The New Way for Edgebanding with PUR Hotmelt

KLEIBERIT
707.6.40 PUR

+ very good stability in open melting tank for 24 hours
+ rapid melting in standard melting tank
+ easy use
+ fits in standard edge banders without need for additional equipment

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COMPETENCE PUR

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

ADVANTAGE
- Excellent bond strength even when exposed to steam
- Very good stability in open melting tank (at normal ambient condition 20°C/65% rel. a.h. minimum 24 hours)

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:**
Turn the blister pack so that the curved side points towards you

**Step 2:**
Push the tablet out with your thumbs

**Step 3:**
Remove the tablet from the blister pack

**Step 4:**
Place the completely unpacked tablet in the melting device

PACKAGING
KLEIBERIT 707.6.40
Carton (with 20 blister at 3 x 32 g net each) 1.92 kg net
KLEIBERIT 761.6 All-in-one Cleaner
Carton with 6 aluminum cartridges 0.2 kg net each
Carton with 18 bags 0.4 kg net each
Carton with 6 aluminum bags in fiber drums 1.8 kg net each
KLEIBERIT 761.7 Cleaner
Carton with 6 bags 0.22 kg net each
Carton with 6 aluminum bags in fiber drums 1.5 kg net each

STORAGE
KLEIBERIT 707.6.40/41 can be stored in factory sealed packaging, approx. 12 months. Protect from humidity!

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KLEBCHEMIE M. G. Becker GmbH & Co. KG • Max-Becker-Str. 4 • 76356 WEINGARTEN/GERMANY • Phone +49 7244 62-0 • Fax +49 7244 700-0
www.kleiberit.com