

KLEIBERIT 705.6

Reactive hot melt adhesive

Fields of application

- 2 layer parquet manufacturing in continuous production
- good adhesion to different materials such as polystyrene, wood, wood based materials, PVC, aluminium, sheet metal (depending on the material a pre-treatment is necessary).
- for highly stressed assembly bonding

Advantages

- after cross-linking highly stressed bondings are achieved; they are very resistant to heat, water and cold
- very good ageing resistance
- no stringing

Properties of the adhesive

Base:	polyurethane
Density:	approx. 1.1 g/m ³
Viscosity (on the day of production) (Brookfield HBTD 10 rpm):	
at 120° C	33,000 ± 4,000 mPa·s
at 140° C	16,000 ± 3,000 mPa·s
Identification:	identification required according to the German hazardous substances regulations GefStoffV; contains diphenylmethane-4,4'-diisocyanate

Attention

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

The adhesive is applied in bead form to the reverse side of the surface layer, or to the upper surface of the supporting layer. This is performed by passing several surface layers or supporting layers through an application plant, which is fitted with a battery of nozzles arranged to evenly apply the adhesive.

A lifting device fitted with suction pads lifts a layer sheet, swings it through a 90 ° angle and places it onto the corresponding sheet, which has already been coated with adhesive. The two layers are bonded together and transported further to a pressing plant, which operates as soon as it is loaded. This cycle requires only a few seconds. In a rotational plant, several presses are arranged together, and according to the order on which pressing is performed, the press time per item requires 15-30 seconds. Once the pressing cycle is achieved, the plant releases the finished parquet., which is removed on a conveyor belt to a stacking plant where it is automatically stacked.

The cross-linking reaction of the adhesive takes place within 24 and 72 hours, depending on the room conditions and the humidity available in the wood.

Processing of the bonded parts is possible after cross-linking.

Cleaning

Following completion of the work with KLEIBERIT 705.6, the application equipment must either be further run until empty, or the remaining adhesive contents must be drained off. Immediately afterwards, apply EVA hot melt EVA hot melt - Cleaning Agent KLEIBERIT 761.7. Melt the cleaning agent and apply to the affected areas until all traces of KLEIBERIT 705.6 have been removed. Any hot melt adhesive, which has already cross-linked can be removed mechanically.

Application nozzles or other small parts which have deposits of dried KLEIBERIT 705.6, can be cleaned by immersing them first in hot Cleaner KLEIBERIT 826.0 and then removing all remaining traces of PUR (see technical data sheet 826.0)

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Application devices

- Cartridge hand pistol for manual application
- Melting tanks with nitrogen cover
- Bulk melters for 20 and 200 litre drums
- Sealed roller systems, nozzle applicators and slot die extruders

Packaging

KLEIBERIT 705.6:

Carton with 12 cartridges, 0,3 kg net each

Carton with 4 pouch packs, 2,0 kg each

Pouch pack, 18 kg net

Cleaning Agent KLEIBERIT 761.7:

Carton with 12 cartridges, 0,25 kg net each

Carton with 4 bags, 1,5 kg each

Metal pail, 15 kg net

Cleaner KLEIBERIT 826.0:

Metal canister, 4.5 kg

Storage

KLEIBERIT 705.6 can be stored in factory-sealed containers as follows:

Cartridges: approx. 12 months

Pouch packs (2 kg) for approx. 12 months

Pouch packs (18 kg) for approx. 12 months

Protect from humidity!

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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.