

Hotmelt Adhesive 771.2

Thermoplastic synthetic resin adhesive for edge banding with low electrical contact resistance.

Fields of application

Bonding of

- PVC and ABS edges with pre-treated back
- Resin impregnated paper edges
- Conductive edges

Advantages

- For conductive PVC edges, e.g. common in raised floor field
- Good melting properties

Properties of the bond

- Good heat resistance
- Good cold resistance
- Good aging resistance
- Good oxidation resistance
- Electrically conductive

Properties of the adhesive

Base:	EVA copolymers
Specific weight:	approx. 1.4 g/cm ³
Viscosity	
Brookfield HBTD:	at 200°C 30,000 ± 10,000 mPa·s
Softening point (ring + ball):	100 ± 5° C
Application temperature:	200-220 °C Low temperatures cause faulty bonding, higher temperatures - maintained for a long time - may damage the adhesive and lead to decomposition.

Electrical Conductivity:

≤10⁶ Ω

(we will gladly provide information regarding the test)

Delivery form:	granules
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

- Automatic edge banding machines with roller application.
Application should occur in counter direction for a uniform adhesive film.

Application techniques

The substrates for edge banding must be processed at exactly right angles and must be free from dust. Boards as well as edge materials have to be acclimatised to room temperature. The most favourable moisture content of the wood is 8-10%. The room temperature must not be lower than 18°C. Draught has to be avoided.

Temperature control:

Regularly check the temperature directly at the application system by means of a laboratory thermometer, a bimetal thermometer or by a thermometer with electric contacts. Readjust it, if necessary.

The thermometers installed in the machine may give incorrect readings after extended use.

Line feed:

20-30 m/min. Low speeds might result in faulty bonding.

Application quantity:

The quantity to be applied should be adjusted in such a manner as to slightly show 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.

Subsequent processing:

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

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Cleaning

Tools can be cleaned with KLEIBERIT Cleaner 827.0.

Packaging

KLEIBERIT Hotmelt Adhesive 771.2:

bag, 3.0 kg net
plastic sack, 20.0 kg net
container, 500.0 kg net

KLEIBERIT Cleaner 827.0:

carton with 12 bottles at 700 g net each
metal canister, 4.5 kg net each

Storage

KLEIBERIT Hotmelt Adhesive 771.2 can be stored for approx. 2 years. Keep in a cool and dry place.

EX0112; 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.