Reactive Hot Melt PUR 702

Fields of application
For highly durable in bonding of:
- Wood based materials

for interior

PVC and wood based profiles with:
- PVC foils
- CPL, thick decor paper
- Veneer

Yellow chromatised aluminium profiles

For interior finishing of motor vehicles:
- lamination of cloth/carpet or PVC foils to substrates made from wood based materials or plastic

Advantages
- Very high green strength with high tack
- Heat resistance more then 150°C
- Cold resistance up to -40°C

Application techniques
PUR- hot melts react with ambient air humidity. KLEIBERIT PUR-HM 702 is available in tightly closed metal containers suitable for platen melters. The package should only be open immediately before use.
The melting equipment must constructed in such a way that the adhesive is protected from ambient air humidity. It is important that the temperature can be controlled accurately.

Yellow chromatised aluminium profiles must be preheated to approx. 40°C immediately before bonding. The chrome coating must not be older then 4 weeks.

Application temperature:
from 140°C to 160°C.
(veneer and resin paper can have higher application temperatures)

The required coat weight depends on the material:
- PVC-Foil 40- 60 g/m²
- Decor papers
  (incl. CPL-Material and thick papers) 50- 70 g/m²
- Veneers 80-120 g/m²

Properties of the adhesive
Basis: Polyurethane
Specific gravity: approx. 1.04 g/cm³
Viscosity (on the day of production)
-Brookfield HBTD 10 rpm (mPa.s):

Product Nr.	120°C	140°C	160°C
702.5	60.000± 15.000	35.000 ± 10.000	20.000 ± 5.000
702.7	100.000 ± 25.000	60.000 ± 15.000	35.000 ± 10.000
702.9	200.000 ± 40.000	100.000 ± 25.000	60.000 ± 15.000

The speed, depending on the materials and the profile geometries used, is between 10-60 m/min and can be even higher. The final bond strength is reached after approx. 7 days.

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

Cleaning
After finishing work with KLEIBERIT PUR hot melt 702 empty the content from the application equipment and drain off any remaining adhesive. Place the EVA KLEIBERIT PUR HM Cleaner 761.7 immediately afterward into the equipment, melt and purge through, until all traces of the PUR hot melt are gone. Cross linked PUR adhesive can only be removed mechanically.

Application equipment
- Cartridge guns for manual use
- Tank melter with nitrogen blanket
- Drum melting systems for 20 and 200 litre drums

KLEBCHEMIE M. G. Becker GmbH & Co. KG, Max-Becker-Strasse 4, D-76356 Weingarten/Baden
Tel.: +49 (0) 72 44 / 62 - 0, Fax: +49 (0) 72 44 / 700 - 0, email: info@kleiberit.com
www.kleiberit.com

Reactive HOT MELT PUR 702

Packaging

KLEIBERIT PUR-HM 702:

Pouch pack	18 kg net
Metal drum	190 kg net

KLEIBERIT Cleaner 761.7:

Carton with 4 pouches	1.5 kg net
Metal pail	15 kg net

Identification

Identification required according to the German hazardous substances regulations GefStoffV, contains Diphenylmethane-4,4'-diisocyanate (see our health and safety data sheet)

When hot melt adhesives are melted and applied, vapours are set free and an unpleasant odour can occur, even if the recommended working temperature is being observed. If the recommended working temperatures are being exceeded for a longer period of time there is a danger of formation of harmful decomposing products. Precautions to eliminate vapours such as suitable ventilation systems must be taken.

Storage

KLEIBERIT PUR-HM 702 can be stored in factory sealed packages:

Pouch pack (18 kg)	approx 12 months
Drum	approx 12 months

Protect from humidity!

EX1109; replaces previous editions

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.

KLEBCHEMIE M. G. Becker GmbH & Co. KG, Max-Becker-Strasse 4, D-76356 Weingarten/Baden
Tel.: +49 (0) 72 44 / 62 - 0, Fax: +49 (0) 72 44 / 700 - 0, email: info@kleiberit.com
www.kleiberit.com