



KLEIBERIT 707.9

Reactive hotmelt adhesive for highly durable edge bonds on Holz-Her edge banding machines with cartridge systems

Field of application

- Solid wood edges
- HPL edges in strips
- PVC edges, extruded/calandered, as strips or rolls (primed)
- Veneer edges
- Duroplastic and thermoplastic edges in rolls

Advantage

- Heat resistance up to +150°C
- Cold resistance up to - 30°C
- Excellent bond strength even when exposed to steam

Properties of the adhesive

Basis: Polyurethane
Specific gravity: approx. 1.3 g/cm³
Color: 00 ivory
 10 white

Viscosity (day of production)

- Brookfield HBTD 10 rpm:

at 140°C: 80,000 ± 20,000 mPa · s

at 160°C: 45,000 ± 10,000 mPa · s

Identification: identification required according to EU regulations; contains diphenylmethane – 4,4 diisocyanate (see our safety data sheet)

Note: Intended for commercial use only.

Hotmelt adhesives release vapors, even if the described working temperature is being observed. When hotmelt adhesives are molten and applied, vapors are set free and an unpleasant odor can occur, even if the recommended working temperature has been observed.

If the recommended working temperature is exceeded over a longer period of time, there is a danger of decomposition products forming which are harmful. Precautions should be taken to eliminate the vapors, e.g. by using a suitable ventilation system.

Application techniques

The substrates should be freshly cut at right angles and should be free from dust. Boards and edge material have to be acclimatized to room temperature. Maintain room temperature of at least 18°C, avoid draughts.

Time required for heating up the cartridge:

2-5 minutes

Processing temperature:

130 - 150°C

During work pauses reduce the temperature to 100°C. Temperature control is of utmost importance when bonding HPL and solid wood edges. Long and thick work pieces need to be processed in the upper temperature range. Low temperatures reduce the wetting of the edges. Application quantity and pressure have to be adjusted in such a way that the application glue lines are crushed and the adhesive slightly pearls out on the margins. This can be easily checked by using a transparent test edge.

Reactive polyurethane hotmelts have a slightly lower initial strength compared to usual EVA hotmelts. Therefore consider the following:

- Use only recently sawed solid wood edges with good fit. Curved or twisted edges are unsuitable.
- Work precisely when preparing the substrate edges.
- PUR hotmelts allow considerably tighter joints compared to EVA hotmelts.
- Proceed very cautiously with thick PVC-edges in roll form due to deformation.
- Pay attention to a maximum roll pressure.



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Special recommendations for processing:

Change from KLEIBERIT 782.0 to 707.9

- Remove cartridges and set to 150°C
- Insert 761.0 and flush out GL 782.0
- Reduce temp. to 130°C
- Insert 707.9 and flush out cleaner

Change from KLEIBERIT 707.9 to 782.0

- Remove material
- Increase temp. to 180-200°C
- Insert GL 782.0 and flush out PUR 707.9
- **Attention: Cleaner 761.0 not needed!**

In detail:

a.) Change from EVA Hotmelt KLEIBERIT 782.0 Supramelt GL to KLEIBERIT 707.9:

Trials have shown that the use of KLEIBERIT Cleaner 761.0 is not necessarily needed if the cartridges are still intact. In this case, 707.9 can be immediately inserted. At a temp. of 150°C, completely purge EVA hotmelt KLEIBERIT Supramelt GL 782.0 from the application system. If KLEIBERIT PUR 707.9 does not back-melt during this process, then Cleaner KLEIBERIT 761.0 (brown) doesn't need to be used. Due to the different colors, it is possible to control if the application system is completely cleaned. The most favorable processing temperature for KLEIBERIT PUR 707.9 is between 120-140°C. This temperature should be kept for the bonding process after the entire cleaning agent has been purged.

b.) Change from KLEIBERIT 707.9 to KLEIBERIT 782.0 Supramelt GL:

Remove cartridges and increase temp. to 180-200°C. Then insert KLEIBERIT Supramelt GL 782.0 (EVA hotmelt) and fully clean the application system. Pay attention that the KLEIBERIT 707.9 has been entirely removed from the melting and application unit. To be sure you should use at least two EVA-cartridges for cleaning the system.

Mixture of EVA and PUR:

Clean the system with the applicator turned so that the adhesive is directed into a cardboard box. Clean the platen with a wooden spatula. When cleaning turn the dosing unit on "up" so that all nozzles are purged. Dispose of the waste adhesive mixture as allowed by local regulations.

For further processing of the edges such as flushing, milling and removing protruding edges, the initial tack provides for a dimensionally stable and tight joint bonding of the edge.

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

Cross-linking of the adhesive film takes approx. 1 - 2 days, depending on humidity. Final bond strengths are reached after approx. 7 days.

Packaging

KLEIBERIT 707.9:

Carton with 6 aluminum cans at 1.56 kg net each

Cleaner

KLEIBERIT 761.0:

Carton with 6 aluminum cans at 1.2 kg net each

Additional packaging sizes available upon request.

Storage

KLEIBERIT 707.9 can be stored in factory sealed packaging for approx. 12 months.

Protect from humidity!

Version 06/12/2016 xv; replaces previous versions

Klebstoff- und Gebinde-Entsorgung

Abfallschlüssel 080409

Unsere Gebinde sind aus recyclingfähigem Material. Gut entleerte Gebinde können der Wiederverwertung zugeführt werden.

Service

Unser anwendungstechnischer Beratungsdienst steht Ihnen jederzeit zur Verfügung. Unsere Angaben beruhen auf unseren bisherigen Erfahrungen und sind keine Eigenschaftszusicherungen im Sinne der BGH-Rechtsprechung. Prüfen Sie selbst, ob sich unser Produkt für Ihre Zwecke eignet. Eine Haftung, die über den Wert unseres Produktes hinausgeht, kann aus den vorliegenden Ausführungen nicht hergeleitet werden, auch nicht aus der Inanspruchnahme unseres kostenlos und unverbindlich zur Verfügung gestellten Beratungsdienstes.