adhesive

Base:	polyolefin, reactive
Density:	approx. 0.9 g/cm ³
Viscosity (on the day of production)	
Brookfield HBTD 10 rpm:	
at 140°C	14,000 ± 3,000 mPa·s
at 160°C	8,000 ± 2,000 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

Profile wrapping

KLEIBERIT 756.3 is supplied in tightly closed containers suitable for use in melting units. The Hotmelt application aggregate should be designed to protect the Hotmelt from being directly exposed to humidity.

Special care is to be taken of precise temperature control of the equipment (record start data of the machine).

The adhesive is applied by means of a roll or nozzle system to the reverse side of the foils and veneers.

Application temperature: 140 – 160 °C

Consumption:

Depending on substrate 80 – 120 g/m²

Chemical cross linking of POR Hotmelt requires moisture. Therefore sufficient air humidity has to be present during processing.

Cross-linking of the adhesive film takes place within 72 hours and 7 days depending on the moisture available.

Open time

approx. 30 seconds with a bead thickness of 2 mm on chipboard. Other carrier materials, processing temperature, material temperature, or foamed / unfoamed influence the open time

Pressing time: approx. 3 seconds

The better the heat dissipation, the shorter the pressing time can be.

Application devices

- Manual cartridge applicators
- Melting tanks with nitrogen induction blanket
- Drum melters

KLEIBERIT 756.3

Cleaning

After finishing work with KLEIBERIT 756.3 empty the applicator or draw off the remaining Hotmelt. Immediately insert EVA Hotmelt - KLEIBERIT Cleaning Compound HM 761.7 - melt and discharge until the last residues of POR Hotmelt have been removed.

Cured Hotmelt can only be removed mechanically.

Small parts that are cross linked with cured POR, like e.g. applicator nozzles, modules, etc., can be boiled in Cleaner KLEIBERIT 826.0 and cleaned (see technical data sheet 826.0)

Packaging

KLEIBERIT 756.3:

carton with 6 fiber drums with aluminium bags, 1.5 kg net each
fiber drum with aluminium bag, 15 kg net
metal drum, approx. 150 kg net

Cleaning Compound

KLEIBERIT 761.7:

carton with 12 cartridges at 0.250 kg net each
carton with 6 bags at 1.50 kg net
metal pail, 15 kg net

Cleaning Compound

KLEIBERIT 761.8:

plastic pail, 20 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 756.3 can be stored in factory sealed containers as follows:
approx. 12 months

Protect from humidity!

Version 19/03/2020 ki; replaces previous versions

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.