



# KLEIBERIT 707.6.40

## Reactive PUR-Hotmelt Adhesive

### 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

### Advantage

- Heat resistance up to +150 °C
- Cold resistance up to - 30 °C
- Excellent bond strength even when exposed to steam
- Very good stability in open melting tank (at normal temperatures 20/65 min. 24 hours)

### Properties of the adhesive

**Basis:** Polyurethane

**Specific gravity:** approx. 1.3 g/cm<sup>3</sup>

**Colour:** 707.6.40 - natural  
707.6.41 - white

**Viscosity (day of production)**

- Brookfield HBTD 10 Upm:

at 120 °C: 100,000 ± 25,000 mPa · mPa·s

at 140 °C: 65,000 ± 15,000 mPa · mPa·s

**Working temperature:** 120-160°C

**Identification:** identification required according to EU regulations; contains diphenylmethane – 4,4 diisocyanate  
(see our safety data sheet)

**Note:** Intended for commercial use only

Hotmelt adhesives release vapours, even if the described working temperature is being observed. When hotmelt adhesives are molten and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working temperature has been observed. If the recommended working temperature is exceeded over a longer period of time, there is a danger of decomposition products forming which are harmful. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

### Application techniques

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.

### Working temperature:

Roller application 120-160 °C

Reduce the temperature to approx. 100 °C during work breaks.

Particular attention should be paid to the accurate temperature control when bonding HPL and solid wood edges. Work at the upper temperatures when bond and thick substrates. Low temperature reduces the wetting of the edges. Coat weight and pressures should be adjusted so that the applied adhesive pearls are slightly pressed out at the edges. Effective pressing out can be checked with a transparent test edge.

Reactive PUR hotmelts have a slightly higher green strength compared to EVA hotmelts. Therefore:

- Only use recently prepared solid wood edges, with perfect fit. Curved edges are not suitable
- Ensure that the base substrate has perfect edges too.
- PUR hotmelt adhesives, compared to EVA hotmelt adhesives, achieve significantly closer joints.
- Thick PVC edges in rolls have to be treated with care as they are under high tension.
- Ensure that the press roller apply maximum pressure.

Chemical cross linking of PUR hotmelts requires moisture. Therefore sufficient air humidity has to be present during processing.

The green strength ensures that the product is durable and has a close joint and allows for further processing, such a flush milling of the edges. The cross linking of the product, depending on the humidity will occur in 3-5 days. The final strength is reached after 7 days.



## KLEIBERIT 707.6.40

### Cleaning

After finishing work with KLEIBERIT 707.6.40 empty the content of the melting vessel and drain of the remaining adhesive in the system. Afterwards use Cleaner KLEIBERIT 761.7, melt the cleaner and then allow the cleaner to push the remaining PUR hotmelt out of the system until all PUR hotmelt has been removed. Cross linked PUR hotmelt can only be removed mechanically.

### Packaging

#### KLEIBERIT 707.6.40:

Carton with 18 bags at 0.4kg each  
Carton with 6 aluminum bags in fiber drum at 2 kg each

#### Cleaner

#### KLEIBERIT 761.7:

Carton with 12 aluminium cartridges, 0.25 kg net each  
Carton with 6 aluminum bags in fiber drums, 1.5 kg net each  
Carton with 6 bags, 0.22 kg net each  
Metal pail, 15.0 kg net

Additional packaging sizes available upon request.

### Storage

KLEIBERIT 707.6.40 can be stored in factory sealed packaging for approx. 12 months.

Protect from humidity!

Version 09/05/2018 XI; replaces previous versions

#### Adhesive and Waste Disposal

**Waste Code** 080409  
080410 - Adhesive fully cured

Our containers are made of recyclable material. Well drained containers can be recycled.

#### 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.