KLEIBERIT®
ADHESIVES • COATINGS

KLEIBERIT 707.6 and KLEIBERIT 707.9

In practical portion bags for edge banding machines

Our economical alternative to polyurethane granulate

As an alternative to PUR granulate, **KLEIBERIT** offers **707.6** and **707.9** in practical aluminum bags.

Tips for processing:

- Melting temperature: 140 °C
- Melt time until application approx. 6-8 min
- Time for complete melting of 400 g: approx. 15 minutes
- Fits well in standard melting tanks, horizontally as well as vertically

PRODUCT INFORMATION

Advantages

- Optimal portioning
- Easy removal from packaging
- Heat resistance up to +150°C
- Cold resistance down to -30°C
- Excellent strength – also when exposed to moisture

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FIELD OF APPLICATION

Edge banding of panels with:

- ABS, PMMA, PVC and PP edges (with suitable adhesion promoter)
- CPL and HPL edges
- Paper edges
- Veneer and solid wood edges

PROCESSING

- 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.
- During work pauses reduce the temperature to 100°C.
- Long and thick work pieces need to be processed in the upper temperature range.
- Application quantity and pressure have to be adjusted in such a way that the surface is fully wetted. This can be easily checked by using a transparent test edge. The adhesive should slightly pearl out on the margins.

NOTE

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

- Use only recently prepared solid wood edges. Curved or twisted edges are unsuitable.
- PUR hotmelts allow considerably thinner glue lines compared to EVA hotmelts.
- Proceed very cautiously with thick thermoplastic edges in roll form due to high material tension.
- Ensure pressure roller has sufficient high pressure.

TECHNICAL PROPERTIES

• **Basis**	Polyurethane
• **Specific gravity**	approx. 1.3 g/cm³
• **Processing temp**	120 - 160 °C
• **Heat resistance**	up to +150 °C
• **Cold resistance**	down to -30 °C
• **Colour**	natural, transparent, white, vanilla

KLEIBERIT 707.6

- **Viscosity** (day of production) **Brookfield HBTD 10 rpm:**

at 120 °C:	approx. 110,000 mPa·s
at 140 °C:	approx. 60,000 mPa·s

KLEIBERIT 707.9

- **Viscosity** (day of production) **Brookfield HBTD 10 rpm:**

at 120 °C:	approx. 160,000 mPa·s
at 140 °C:	approx. 80,000 mPa·s

INSTRUCTIONS FOR EASY HANDLING

Step 1:
Cut the pouch packaging under the welded seam with scissors.

Step 2:
Cut the pouch packaging from the open side toward the bottom with scissors.

Step 3:
Manually remove the pouch packaging so that the adhesive block is free from packaging.

Step 4:
Place the adhesive block in the pre-heated melting tank.

The adhesive is melted within minutes and ready for application. Cleaning takes place as known with cleaning granulate **KLEIBERIT 761.7**.

PACKAGING

KLEIBERIT 707.6/707.9:
Carton with 18 bags at 0.4 kg net each
KLEIBERIT 761.7 Cleaner
Carton with 6 bags at 0.22 kg net each
Additional packaging sizes available upon request.

STORAGE

KLEIBERIT 707.6/707.9 can be stored in factory sealed packaging for approx. 12 months. Protect from humidity!

IDENTIFICATION

Identification required according to EU regulations; contains **diphenylmethane – 4,4 diisocyante**. **See our safety data sheet**.
Intended for commercial use only.

TECHNICAL DATA

KLEIBERIT 707.6
KLEIBERIT 707.9

SERVICE

Our applications department may be consulted at any time without obligation. The statements herein are based on our experiences 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 application. No liability exceeding the value of our products can be derived from these statements. This also applies to the technical consultancy service, which is rendered free of charge and without obligation.