KLEIBERIT 871.5

Hot Press Adhesive

Fields of application
- Bonding of veneers on standard chipboard, non-flammable A2 boards and other wooden materials
- Bonding of surfaces

Advantages
- Low-formaldehyde
- Soluble, bleeding through can be avoided to a large extent
- Long pot life
- Favourable viscosity for processing
- Also suitable for HF-presses

Properties of the bond
- In compliance with our processing and at pressing temperatures of at least 100 °C, the values of the emission classes E1 according to EN 16516 and CARB 2 are achieved after veneering, if the support materials by themselves also reach E1 or CARB 2 (corresponds E05 to DIN 717-1).

Properties of the glue powder

Base:	urea formaldehyde condensation resin
Delivery form:	powder
Colour:	white
Identification:	Identification not required according to EU regulations (see our safety data sheet)

Application methods
- With spatula
- With manual gluing devices

Application techniques
Mixing proportion:
100 parts by weight of glue powder
50 parts by weight of water (18-20° C)

The quantity of water may be slightly varied.

Mixing vessels made of glass, plastic or aluminium are suitable. First empty the glue powder into the mixing vessel, then add approx. 2/3 of the water. Stir with stirring spindle or suitable tool until the mixture is free from lumps, then add the remaining water. The glue mixture is ready for use immediately.

The glue mixture has to be somewhat thicker for bonding A2 board (100:30 parts by weight)

Attention, pot life is reduced!

Please observe the following during veneer work with birch veneer:

Birch veneer has different wood ingredients which can cause faulty bonds. To avoid this problem, it is recommended to mix in white glue in an amount of 20-25% in the urea formaldehyde paste.

Consistency of the mixture:
varies from viscous to fluid depending on the requirements of the veneers.
Service time of the glue mixture:
at 20° C approx. 7 hours
at 30° C approx. 2.5 hours
Application quantity: Depending on the surface quality and absorbability of the substrate material, 100-150 g/m² must be applied.
Assembly time: The time between glue application until feeding into the press can be as much as 10 minutes.
This time can vary depending on the application quantity, room temperature as well as the absorbency of the material and must be determined with preliminary testing.
Feeding time:
The feeding time until closing the press is an maximum of 1-2 minutes

The higher the temperature, the shorter the feeding time!

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Intensity of pressure: 0.4 - 0.8 N/mm²

Press time:

press temperature ° C	base time in minutes	heating time/veneer thickness in minutes/mm
100	3	1
120	2.5	0.5

The total press time consists of base time and heating time. The values given are based on normal processing conditions and a moisture content of the wood of 8-10 %.
Exceptionally long parts which are projecting out of the press, can be pushed into the press within a period of approx. 15 minutes, (staggered pressing).

Cleaning

It is recommended to clean the work tools with cold water.

Packaging

KLEIBERIT Hot Press Glue 871.0:
Bag, 25 kg net

Additional packaging sizes upon request

Storage

KLEIBERIT 871.5 must be kept airtight and stored in a cool and dry place.
Shelf life in factory-sealed containers:
at 20° C approx. 6 months
at 30° C approx. 2 months

Version 28/01/21 lz; replaces earlier 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.

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