Supramelt GL 782.0

Fields of application

Bonding of

- Veneer and solid wood edges
- Decorative laminate edges
- Polyester edges
- Synthetic resin edges
- PVC and ABS edges

Properties of the adhesive

Base:	EVA-Copolymer
Specific gravity:	approx. 1.3 g/cm³
Melting point (ring and ball) DIN 1995:	120° ± 10 °C
Melting index according to DIN 53 735 (MFI 150/2.16):	60 ± 15 g/10 minutes
Time required for heating up:	2 – 5 minutes
Viscosity Brookfield HBTD, Sp. 27/10 rpm:	
at 180 C:	110.000 ± 20.000 mPa.s
at 200 °C :	65.000 ± 10.000 mPa.s
Working temperature:	200 - 220 °C (Thermostate indication)
Line speed:	8 to over 20 m/minutes, depending on machine
Heat resistance:	up to +80 °C depending on the edge
Cold resistance:	as low as -20 °C depending on the edge
Delivery form:	Cartridges Diameter 63 ± 0,5 mm, Length 80 ± 2mm
Colour numbers:	white (10), ivory (20), mahogany (70)
Identification:	identification not required according to the German hazardous substances regulations GefStoff (see our safety data sheet)

Attention

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 techniques

Substrates:
The substrates for edge banding have to be processed at exactly right-angles and should be free from dust. Boards and edges have to be conditioned 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.

Time required for heating up:
2 – 5 minutes

Working temperature:
200 - 220 °C (thermostate indication)
Working temperature may be increased to 230 °C for a short time when using woods difficult to bond. The temperature control at the application nozzle is especially important when decorative laminate edges and solid wood edges are to be bonded. With long and thick parts you should work in the upper temperature range. Low temperatures reduce the wetting of the edge.

Line speed:
From 8 to over 20 m/minute, depending on machine

Application quantity:
The quantity to be applied and the pressure should be adjusted in such a manner as to show some pearling on the end of the bond. In order to check whether the adhesive film has been applied continuously, a strip of rigid and transparent PVC can be used.

Some hints for the bonding of solid wood:

- If you are using solid wood edges you should give preference to wood with straight grain which does not tend to deflecting ("plating").
- Wood edges with annual rings which are standing vertically to the joint give optimum strength.
- Work with precision when preparing the substrate material.
- Avoid a cut surface which is too coarse.
- The pressing devices distance should be set slightly less than the edges' thickness.

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Supramelt GL 782.0

Trials by the user are absolutely necessary as edge materials are in a continual process of change.

Cleaning
Please see instructions of the manufacturer when cleaning the application unit.

Packaging
KLEIBERIT 782.0:
Cartons of 45 cartridges, approx. 15 kg net

Storage
KLEIBERIT Supramelt GL 782.0 can be stored for approx. 1 year. Keep in cool and dry place.

EX1205

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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KLEIBERIT®

FIELD OF APPLICATION

Bonding of

- HPL edges
- Epoxy resin edges
- ABS edges
- Solid wood edges
- Polyester edges
- 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 (Thermostat)
- Correct temperature settings are especially important when bonding HPL and 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.
- Prepare the base substrate exactly
- The chipboard should have a surface which does not have rough cutting marks.
- Adjust the press tolerance to be a little bit lower then the width of the edge.

TECHNICAL PROPERTIES

- **Basis** Ethylene-Vinylacetate-Copolymer
- **Specific gravity** approx. 1,3 g/cm3
- **Softening point (Ring and Ball) DIN 1995** 110°C ± 5°C
- **Melting index DIN 53 735 (MFI 150/2.16)** 60 ± 15 g/10 min.
- **Pre heat time** 2 - 5 minutes
- **Speed** 8 - 20 m/min., depending on machine
- **Heat resistance** up to +80°C depending on edge
- **Cold resistance** up to -20°C depending on edge
- **Colours** white (10)
  ivory (20)
  mahogany (70)
  black (99)
  transparent (782.5)
- **Product formant** 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 SUPRAMELT 782 GL/782.5
Approx. 2 years
Store cool, dry and in original sealed packaging.

IDENTIFICATION

identification is not required to the German hazardous substances regulation GefStoffV
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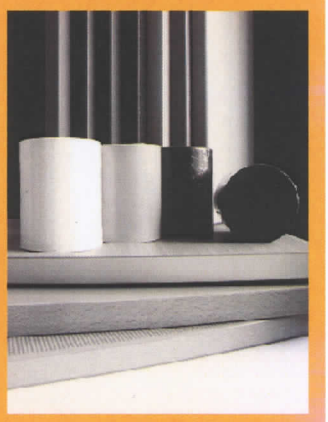
Please observe our data sheet 782 GL

TECHNICAL DATA

SUPRAMELT 782 GL



SERVICE

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