

KLEIBERIT 707.6.40

...in the proven aluminum can!

Very good stability in melting system for 24 hours



ATTENTION!
The separator must be removed from the cartridge before processing.



Advantages in a glance:

- Very good stability in open melting tank (at normal temperatures 20/65 min. 24 hours)
- Invisible glue line
- Very good green strength
- 100% cylindrical form
- Optimal adhesive protection from moisture
- Stable packaging
- Fill quantity: 260 g
- Available in the colors natural and white

PRODUCT INFORMATION



Reactive hotmelt adhesive for high quality edge banding on HOLZ-HER edge banding machines with cartridge systems.

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

Additional Advantages

- Heat resistance up to +150 °C
- Cold resistance down to -30 °C
- Excellent strength – also when exposed to moisture
- Very good stability in melting system

KLEBCHEMIE

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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. 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 when the application glue lines are pressed, a closed glue film is formed and the adhesive slightly pearls out on the margins. This can be easily checked by using a transparent test edge.

NOTE

Reactive PUR hotmelts have a slightly lower green strength compared to 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.

TECHNICAL PROPERTIES

- **Basis** Polyurethane
- **Specific gravity** approx. 1,3 g/cm³
- **Heating time** 2-5 minutes
- **Processing temp** 120-160 °C
- **Heat resistance** up to +150 °C
- **Cold resistance** down to -30 °C
- **Colour** 707.6.40 - natural
707.6.41 - white
- **Viscosity** (day of production) Brookfield HBTD 10 rpm:
at 120 °C: 100.000 ± 25.000 mPa·s
at 140 °C: 65.000 ± 15.000 mPa·s

INSTRUCTIONS FOR EASY HANDLING



Step 1:
Open the aluminum can at the upper rim with a can opener (KLEIBERIT art.no. 895.1.9500)



Step 2:
Bend out the edge of the open aluminium can with the aid of a can opener.



Step 3:
Turn aluminium can and let the adhesive block out of the can.



Step 4:
Completely remove silver separator.

SPECIAL RECOMMENDATIONS FOR CLEANING

Change from KLEIBERIT 782.0 to KLEIBERIT 707.6.40

- Remove cartridges and set to 150 °C
- Insert 761.0 and flush out 782.0
- Reduce temp. to 130 °C
- Insert 707.6.40 and flush out cleaner

Change from KLEIBERIT 707.6.40 to KLEIBERIT 782.0

- Remove material
- Increase temp. to 160-180 °C
- Insert 782.0 and flush out 707.6.40

PACKAGING

KLEIBERIT 707.6.40

Carton (with 6 aluminum cans at 0.26 kg net each) 1.56 kg net

KLEIBERIT 761.0 Cleaner

Carton with 12 aluminum cartridges at 0.25 kg net each

KLEIBERIT 895.1.9500 can opener

Additional packaging sizes available upon request.

STORAGE

KLEIBERIT 707.6.40 can be stored in factory sealed packaging as follows: cans, approx. 12 months.

Protect from humidity!

IDENTIFICATION

Identification required according to EU regulations; contains **diphenylmethane - 4,4 diisocyanate** (see our safety data sheet). **Intended for commercial use only.**

TECHNICAL DATA

**KLEIBERIT
707.6.40**



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.