

Water Resistant Bonding

with **KLEIBERIT** Adhesives

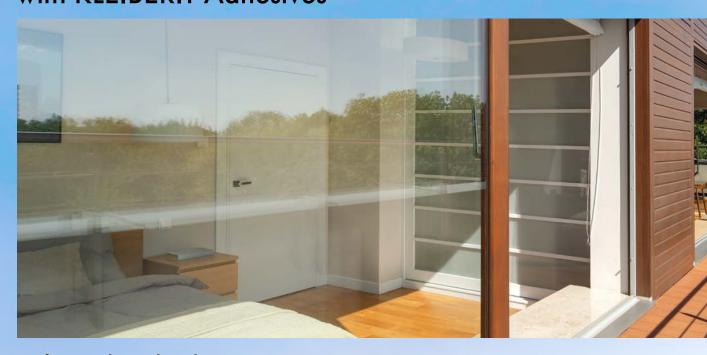


Surface and joint bonding | Profile wrapping | Edge banding



Competence **PUR**

Water Resistant Bonding with **KLEIBERIT** Adhesives



Surface and joint bonding

KLEIBERIT 303.0

gluing qualities: D3 according to DIN EN 204 D4 according to DIN EN 204 with hardener KLEIBERIT 303.5 WATT 91 (DIN EN 14257) > 7 N/mm²

application methods: brush, glue roller, trowel, roller, nozzle system

Base: Density: Colour: Viscosity at 20°C (Brookfield Sp. 6/20 Upm): Pot life:

PVAC dispersion approx. 1.1 g/cm³ white

12,000 ± 2,000 mPa·s with 5% KLEIBERIT 303.5 approx. 24 hours 6 - 10 minutes

Open time at 20°C:

KLEIBERIT 304.4

gluing qualities: D4 according to DIN EN 204 with hardener KLEIBERIT 808.0 WATT 91 (DIN EN 14257) > 7 N/mm²

application methods: brush, glue roller, trowel, roller, nozzle system

Base: Density: Colour: Viscosity at 20°C (Brookfield Sp. 6/20 Upm): 7,000 ± 1,500 mPa·s Open time at 20°C:

20 - 25 minutes

polymer dispersion

approx. 1.3 g/cm³

brown

KLEIBERIT 501.0

gluing qualities: D4 according to DIN EN 204 WATT 91 (DIN EN 14257) > 7 N/mm²

application methods: brush, glue roller, trowel, roller, nozzle system

Base: Density: Colour: Viscosity at 20°C (Brookfield Sp. 6/20 Upm): 7,000 ± 1,500 mPa·s Open time at 20°C:

polyurethane approx. 1.3 g/cm³ brown

20 - 25 minutes

KLEIBERIT 510.3.30

gluing qualities: D4 according to DIN EN 204 WATT 91 (DIN EN 14257) > 7 N/mm²

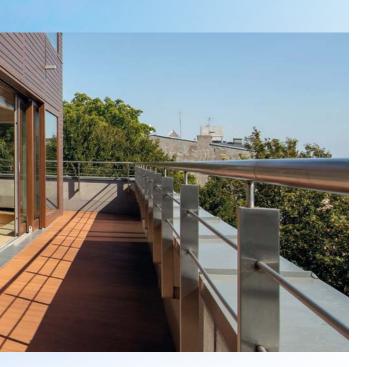
application methods: brush, glue roller, trowel, roller, nozzle system

Base: Density: Colour: Viscosity at 20°C Open time at 20°C: polyurethane approx. 1.13 g/cm³ vanilla

(Brookfiled Sp. 4/20 Upm): approx.18,500 mPa·s 20 - 25 minutes

Competence





KLEIBERIT 706.0.09

gluing qualities: highly heat resistant, watertight, extremely cold resistant and durable bond is attained

application methods: roller, slot nozzle

Base: Density: Colour: Auftragstemperatur: Viscosity at 20°C

polyurethane approx. 1.10 g/cm³ milky white 120°C

(Brookfield HBTD 10 Upm): 120 °C: 12,000 mPa·s ± 3,000 mPa·s 140 °C: 6,000 mPa·s ± 2,000 mPa·s 1-3 minutes

accoya® and tricoya® are registered trademarks of Accsys Technologies PLC. Both are highly resistant, chemically modified materials for durable, dimensionally stable end products, suitable for outdoor use. accoya® stands for refined solid wood, mostly used as profile materials. tricoya® stands for refined wood fiber materials, mostly used in form of board materials. Longevity is achieved by modifying the naturally grown wood, usually a wood species with little resistance, through acetylation so that the molecular structure of the previously hygroscopic material is changed in such a way that moisture absorption and moisture binding is greatly reduced. As a rule, the acetylation of wood is achieved by impregnation with an acetic anhydride solution. This causes the hygroscopic hydroxyl groups of the wood cell walls to be esterified. The original hygroscopicity or moisture absorption and moisture binding is thus considerably reduced. Infestation by microorganisms can also be excluded.

The KLEIBERIT adhesives listed in this product brochure have been extensively tested for their suitability for both materials. They have in-house test certificates as well as performance certificates from independent, renowned testing institutes. Besides chemically reactive polyurethane adhesives, a selected PVAC dispersion and an EPI system are available. The processing of both adhesives, which are liquid in the processing state, is similar to the known solid wood gluing processes. Due to the modified water absorption capacity of accoya® and tricoya[®], slightly longer pressing times may be necessary. If, on the other hand, a moisture-reactive PUR adhesive is chosen, whether in the form of a liquid prepolymer or as a hotmelt, the addition of moisture may be required for the usual quick setting reaction due to the low to non-existent moisture on the surface of the acetylated material. The optimal processing conditions when using accoya® and tricoya® have to be determined in the form of test runs, as with all other materials that undergo a bonding process. The advantages offered by these wood-based materials quickly outweigh the test effort.

KLEIBERIT 706.1.50 ME

gluing qualities: highly heat resistant, watertight, extremely cold resistant and durable bond is attained; IMO FTP Code part 5

application methods: roller, slot nozzle

Open time:

Base: Density: Colour: Auftragstemperatur: Viscosity at 20°C/40% RH (Brookfield HBTD 10 Upm): 120 °C: 18,000 mPa·s ± 4,000 mPa·s

polyurethane approx. 1.10 g/cm³ yellowish 120-130 °C

140 °C: 9,000 mPa·s ± 2,000 mPa·s < 8 minutes

Open time:

Edge banding

KLEIBERIT 707.9.40

gluing qualities: highly heat and moisture resistant when using suitable plastic edges (e.g. ABS, PP, PVC, etc.)

application methods: roller, slot nozzle

Base:polyurethaneDensity:approx. 1.10 g/cm³Colour:ivoryApplication temperature:120°C -140°CViscosity140 °C: approx. 35,000 mPas

KLEIBERIT 707.9.58

gluing qualities: highly heat and moisture resistant when using suitable plastic edges (e.g. ABS, PMMA, PP, PVC, etc.)

application methods: roller, slot nozzle

| Base: | polyurethane |
|---------------------------|-----------------------------|
| Density: | approx. 1.10 g/cm³ |
| Colour: | ivory |
| Application temperature: | 140°C -160°C |
| Viscosity | |
| (Brookfield HBTD 10 Upm): | 140 °C: approx. 80,000 mPas |
| | 160 °C. approx. 45,000 mPas |

Profile wrapping

KLEIBERIT 704.6

gluing qualities:

weather-resistant, if plastic films suitable for outdoor use are used

application methods: slot nozzle

| Base: | polyurethane |
|---------------------------|--------------------------------|
| Density: | approx. 1.10 g/cm ³ |
| Colour: | transparent |
| Application temperature: | 120°C -140°C |
| Viscosity | |
| (Brookfield HBTD 10 Upm): | 120 °C: approx. 60,000 mPas |
| | 140 °C: approx. 35,000 mPas |

Would you like expert advice or do you need more detailed information? Contact us directly by email, phone or visit our website.

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