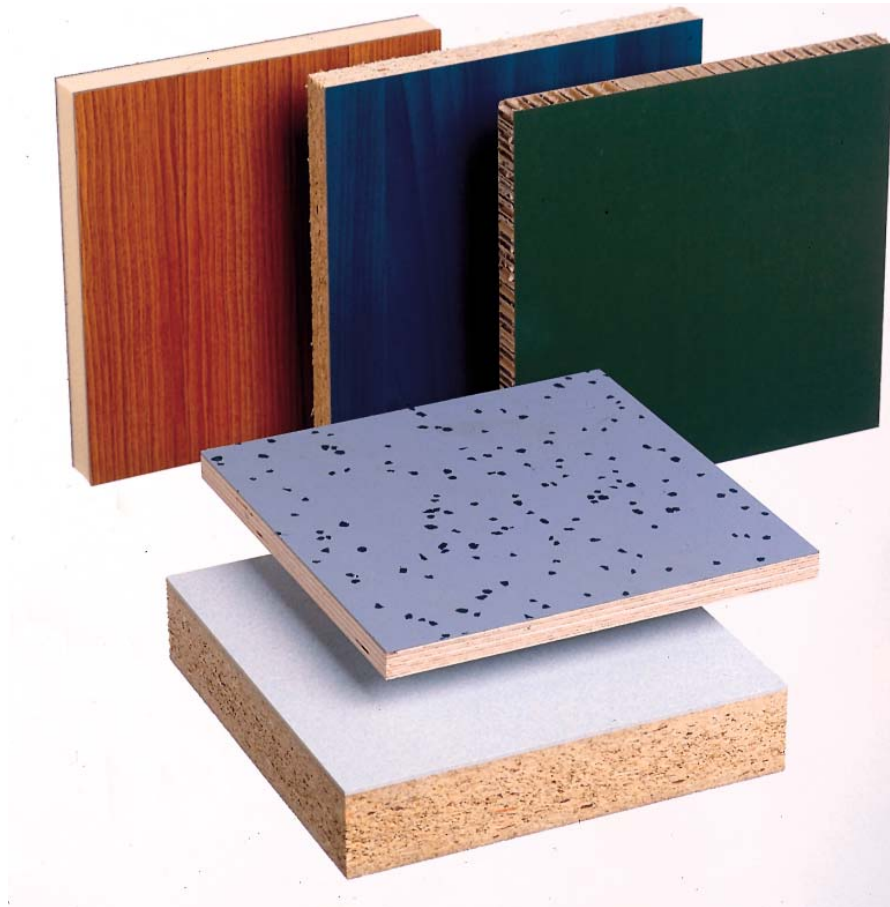


Surface bonding and lamination



KLEIBERIT polyurethane adhesives

KLEIBERIT 1C-PUR 501

Liquid adhesive on polyurethane basis for strong bonds of wood, metal and plastics

- water resistance D4 according to DIN/EN 204
- temperature resistance according to Watt 91 > 9N/mm²
- joint filling

KLEIBERIT 1C-PUR 502.8

1C PUR liquid adhesive with short pressing times for bonding of composite elements such as wood, wooden based materials, metal, plastics and many types of foams

- short pressing times

KLEIBERIT PUR 700/706

Reactive hot melt adhesive on polyurethane basis with

- long open time up to 10 min.
- very good application properties through slot nozzles, rollers or spraying process
- excellent temperature resistance from -40°C to 150°C (depending on substrates)

ADHESIVES

Surface bondings are used in a multitude of different industries: the building, automotive and furniture industry are only some examples. Depending on the range of requirements, the substrates to be bonded and the technical process, a wide variety of different adhesive systems are available

One-component polyurethane adhesives (PUR) for joint-filling bonding of wood, metal and plastic and even substrates with coarse surfaces - sandwich production, insulating boards etc.

Reactive Polyurethane-HM (PUR) for surface lamination and bonding of various substrates such as wood and wood based materials, plastic, metals or the substrates with each other.

Urea and melamine resin adhesives for surface bondings of veneers, production of contoured parts made from multi layer veneer and parquet and door production etc.

Dispersion on ethylene-vinyl acetate basis (EVA) for lamination of papers or PVC foils (loudspeakers and furniture).

Dispersion on PVAC basis for bonding of veneer to a variety of wooden substrates

KLEBCHEMIE

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KLEIBERIT urea and melamine resing adhesives

KLEIBERIT hot press glue 871

urea resin adhesive with built-in hardener

- easy to mix
- low formaldehyde content E1
- short pressing times

KLEIBERIT hot press glue 881.1

urea resin adhesive with separate hardener. Suitable for the production of 3-layer parquet

- quality A 100
- excellent bond quality

KLEIBERIT Dispersions on PVAC and EVA basis

KLEBIT 303

Universal dispersion adhesive on PVAC basis for surface bonding of veneers and HPL materials

- high bond quality - D3 according to DIN/EN 204
- very good ratio open time/pressing time
- outstanding processing performance using application machines

KLEIBERIT 332

Dispersion on PVAC basis

- very long open time up to 20-25 minutes (20°C, approx. 120 g/m²)

KLEIBERIT EVA 464

Dispersion on ethylene-vinyl acetate basis for surface lamination of PVC and paper foils

- very good processing performance
- suitable for cold and thermolamination
- very smooth surface - no telegraphing through papers

Application:

One-component polyurethane liquid adhesives can be applied both manually (spatula, glue roller) and mechanically. The mechanical application technology has improved a lot over the last 2-3 years, the main techniques are spraying and application of many beads next to each other.

Reactive polyurethane hot melt adhesives for surface bonding have a low to medium viscosity when melted.

The application temperature should be between 100° C and 130° C. The adhesive is melted in a pre-melter and then pumped to the application device. The adhesive can be applied with application rollers, slot nozzles, doctor blades and spraying devices.

Urea and melamine resin adhesives are sold as powder and mixed with water, hardeners and sometimes fillers - according to the recommend mixing ratio - before use.

The mixed adhesive is normally applied with glue rollers. Another possibility is the application of beads using a so called "curtain coater".

Dispersions adhesives are usually applied with two or four glue rollers directly on the substrate. The dispersions stand for excellent properties in proportioning and also good flowing properties using the rollers.

The dispersions can, of course, also be applied manually using spatulas, glue rollers or brushes.

KLEIBERIT adhesives for surface bonding /lamination

KLEIBERIT Product	Sandwich-elements	Parquet		Lamination of large surfaces									Multi-layer veneer production	Properties
		2-layer	3-layer	on wood			on PVC			on aluminium				
				PVC	paper	veneer	PVC	paper	veneer	PVC	paper	veneer		
1C-PUR 501	■	▼	▼			▼							■	D4 according to DIN/EN 204; joint-filling, high temperature resistance according to WATT 91 > 9,5 N/mm ²
1C-PUR 502.8	■	▼	▼			▼							■	short pressing times suitable for combination bondings
PUR HM 700	■	▼	▼	■	■	▼	▼	▼	●	▼	▼	●	●	long open time > 4 minutes high temperature resistance -30° C to 150° C
PUR HM 704/706	■	■	▼	■	■	▼	■	■	■	■	■	■	▼	universal use; high green strength good adhesion on wood, plastics, metal
UREA 871			▼		●	■							■	E1 quality short pressing times
Melamine 881			■		●	■							■	special-purpose adhesive for production of 3-layer parquets fulfills all requirements
PVAC-dispersion 303			▼		▼	■							■	universal use D3 quality according to DIN/EN 204
PVAC-dispersion 332					▼	■							■	long open time 20-25 minutes (at 20° C)
EVA-dispersion 464				■	■	●								especially suitable for lamination of foils and paper for cold and thermo-lamination

■ very well suited ▼ well suited ● possible