

Hot Press Glue 864.0

With hardener included

Thermosetting urea resin glue in powder form for medium press times

Fields of application

- Bonding of veneers
- Bonding of surfaces

Advantages

- Well soluble, bleed through can be avoided to a large extent
- Long pot life
- Ready for use as soon as mixed with water
- Favourable viscosity for processing
- Good application properties - high yield

Properties of the bond

- Bond strength corresponding to stress group IF as per DIN 68 705 can be achieved with KLEIBERIT Hot Press Glue 864.0.

Properties of the glue powder

Base:	Urea formaldehyde condensated resin
Delivery form:	Powder
Colour:	White
Identification:	Identification not required according to the German hazardous substances regulations GefStoffV. (see our safety data sheet)

Application methods

- spatula
- manual gluing devices
- glue spreading machines

Application techniques

Mixing proportion:

100 parts by weight of glue powder
 80 parts by weight of water (18-20° C)
 Dosed by means of a measuring cup:
 2 parts by volume of glue powder
 1 part by volume of water (18-20° C)

The quantity of water may be slightly varied.

A higher viscosity of the glue mixture can be achieved by adding rye flour (10-30%).

Mixing vessels may be made of glass, plastic or aluminium. First the glue powder must be fed into the mixing vessel, then add approx. 2/3 of the water. Stir with stirring spindle or suitable tool until the mixture is lump free, then add balance of water. The glue mixture is immediately ready for use.

Consistency of the glue mixture:

May be varied from viscous to fluid depending on the nature of the veneers.

Pot life of the glue mixture:

at 20° C approx. 5 hours
 at 30° C approx. 3 hours

Application, Consumption:

Depending on the surface quality and absorbability of the substrate material 100-150 g/m² must be applied.

Assembly Time:

The time between glue application and feeding into the press can be approx. 10-15 minutes

Feeding Time:

The feeding time until closing of the press can be approx. 1-2 minutes.

The higher the temperature the shorter the feeding time!

Intensity of pressure:

0.3-0.8 N/ mm² (3-8 kp/cm²)

Pressing Time:

Press temperature in ° C	Base time in minutes	Heating time/ veneer thickness in minutes/ mm
70	6	2
80	4	2
100	2	1
120	2	0,5

The total press time consists of base time and heating time. The values given are based on normal processing conditions and a moisture content of the wood of 8-10 %. Exceptionally long parts not fitting into press can be inserted in a second cycle within a time range of 15-20 minutes.

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Cleaning

It is recommended to clean the work tools with cold water.

Packaging

KLEIBERIT Hot Press Glue 864.0:

Bags, 25 kg net

Storage

KLEIBERIT Hot Press Glue 864.0 must be kept airtight in a cool and dry place. The shelf life in factory sealed containers are:

at 20° C: approx. 6 months

at 30° C: approx. 2 months

EX 0300, replaces previous data sheets

Waste Disposal

Disposal of contents and/or containers should comply with all applicable federal, state and local regulations.

Our containers are made of recyclable material.

Service

Our application department may be consulted at any time without obligation. The statements made herein are based on our experience 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 purposes. No liability exceeding the value of our product can be derived from the foregoing statements. This also applies to the technical consultancy service which is rendered free of charge and without obligation.