

KLEIBERIT 782 SUPRAMELT



THE SMOOTH THING - A HOTMELT CARTRIDGE WITH EASY SLIDE COATING

FIELD OF APPLICATION

Bonding of

- Epoxy resin edges
- Pre-primed ABS edges
- Solid wood edges
- Polyester edges
- Pre-primed PVC-edges
- Veneer edges

APPLICATION

- Both substrates have to be cut to an exact right angle and must be free from dust.
- Bring the substrate and the edging material up to room temperature
- The ideal moisture content of the wood is 8-10%, room temperature of min. 18 °C, avoid drafts
- Pre heat time 2-5 minutes, application temperature 200-220 °C
- Correct temperature settings are especially important when bonding solid wood edges
- When bonding long and/or ridged pieces the application temperature should be in the higher temperature areas.
- Lower temperatures reduce the „wetting out“ of the edges
- Coat weight and press pressure should be adjusted so that the applied beads are pressed flat and the adhesives quills out on the edges slightly. To determine the correct coat weight the use of a transparent edge is advised.

NOTE

- For solid wood edging the use of linear grain wood is preferable as this is less prone to bend.
- To achieve optimum bond strength the wood grain of the edges should be vertical on the bond surface.
- Precisely align the edging material
- The chipboard should have a surface which does not have rough cutting marks.
- The easy slide coating does not need to be removed prior to processing.

TECHNICAL PROPERTIES

- Base: Ethylene-Vinylacetate-Copolymer
- Specific gravity: approx. 1.3 g/cm³
- Softening point: (Ring and Ball) DIN 1995
120 °C ± 10 °C
- Melting index: DIN 53 735 (MFI 150/2.16)
60 c 15 g/10 min.
- Pre heat time: 2 - 5 minutes
- Speed: 8 - 20 m/min., depending on machine
- Heat resistance: to +80 °C depending on edge
- Cold resistance: to -20 °C depending on edge
- Colours: white (10), ivory (20), mahogany (70), black (99)
- Packaging: cartridge Ø: 63 ± 0,5 mm
length: 80 ± 2,0 mm

CLEANING

When cleaning the application equipment observe the manufacturers instructions.

DISPOSAL

Hardened adhesive domestic waste disposal. Our packaging is made from recyclable materials.

PACKING SIZES

Carton with 45 cartridges, approx. 15 kg net.

STORAGE

KLEIBERIT 782 Supramelt can be stored for approx. 2 years. Store cool, dry and in original sealed packaging.

IDENTIFICATION

Identification is not required to EU regulation. When hotmelt adhesive are melted and applied, vapours are set free and an unpleasant odour can occur, even is the recommended working temperature has been observed. If the recommended working temperature is exceeded over a long period of time, harmful decomposition products can develop. Precautions should be taken i.e. using suitable ventilation, to eliminate vapours.