

KLEIBERIT 707.6 AND KLEIBERIT 707.9



IN PRACTICAL PORTION BAGS FOR EDGE BANDING MACHINES

In the living area, it is impossible to imagine life without case furniture. This includes everyday pieces such as cabinets, chests of drawers, coffee tables or stereo cabinets which can be found in almost every living room. The panels used for this type of furniture are often made of wood-based materials, such as MDF or pressboard. To create a desirable appearance, the surfaces are laminated with decorative material. This would not be possible without suitable adhesives. Durability, perfectly laminated surfaces or an edge finish with an invisible glue line define the demanding requirements profile of the adhesive. The adhesive used plays a key role in ensuring an uncomplicated and efficient production process.

Polyurethane-based adhesives offer by far the best performance. As an economical alternative to PUR granulate, KLEIBERIT offers 707.6 and 707.9 in practical aluminum bags.

FIELD OF APPLICATION

Edging of panel materials with:

- ABS-, PMMA-, PVC- and PP-edges (with suitable bonding agent)
- CPL- and HPL-edges (may require bonding agent)
- Paper-edges
- Veneer and solid wood edges

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

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



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

- Base: 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

IDENTIFICATION

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

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!