



Hot Melt Adhesive 779.7

Universal hot melt adhesive based on synthetic resin for bonding edges. Also suited for the soft-forming process.

Fields of application

Bonding of

- Polyester edges
- Melamine resin edges
- PVC and ABS edges with pre-treated back
- Uncompressed paper edge bandings
- Solid wood and veneer edges

Advantages

- Universally applicable
- Good re-melting properties
- Very fast solidification properties with fast running machines

Properties of the bond

- Heat resistance, depending on the edges approx. 120°C (in a drying channel, the bond resists temperatures of up to +120° C for a short time)
- Cold resistance, depending on the edge down to approx. -30°C
- Good resistance to water, (important when bleaching or staining veneer edges)
- Good ageing resistance
- Good resistance to oxidation

Properties of the adhesive

Base: EVA-Copolymer
Specific weight: approx. 1.32 g/cm³

Melt index according to DIN 53 735 (MFI 150/2,16): 35-15 g/10 min.

Viscosity

Brookfield HBTD, sp. 27/10 tr/mn:

at 180°C	150,000 ± 20,000 mPa s
at 200° C	85,000 ± 10,000 mPa s
at 220° C	55,000 ± 10,000 mPa s

Softening point (ring and ball) according to DIN 1995: 110 ± 5°C

Melting time of approx.

5 kg of adhesive: approx. 45 minutes, after approx. 30 min. the roller should be turned on. For longer stoppage of the machine, the temperature should be reduced to approx. 160°C

Process temperature: 200-210°C
Lower temperatures may cause faulty gluing, higher temperatures - maintained for a long time - may damage the adhesive and lead to decomposition.

Delivery form: granules

Colours available: white-10, ivory-20, black-100

Identification: not required according to German regulation GefStoffV (see our 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 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 machinery

- Automatic edge banding machines with roller application
- Automatic edge banding machines with spray nozzle

Application techniques

The substrates for edge banding have to be processed at exactly right angles and should be free from dust. The boards as well as the edges have to be acclimatised to room temperature.

The most favourable moisture content of the wood is 8-10 %. The room temperature may not be lower than 18°C. Draughts have to be avoided.

Temperature Control:

Regularly check the temperature directly at the application system by means of a laboratory thermometer, bimetal thermometer or by a thermometer fitted with electric contacts. Readjust it, if necessary. The thermostats installed in the machine may give incorrect readings after extended use.



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Rate of Feed:

20-80 m/min.; a very slow line speed may cause faulty gluing.

Application Quantity:

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

Treatment after Gluing:

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

Due to the fact that edge banding material are subject to change, your own trials are absolutely necessary.

Cleaning

Tools can be cleaned with KLEIBERIT Cleaner 827.0.

Packaging**KLEIBERIT Hot Melt Adhesive 779.7:**

sack, 25 kg net

KLEIBERIT Cleaner 827.0:

tin can, 4.5 kg net

Additional packaging available upon request.

Storage

KLEIBERIT Hot Melt Adhesive 779.7 can be stored for approx. 2 years. Keep in a cool and dry place.

EX0210; replaces previous versions

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.