



# Reactive PUR Hot Melt 706.1

**Reactive hot melt based on polyurethane (PUR) for surface lamination**

## Fields of application

- Surface lamination
- Good adhesion to various materials, such as wood, wood material, metal plate, PMMA, PC, GRP, ABS, aluminium, steel (dependant upon the material used, pre-treatment could be necessary)
- The long open time allows large surfaces areas to be bonded
- One of the materials to be bonded must be permeable

## Advantages

- Very high green strength
- Following cross-linking, a highly warmth-resistant, watertight and extremely cold-resistant bond is attained
- Low processing temperature
- Long open time

## Properties of the adhesive

**Base:** polyurethane

**Specific weight:** approx. 1.1 g/cm<sup>3</sup>

**Viscosity** (on the day of production)

**Brookfield HBTD 10 rpm:**

at 120° C 12,000 ± 3,000 mPa s

at 140° C 6,000 ± 2,000 mPa s

**Identification:** identification required according to the German hazardous substances regulations GefStoffV; contains diphenylmethane-4,4'-diisocyanate, (see our safety data sheet)

## Attention

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, harmful decomposition products can develop. Precautions should be taken to eliminate the vapours, e.g. by using a suitable ventilation system.

## Application techniques

In order to bond large surface areas with **KLEIBERIT 706.1**, a melting plant can be used with a roller-application plant, suitable for PUR hot melt adhesives.

**Reference value for open time for application onto chip boards:** 6-8 minutes for a

**Application quantity:** 100 g/m<sup>2</sup>

**Application temperature:** 120 °C

**Room temperature:** 20 °C

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

## Cleaning

Following completion of the work with **KLEIBERIT PUR Hot Melt 706.1**, either run the application empty or drain off the remaining contents. Immediately afterwards apply melted **KLEIBERIT Cleaning Agent 761.8** and reverse the direction of the rollers until the last traces of PUR hot melt have been removed. Hot melt adhesive which has already cross-linked can only be removed mechanically.

## Application devices

- Tank device with a nitrogen blanket
- Barrel melting plant for 20 and 200 litre containers
- Suitable roller-application plant

## Packaging

**KLEIBERIT PUR Hot Melt 706.1:**

Carton with 4 pouch packs at 1.8 kg each net

Metal pail 18.0 kg net

Metal drum 190.0 kg net

**KLEIBERIT Cleaning Agent 761.8:**

Plastic pail 20.0 kg net

Fibre drum 136.0 kg net

## Storage

**KLEIBERIT PUR Hot Melt 706.1** can be stored in factory sealed containers as follows:

Pouch packs: approx. 12 months

Metal pail: approx. 12 months

Metal drum: approx. 12 months

Protect from humidity!

EX0309



# 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.