## KLEIBERIT Products for Profile Wrapping Exterior

<table>
<thead>
<tr>
<th>Product Code</th>
<th>Density (g/cm³)</th>
<th>Viscosity at 120°C [mPas]</th>
<th>Viscosity at 140°C [mPas]</th>
<th>Application Method</th>
<th>Solvents according to German Regulation</th>
<th>Flammable</th>
<th>Identification</th>
<th>Application Method</th>
<th>Applications</th>
<th>Characteristics</th>
</tr>
</thead>
<tbody>
<tr>
<td>831.0</td>
<td>1.33</td>
<td>20</td>
<td>-</td>
<td>-</td>
<td>no</td>
<td>GH507</td>
<td>GH510</td>
<td>primer felt pad</td>
<td>Fluorescent primer for wrapping PVC profiles</td>
<td>Wide processing window, fast evaporation</td>
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<tr>
<td>831.2</td>
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<td>10</td>
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<td>-</td>
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<td>GH507</td>
<td>GH510</td>
<td>primer felt pad</td>
<td>Fluorescent primer for wrapping POM profiles</td>
<td>Wide processing window, more aggressive version of 831.0, fast evaporation</td>
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<tr>
<td>831.4</td>
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<td>GH502</td>
<td>GH517</td>
<td>primer felt pad</td>
<td>Fluorescent primer for PIR/PMMA profile wrapping and for pre-treating acrylate foils</td>
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<td>831.6</td>
<td>1.3</td>
<td>20</td>
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<td>GH510</td>
<td>primer felt pad</td>
<td>Fluorescent primer for wrapping PMMA profiles</td>
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<td>831.7</td>
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<td>primer felt pad</td>
<td>Fluorescent primer for wrapping PVC and acrylate profiles</td>
<td>Fast evaporation</td>
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<tr>
<td>831.8</td>
<td>1.33</td>
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<td>no</td>
<td>GH507</td>
<td>GH510</td>
<td>primer felt pad</td>
<td>Fluorescent primer for wrapping PVC and acrylate profiles</td>
<td>Wide processing window, fast evaporation</td>
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<td>840.3</td>
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<td>GH503</td>
<td>GH510</td>
<td>primer felt pad</td>
<td>Fluorescent primer for wrapping PVC profiles with PUR hotmelt</td>
<td>Low VOC, without the addition of NEP</td>
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<td>primer felt pad</td>
<td>Fluorescent primer for wrapping PVC profiles with PUR hotmelt</td>
<td>Low VOC, water based</td>
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<td>GH503</td>
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<td>Low VOC</td>
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<td>GH510</td>
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<td>Fluorescent primer for wrapping PVC profiles with PUR hotmelt</td>
<td>Low VOC, without the addition of NEP</td>
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<td>-</td>
<td>no</td>
<td>GH503</td>
<td>GH510</td>
<td>primer felt pad</td>
<td>Fluorescent primer for wrapping PVC profiles with PUR hotmelt</td>
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<td>primer felt pad</td>
<td>Fluorescent primer for wrapping PVC profiles with PUR hotmelt</td>
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<td>Cleaning agent for application tools and machines of steel for uncured and cured PUR adhesives</td>
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<tr>
<td>832.6</td>
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<td>6</td>
<td>-</td>
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<td>-</td>
<td>Cleaning agent for application tools and machines of steel for uncured and cured PUR adhesives</td>
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</tr>
</tbody>
</table>

## Stay Cool During the Tropic Test

with adhesive systems from KLEIBERIT!

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**Applications**

- **Coat RAL**
- **Approval**
- **Weight**
- **Line**
- **Application Method**
- **Characteristics**

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**www.kleiberit.com**

***Competition PUR***

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Stay Cool During the Tropic Test with adhesive systems from KLEIBERIT!

For more than 40 years, PVC windows for internal as well as external use have been wrapped with decorative PVC foils. The standard required of the adhesives was then, and is now, very high. High temperature, humidity and ageing resistance, as well as a high green strength for inline production are just some of the requirements for perfect and products.

Over the last 25 years, solvent-free polyurethane hotmelts have been the alternative to solvent adhesives, and they also still cover all profile wrapping requirements. KLEIBERIT PUR Hotmelt 704 set a quality standard in the market.

The complete KLEIBERIT product range is the answer to using new profile and foil systems, quick subsequent processing and fulfilling the requirements and guidelines of the new RAL GZ 716.

KLEIBERIT 704.3
- High initial strength
- Very fast setting
- Excellent temperature, weathering and ageing resistance
- Approved by RAL GZ 716

KLEIBERIT 704.5
- Excellent processing properties
- Fast setting
- Excellent temperature, weathering, and ageing resistance
- Approved by RAL GZ 716
- Easy to apply with slot nozzle, doctor blade and roller

KLEIBERIT 704.6
- Very high green strength
- Long open time
- Approved by RAL GZ 716
- Very well suited for wide lamination lines
- Can be used for a variety of applications

KLEIBERIT 704.7
- Approved by RAL GZ 716
- Easy to apply with slot nozzle, doctor blade and roller

KLEIBERIT 704.8
- Approved by RAL GZ 716
- Easy to apply with slot nozzle, doctor blade and roller

KLEIBERIT 707/702
Especially for wrapping CPL or papers to PVC windowsills and aluminium profiles
- Very high green strength for wrapping materials with high memory

KLEIBERIT 705.4
- Approved by RAL GZ 716
- Approved by RAL GZ 716
- Easy to apply with slot nozzle, doctor blade and roller
- Easy to apply with slot nozzle, doctor blade and roller

Solvent Adhesives

KLEIBERIT 257.7 and 261.7 are applied at room temperature after the addition of KLEIBERIT 870.0. The adhesive is applied via a doctor blade to the underside of the wrapping material. The majority of the solvent is evaporated in a drying tunnel or with heated plates before the foil comes in contact with the profile. The foil is wrapped on to the profile by rollers placed in accordance with the profile geometry.

Profile preparation
PVC profiles are normally blown off with dry, ionized air before the primer is applied. Afterwards the primer (KLEIBERIT 831, 840 or 848) is applied using felt pads which have been adjusted to the respective profile shape. When using modern low VOC primer systems (e.g. KLEIBERIT 840), the use of vacuum application technology is becoming more prevalent. The primer is subsequently dried using heat sources such as IR heaters or hot air blowers.

Application

PUR Hotmelts
Depending on the type, they are low to medium viscous in their molten state condition. They distinguish themselves through good melting properties, good dosing, and long open time but high green strength. The adhesive is always applied to the underside to the wrapping material via roller, doctor blade or slot nozzle. The application temperature is between 100°C - 140°C.

Solvent Adhesives
KLEIBERIT 257.7 and 261.7 are applied at room temperature after the addition of KLEIBERIT 870.0. The adhesive is applied via a doctor blade to the underside of the wrapping material. The majority of the solvent is evaporated in a drying tunnel or with heated plates before the foil comes in contact with the profile. The foil is wrapped on to the profile by rollers placed in accordance with the profile geometry.