

# A Quality Bond

## Recommendation List for Edge Banding with Brandt Machines

Machine Type	Edge Thickness [mm]	Line Speed [m/min]	Recommended Adhesive KLEIBERIT	Application Temperature	HM-Type Base	Adhesive Characteristics
OPTIMAT KDF 9XX	0,4 - 20	8 to 20	773.3	170 - 200° C	EVA	Very high green strength, no stringing
OPTIMAT KDN 9XX			788.0	200 - 230° C	EVA	Universal, solid wood edges to 20 mm
			707.9	120 - 160° C	PUR	Universal, very high heat and cold resistance
OPTIMAT KDF 7XX	0,4 - 12/15	8 to 20	735.0	200 - 230° C	EVA	Universal, solid wood edges to 20 mm
OPTIMAT KDN 7XX			788.3	130 - 160° C	EVA	Long open time, low application temp., man. edgeb.
			773.3	170 - 200° C	EVA	Very high green strength, no stringing
			707.9	120 - 160° C	PUR	Universal, very high heat and cold resistance
OPTIMAT KDF 6XX	0,4 - 12	8-16/20	788.0	180 - 200° C	EVA	Universal, solid wood edges to 20 mm
OPTIMAT KDN 6XX			788.3	130 - 160° C	EVA	Long open time, low application temp., man. edgeb.
			773.3	170 - 200° C	EVA	Very high green strength, no stringing
			753.5	190 - 210° C	PO	Universal use, high heat resistance
			707.9	120 - 160° C	PUR	Universal, very high heat and cold resistance
OPTIMAT KDF 5XX	0,4 - 8	11/14	788.3	130 - 160° C	EVA	Long open time, low application temp., man. edgeb.
OPTIMAT KDN 5XX			788.0	180 - 200° C	EVA	Universal, solid wood edges to 20 mm
			773.3	170 - 200° C	EVA	Very high green strength, no stringing
			707.9	120 - 160° C	PUR	Universal, very high heat and cold resistance
OPTIMAT KDF 4XX	0,4 - 8	11/14	788.3	130 - 160° C	EVA	Long open time, low application temp., man. edgeb.
OPTIMAT KDN 4XX			788.0	180 - 200° C	EVA	Universal, solid wood edges to 20 mm
			773.3	170 - 200° C	EVA	Very high green strength, no stringing
			707.9	120 - 160° C	PUR	Universal, very high heat and cold resistance
OPTIMAT KDF 3XX	0,4 - 3	11	788.3	130 - 160° C	EVA	Long open time, low application temp., man. edgeb.
OPTIMAT KDN 3XX			788.7	160 - 200° C	EVA	Universal use, solid wood edges to 20 mm
			773.3	170 - 200° C	EVA	Very high green strength, no stringing
OPTIMAT KDF 2XX	0,4 - 3/6	10	788.3	130 - 160° C	EVA	Long open time, low application temp., man. edgeb.
OPTIMAT KDN 2XX			788.7	160 - 200° C	EVA	Universal use, solid wood edges to 20 mm
OPTIMAT KTD 820	0,4 - 3	0,7 to 4,2	788.3	130 - 160° C	EVA	Long open time, low application temp., man. edgeb.
OPTIMAT KTD 720	0,4 - 3	4 bis 9	788.7	160 - 200° C	EVA	Universal use, solid wood edges to 20 mm

## Recommendation List for KLEIBERIT Cleaner with Brandt Machines

Product	820	823.3	827	826	Cleaner for PUR HM		
					761.4	761.7	761.9
Viscosity in [mPa•s] at 120°C	-	-	-	-	20.000	11.000	60.000
Delivery form	liquid	liquid	liquid	liquid	granulate	granulate/block	granulate/block
Colour	transparent	transparent to yellow		transparent/oily	blue	blue	blue