Hot Melt Adhesive 773.3

Thermoplastic hot melt adhesive for edge banding on edge banding machines.

Fields of application

Bonding of

- Polyester edges
- CPL and melamine resin edges, also so called thin edges
- PVC and ABS edges (primed)
- Uncompressed resin-impregnated paper edges

Advantages

- Good melting properties
- Very clean processing
- No stringing
- High green strength

Properties of the adhesive

Base:	EVA-Copolymers
Specific weight:	approx. 1.03 g/cm³
Viscosity (Brookfield HBTD):	
at 180° C:	80,000 ± 15,000 mPa s
at 200° C:	50,000 ± 10,000 mPa s
Melting index according to DIN 53 735 (MFI 150/2,16):	50 ± 10 g / 10 minutes
Softening point (ring and ball):	105 ± 5° C
Process temperature:	
- edge banders:	180 - 200°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:	beige-transparent
Identification:	not required according to the German hazardous substances regulations 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 devices

- Automatic edge banders with roller applicator

Application techniques

The substrates for edge bonding have to be processed at exactly right angles and must 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 should not be lower than 18°C. Draughts should 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 with electrical contacts. Re-adjust if necessary. The thermometers installed in the machine may give incorrect reading after extended use.

Speed
Machine speed is 10-30 m/min., depending on width of edges; insufficient speed might result in faulty bondings.

Application quantity
Please adjust application quantities so that the adhesive can be seen at the edges of the bonding. You can check an even glue film with transparent PVC strips.

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Post-processing
The bonded material can be processed immediately after bonding (sawing, routing, planing, etc.)

Cleaning
Tools can be cleaned with KLEIBERIT Cleaner 827.0.

Packaging
KLEIBERIT Hot Melt Adhesive 773.3:
Sack, 3 kg net
PE sack, 20 kg net
KLEIBERIT Cleaner 827.0:
metal canister, 4.5 kg net
carton with 12 bottles at 0.7 kg net each

Additional packaging available upon request.

Storage
KLEIBERIT Hot Melt Adhesive 773.3 can be stored for approximately 2 years. Keep in a cool and dry place.

EX0610

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.

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