



# Reactive PUR Hotmelt 707.9

## 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
- All of the raw materials used meet the Directive 2002/72/EG for products intended to come into contact with food.

## Properties of the adhesive

**Basis:** Polyurethane  
**Specific gravity:** approx. 1.3 g/cm<sup>3</sup>  
**Colour:** 00 ivory  
 10 white  
 12 vanilla

### Viscosity (day of production )

#### - Brookfield HBTD 10 Upm:

at 120°C: 160.000 ± 50.000 mPa · mPa·s

at 140°C: 80.000 ± 20.000 mPa · mPa·s

at 160°C: 45.000 ± 10.000 mPa · s

**Working temperature:** 120-160°C

**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 vapours, even if the described working temperature is being observed. When hotmelt adhesives are molten and applied, vapours are set free and an unpleasant odour 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 vapours, 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.

### Working temperature:

Roller application 120-160°C

Reduce the temperature to approx. 100°C during work breaks.

Particular attention should be paid to the accurate temperature control when bonding HPL and solid wood edges. Work at the upper temperatures when bond and thick substrates. Low temperature reduces the wetting of the edges. Coat weight and pressures should be adjusted so that the applied adhesive pearls are slightly pressed out at the edges. Effective pressing out can be checked with a transparent test edge.

Reactive PUR hotmelts have a slightly higher green strength compared to EVA hotmelts. Therefore:

- Only use recently prepared solid wood edges, with perfect fit. Curved edges are not suitable
- Ensure that the base substrate has perfect edges too.
- PUR hotmelt adhesives, compared to EVA hotmelt adhesives, achieve significantly closer joints.
- Thick PVC edges in rolls have to be treated with care as they are under high tension.
- Ensure that the press roller apply maximum pressure.

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

The green strength ensures that the product is durable and has a close joint and allows for further processing, such a flush milling of the edges. The cross linking of the product, depending on the humidity will occur in 1-2 days. The final strength is reached after 7 days.



## Reaktiver PUR Hotmelt PUR 707.9

### Cleaning

After finishing work with KLEIBERIT PUR hotmelt 707.9 empty the content of the melting vessel and drain of the remaining adhesive in the system. Immediately afterwards use KLEIBERIT Cleaner 761.7, melt the cleaner and then allow the cleaner to push the remaining PUR hotmelt out of the system until all PUR hotmelt has been removed. Cross linked PUR hotmelt can only be removed mechanically.

### Packaging

#### **KLEIBERIT PUR hotmelt 707.9:**

Carton with 12 aluminium cartridges, 0.3 kg net each  
 Carton with 18 bags, 0.4 kg net each  
 Carton with 6 aluminum bags in fiber drums, 2.0 kg net each  
 Aluminum bag in fiber drum, 18.0 kg  
 Metal drum, 200 kg

#### **KLEIBERIT Cleaner 761.7:**

Carton with 12 aluminium cartridges, 0.25 kg net each  
 Carton with 6 aluminum bags in fiber drums, 1.5 kg net each  
 Carton with 6 bags, 0.22 kg net each  
 Metal pail, 15.0 kg net

Additional packaging sizes available upon request.

### Storage

KLEIBERIT PUR hotmelt 707.9 can be stored in factory sealed packaging as follows:

Aluminium cartridges, approx. 12 months  
 Aluminum bag in fiber drum (2kg), approx. 12 months  
 Aluminum bag in fiber drum (18 kg), approx. 12 months  
 Bag, approx. 12 months  
 Metal drum, approx. 12 months

Protect from humidity!

Version MF 1113; replaces previous versions

#### Klebstoff- und Gebinde-Entsorgung

Abfallschlüssel 080410

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.