



# Hot Melt Adhesive 753.5

**Thermoplastic synthetic resin adhesive for direct post-forming and for bonding of straight edges.**

## Fields of application

- Direct-post-forming of veneer, multi layer papers and melamine papers
- Bonding of straight edges made of solid wood, paper and melamine edges
- Veneer and plastic edges on CNC machines

## Advantages

- Very high green strength
- Depending on the material used, heat resistance up to 120 °C and cold resistance down to - 30 °C are possible
- Good wetting on paper, veneer and melamine

## Properties of the adhesive

<b>Basis:</b>	polyolofine
<b>Specific weight:</b>	approx. 1.2 g/cm <sup>3</sup>
<b>Colour:</b>	yellowish
<b>Softening point (ring and ball):</b>	approx. 160 ± 10 °C
<b>Viscosité Brookfield HBTD:</b>	
at 180°C	110,000 ± 20,000 mPa.s
at 200°C	65,000 ± 15,000 mPa.s
<b>Melting index acc. to DIN EN ISO 1133 (MFI/170/1,2)</b>	100 g ± 20 g/10 minutes
<b>Identification:</b>	identification not required according to German regulation GefStoffV (see our safety data sheet)

Hot melt adhesives release vapours, even if the prescribed working temperature is observed. When hot melt adhesives are melted and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working temperature has been observed. Moreover if the prescribed working temperature is exceeded over a longer period, there is a danger of decomposition products forming which are harmful. Precautions must be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

## Application machinery

- Edge banding machines of the following manufacturers: HOMAG, IMA, IDM, STEFANI
- Direct- post-forming installations of the following manufacturers: HOMAG, IMA, IDM
- Application equipment: roller, nozzle
- CNC machines

## Application techniques

Application techniques:

Direct post-forming direct: 190-200 °C

Straight edge: 200-210 °C

Line speed: 20-50 m/min

The substrates must be dry, free from dust and acclimatised.

## Application Quantity:

The quantity applied should be adjusted in such a way that the adhesive slightly shows on the edge of the part to be glued. In order to check whether the adhesive film is continuously applied, a strip of transparent rigid PVC can be used.

## Post-Treatment:

The glued material can be further processed immediately after bonding (sawing, routing, planing etc.)

## Cleaning

With spatula when the glue is still hot.

Tools can be cleaned with KLEIBERIT 827.0.

## Packaging

### KLEIBERIT HM 753.5:

Plastic sack, 20.0 kg

### KLEIBERIT Cleaner 827.0:

Metal canister, 4.5 kg

## Storage

KLEIBERIT Hot Melt Adhesive 753.5 can be stored for approx. 24 months. Keep in a cool and dry place.

EX1010; replaces previous data sheets



# KLEIBERIT®

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#### **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.