

# Hot Press Glue 881

## Water-resistant hot press glue for veneer bonding according to DIN 68 705 BFU 100 and DIN EN 204 D4

KLEIBERIT Hot Press Glue 881.1 is a powdered veneer glue based on melamine formaldehyde. After the addition of Hardener 881.2 and perhaps a filler in order to adjust the viscosity, KLEIBERIT Hot Press Glue 881 can be used for hot bonding from 90°C. The bond is resistant to the influences of cold and hot water.

### Product names:

KLEIBERIT Hot Press Glue 881.1  
KLEIBERIT Hardener 881.2

### Fields of application

Veneer bonding with

- House and outer doors
- Water resistant chipboards
- Humidity stressed surfaces indoors and outdoors

### Advantages

- Meets the requirements of DIN 68 705 BFU 100 and DIN EN 204 D4
- Easy application
- Long pot life
- Short press times
- When the glue is used properly, bleed through can be avoided to a large extent
- Liquid hardener saves the mixing of a solution

### Application techniques

The materials to be glued must be dust, oil and grease free and acclimatized. The ideal moisture content of the wood is 10 - 12%.

#### Mixing proportion:

100 parts by weight of Hot Press Glue 881.1  
50 parts by weight of water  
10 parts by weight of wheat flour  
15 parts by weight of Hardener 881.2

Mix KLEIBERIT Hot Press Glue 881 with 2/3 of the water until the mix is lump free, then add the wheat flour and the hardener, with the water balance the required viscosity can be adjusted. The mix is ready for use immediately. It is also possible to do without the wheat flour addition, but in this case the

water proportion should be reduced to 30 parts by weight.

### Usability of the mix:

at 20° C approx. 5.0 hours  
at 30° C approx. 1.5 hours

The life of the mix can be extended by adding 0.5% ammonium hydrate.

### Glue application:

The glue can be applied by toothed spatula, glue roller or glue spreading machine.

### Consumption:

Veneering 140 - 180 g/m<sup>2</sup>  
Crossbanding 160 - 200 g/m<sup>2</sup>

### Assembly time:

The time between glue application and feeding into the press should not be more than 10 - 13 minutes. The feeding time until closing of the press should not exceed 1 - 2 minutes.

### Pressing power:

0.2-0.7 N/sq. mm (2-7 kp/sq. cm)

### Pressing time:

Pressing Temperature °C	Base Time Minutes	Final Heating Time/ Veneer Thickness Minutes/mm
90	5	2
100	4	1
110	3	1/2

The complete pressing time is base and final heating time added.

The data indicated are without obligation, they are based on a moisture content of the wood of 10%. As the different bonding processes are influenced by various factors, the exact times must be determined by trials to be carried out in the factory.

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### Cleaning

Before KLEIBERIT Hot Press Glue 881 is hardened, tools may be cleaned with water. After finishing of the hardening process, glue residues can only be removed mechanically.

### Packaging

#### **KLEIBERIT Hot Press Glue 881.1:**

plastic pail, 5 kg net  
PE sack, 25 kg net

#### **KLEIBERIT Hardener 881.2:**

plastic bottle 0.750 kg net

Additional packaging sizes available upon request.

### Storage

KLEIBERIT Hot Press Glue 881.1 must be kept airtight and in a cool and dry place.

Shelf life in factory sealed containers.

#### **KLEIBERIT Hot Press Glue 88.1 and Hardener**

##### **881.2 :**

at 20°C, approx. 12 months,  
at 30° C approx. 6 months

EX0212; 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.