



## Hot Melt Adhesive 779.6

**Thermoplastic synthetic resin adhesive for bonding and pre-coating of edges.**

### Fields of application

Bonding of

- Polyester edges
- Melamine resin edges
- PVC, PP and ABS edges with pre-treated backs
- Uncompressed resin-impregnated paper edge bandings
- Solid wood and veneer edges

### Advantages

- Universally applicable
- Good re-melting properties
- Suitable for pre-coating of edges

### Properties of the bond

- Heat resistance, depending on the edge: approx. 80° C
- (In a drying channel, the bond resists temperatures of up to 120° C for a short time)
- Cold resistance, depending on the edge: approx. -20° C
- Good water resistance (important when staining and bleaching veneer edges)
- Good ageing resistance
- Good oxidation resistance

### Properties of the adhesive

<b>Base:</b>	EVA-Copolymers
<b>Specific weight:</b>	approx. 1.38 g/cm <sup>3</sup>
<b>Viscosity (Brookfield HBTD) sp. 27/10 tr/mn:</b>	
at 180°C	130.000 ± 22.000 mPas
at 200°C	80.000 ± 15.000 mPas
<b>Melt index according to DIN 53 735 (MFI 150/2.16):</b>	50 ± 15 g/ 10 min.
<b>Softening point (ring and ball):</b>	105 ± 5° C
	For long stoppage of the machine, the temperature should be reduced to approx. 160°C.

**Process temperature:**

200-210°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

**Colour numbers:**

white - 10, ivory-20,

**Identification:**

identification not required according to the German hazardous substances regulation 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 machinery

- Automatic edge banding machines with roller applicator
- Automatic edge banding machines with spray nozzle applicators
- Machines for pre-coating edges

### Application techniques

The substrates for edge bonding have to be processed at exactly 90 °s 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 must not be lower than 18 °C. Draughts have to be avoided!

#### Temperature Control:

Regularly check the temperature directly on the application system by means of a laboratory thermometer, bi-metal thermometer or by a thermometer with electrical contacts. Readjust if necessary. The thermometers installed in the machine may give incorrect readings after extended use.

**Rate of Feed:**

20-50 m/min., depending on the width of the edge, a very slow line speed may cause faulty gluing.

**Application Quantity:**

The quantity applied should be adjusted in such a manner as to slightly show on the edge of the part to be glued. In order to check whether the adhesive film is evenly applied, a strip of rigid transparent PVC can be used.

**Consumption for pre-coating of edges:**

80-100 g/m<sup>2</sup>

**Post-Treatment:**

The glued material can be further processed immediately after bonding, (sawing, routing, planing, etc).

**Cleaning**

Tools can be cleaned with KLEIBERIT Cleaner 827.0.

**Packaging****KLEIBERIT Hot Melt Adhesive 779.6**

bag, 25 kg net

**KLEIBERIT Cleaner 827.0**

metal canister, 4,5 kg net

**Storage**

KLEIBERIT Hot Melt Adhesive 779.6 can be stored for approx. 2 years. Keep in a cool and dry place.

EX0801 – replaces all previous data sheets

**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.