

# Edge Banding

With KLEIBERIT PUR hotmelt adhesives, the possibilities for using design edges are unlimited and reliable

## KLEIBERIT PUR Hotmelt

### KLEIBERIT 707.6

Reactive PUR hotmelt adhesive

- High temperature resistance from -30 °C up to +150 °C
- Very high humidity, water and steam resistance

### KLEIBERIT 707.7

Reactive PUR hotmelt adhesive for highly durable bonding of edges

- Optimal bond on edges which are otherwise difficult to bond
- High temperature resistance from -30 °C up to +150 °C
- Very high humidity, water and steam resistance
- Excellent strength, also when exposed to steam

### KLEIBERIT 707.9

Reactive PUR hotmelt adhesive

- High temperature resistance from -30 °C up to +150 °C
- Very high humidity, water and steam resistance
- All raw materials used comply with Directive 2002/72/EG for products which are intended to come into contact with food

## KLEIBERIT PO Hotmelt

### KLEIBERIT 754.0

For straight edges, softforming and postforming

- High temperature resistance from -30 °C to +140 °C depending on edging material
- Very high green strength
- Application with roller or slot nozzle
- Suitable for processing on CNC processing centres



## KLEIBERIT EVA Hotmelt

### KLEIBERIT 773.3

"Universal" and "transparent" for nearly all edging materials

- Absolutely no stringing – so smearing during routing
- Very good pre-melting properties for high line speeds up to 30 m/min
- Suitable for difficult softforming profiles with a tight radius
- Transparent – invisible glue line

## ADHESIVES

In the edge banding field, the adhesive requirements of the furniture industry are constantly increasing, especially regarding faster application, temperature and heat resistance, shapes and materials.

Suitable adhesive systems for edge banding are:

### Reactive PUR Hotmelts

(polyurethane):

- Besides the physical setting there is a chemical cross linking
- Much higher moisture and temperature resistance from -30 °C up to +150 °C

### EVA Hotmelts

#### PO Hotmelts

(Ethylene-vinyl acetate and polyolefin):

- Based on thermoplastic synthetics or resins which set purely physical
- Reach strength immediately after cooling and setting/crystallisation
- Temperature resistance from -30 °C to +140 °C

**KLEIBERIT SE & Co. KG**  
 Max-Becker-Str. 4  
 76356 Weingarten/Germany  
 Phone: +49 7244 62-0  
 Fax: +49 7244 700-0  
[www.kleiberit.com](http://www.kleiberit.com)

**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

**KLEIBERIT 773.7**

- Very good melting properties
- Suitable for softforming processes and bonding in CNC processing centres (easy edge)
- Especially suited for line speeds of 10-35 m/min
- High temperature resistance from -30 °C to +100 °C (depending on edging material)

**KLEIBERIT 773.8**

- Good melting properties
- Also suitable for CNC
- Very clean processing, no stringing
- Especially suited for line speeds of 10-50 m/min

**KLEIBERIT 774.4**

- Medium viscosity
- Good green strength

- Also suited for edge pre-coating
- Especially suited for line speeds of 15-50 m/min

**KLEIBERIT 777.2/.4**

- High green strength
- Also suited for softforming
- Especially suited for line speeds of 18-50 m/min
- Very high temperature resistance from -30 °C to +120 °C (depending on edging material)

**KLEIBERIT 779.6**

- Good melting properties
- Also suitable for pre-coating edges
- Especially suited for line speeds of 8-50 m/min
- Very high temperature resistance from -30 °C to +120 °C (depending on edging material)

**KLEIBERIT 779.7**

- High green strength
- Also suited for softforming
- Especially suited for line speeds of 20-80 m/min
- Very high temperature resistance from -30 °C to +120 °C (depending on edging material)

**KLEIBERIT Products in HolzHer Cartridge Systems**

Hotmelt adhesives in cartridge form with easy slide coating for HolzHer cartridge systems.

- Increased adhesive flow
- Problem-free cartridge melting, no residue

KLEIBERIT 707.6, 707.9, 773.8, 779.6 and 782.0 are available in cartridges for HolzHER systems.

**Application**

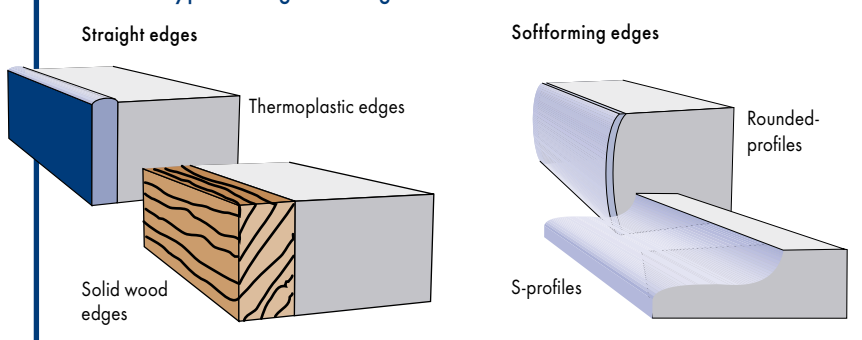
Hotmelt adhesives for bonding of edges and softforming have a medium or high viscosity, in order to fill the gaps in the middle layer of the chipboard and to achieve good strength across the whole width of the board.

Quick crystallisation in the press is necessary to avoid smearing during flush milling. The green strength of hotmelt adhesives must be very high, especially for softforming processes, so that the memory of the edging materials cannot cause the glue line to open.

Edge banding adhesives are free flowing and therefore do not cause blocking in the granulate pre-melter.

Edge banding hotmelts are melted in granulate premelters which are usually situated directly above the application system. The pre-melted adhesive is guided (level-controlled) through a heated hose into the application basin. The application is either with roller or with a nozzle.

For straight edges the adhesive is usually applied on the chipboard, for softforming always to the edging material.

**Different Types of Edge Banding****KLEIBERIT Adhesives for Edgebanding**

type of machine		manual or slow edge banding machines	usual edge banding machines >18m/min		high-speed edge banding machines		CNC-processing center	contour edge banding machines	
KLEIBERIT	Product		straight edges	softforming	straight edges	softforming		straight edges	softforming
EVA Hotmelts	773.3		■	■	■	■	●	●	●
	773.7	●	■	■	●	●	■	■	▼
	773.8		■	■	■	■	■	●	●
	774.4		■	■	●				
	777.2/777.4		■	■			▼		
	779.6		■	●	▼	●	▼	●	●
PO-HM	779.7	●	■	■	▼	▼	▼	●	●
	754.0	●	■	■	■	■	●	●	●
PUR-HM	707.6	▼	■	■	■	●	●	■	■
	707.7	▼	■	■	■	●	●	■	■
	707.9	▼	■	■	■	●	■	■	■

■ very well suited

▼ well suited

● possible